

CATALOG
GENERAL PROGRAM
GP 06



WITH THE **LEUCO ONLINE-CATALOG**

**FINDING TOOLS!
QUICKLY & EASILY!**

The LEUCO online catalog is always up to date and will support you around the clock in selecting your tools. The filter functions help you find the right tool:

WWW.LEUCO.COM/PRODUCTS





**Our specialized consultants help you choose
the right tool and give you the required
information on our sharpening service**









**+49 (0) 7451 / 93 0
info@leuco.com**

BRANDS YOU CAN RELY ON




Sizing saw blades

	LEUCO precision saw blades
	Saw blades with optimized price-performance ratio
DUPLOVIT®	The original hollow-ground tooth saw blades





Panel sizing circular saw blades

   	Tungsten carbide-tipped panel sizing circular saw blades for the universal use in wood-based materials, for single panel or stack cuts and high volumes
   	Tungsten carbide-tipped panel sizing circular saw blades for finish-cut quality in wood-based materials, even with sensitive top layers, for single panel or stack cuts. Noise-reduced design nn-System




Hoggers

	DP compact hoggers with stepped cut
	DP compact hoggers for universal use
	DP compact hoggers with crowned tooth geometry; noise-reduced airFace design



Cutterheads

	Universal cutterhead system with standard body
LEUCO EcoPro	Flexible cutterhead system with direct knife clamping
LEUCO SetProfiler	Back-serrated knife system with large resharpenable area
	High-performance cutterhead system for customized profiles, play-free and quick knife change
	High-performance diamond profile cutters for highest feed rates
	Joining cutterhead system with manually changeable DP-tipped segments, very high concentric accuracy and consistent tool diameter, noise-reduced airFace design







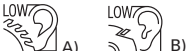
Clamping elements

	Precision quick change system with bayonet mount for through-feed processing
LEUCO Hydro-S-System	Precision quick change system with bayonet mount on hydro bushing for through feed processing
LEUCO ZEROPLAN	Quick change system with adjustable runout for through-feed processing
	Quick change system with adjustable runout for through-feed processing
	High-performance precision clamping element with polygonal clamping technology for shank-type tools






Drill bits

	Drill bit program range with fine-grain tungsten carbide and optimized grinding for long edge lives
	Drill bit program with ultra fine-grain tungsten carbide and optimized polished section for very long edge lives and best cutting quality in laminated panel materials
LEUCO EcoLine	Universal, economic dowel and through-hole bit program

System tools

	System tools with optimized chip removal for aggregates with inward-directed chip jet
CM	All LEUCO tools with optimized chip removal design are characterized by this sign
	Bores in the tool body optimize the aerodynamics and thus the noise level
	The aerodynamic surface of the body ensures a reduced noise level during operation
	Shank-type tools and bore-type cutters with a shear angle $\geq 55^\circ$ for the best cutting quality currently available on the market; long edge lives and additional applications that were previously considered technically impossible
	Saw blades and grooving cutters with a tooth group combination of 5 teeth: noise-reduced, low cutting pressure, excellent cutting quality
	DP format and panel sizing saw blades with very small chip gullets work quietly and comfortably. Noise level below the level required for hearing protection; best cutting quality, long edge life in many wood-based panels
	All low noise level circular saw blades (A) and all low noise level tools with bore (B) are provided with this label

Cutting materials and coatings

	LEUCO HW cutting materials
HL Board®	LEUCO HW cutting materials for panel board processing
HL Solid®	LEUCO HW cutting materials for solid wood processing
	Coatings of the cutting edge are suited for each application
	Diamond high-performance cutting materials optimized for each application
LEUCO DIA	High-performance diamond tools with full height diamond tips (approx. 6 mm)
	Diamond-tipped tools with a resharpening area of 0.5 mm – 1.5 mm depending on the tool type and the tool diameter
	Diamond-tipped tools with a resharpening area of 1.5 mm or 2.0 mm depending on the tool type

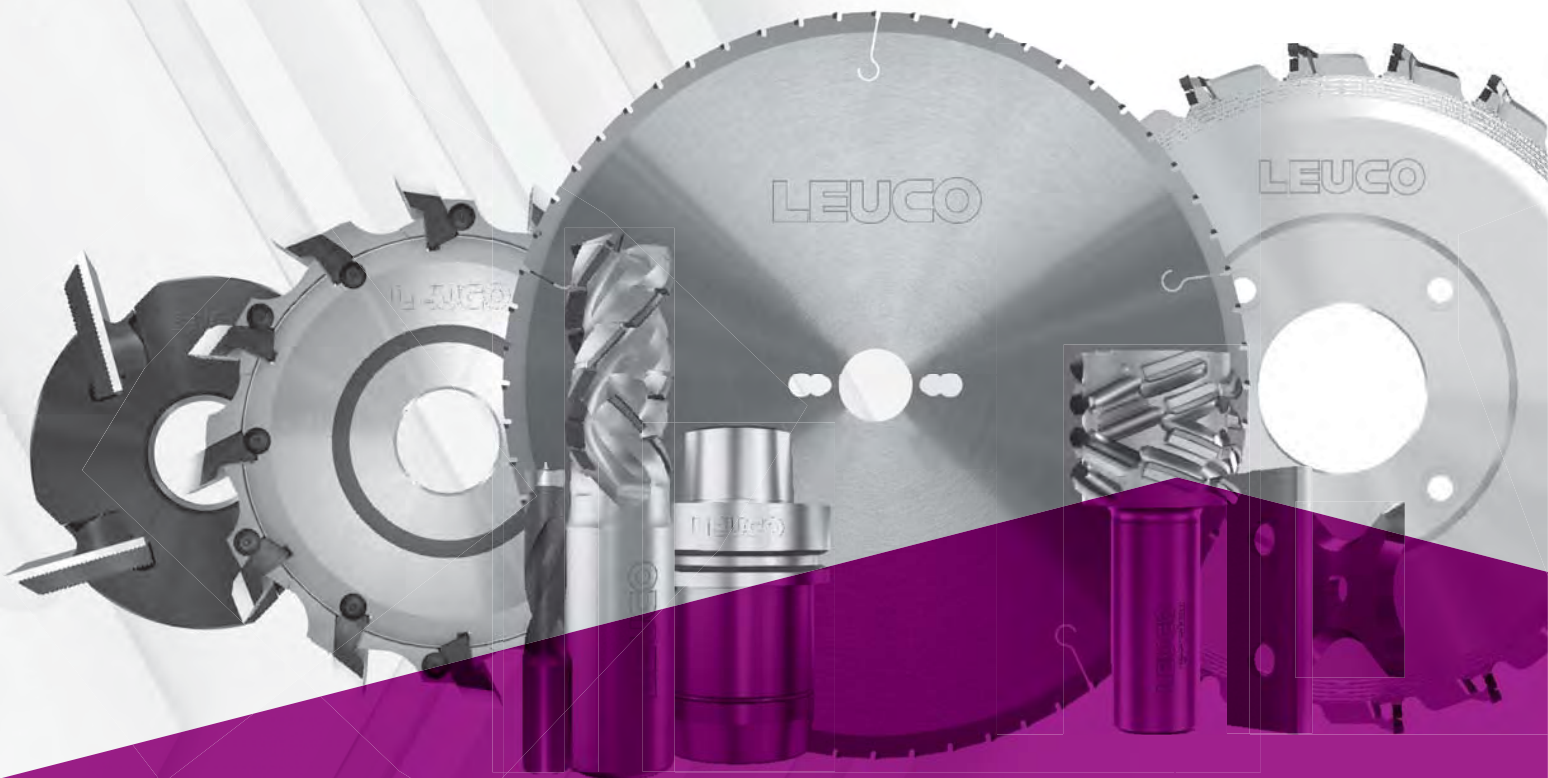
THE LEUCO PERFORMANCE PROMISE

MAGENTIFY YOUR POSSIBILITIES

INTELLIGENT SERVICES.

CUSTOMIZED SOLUTIONS.

INNOVATIVE TOOL TECHNOLOGIES.



About us
New tools in the GP 06

Circular saw blades



Hoggers



Milling tools with bore



Shank-type milling tools



Drill bits



Turnover knives
Exchangeable knives
Knives



Clamping systems



Spare Parts
General technical information



LEUCO addresses
Inquiry for special products
LEUCO services
Sharpening service



MAGENTIFY MISSION

Our goal is to improve the opportunities for our customers and partners through forward-looking innovations and to open up the potential of wood and related materials as a recyclable raw material to benefit people.

PIONEERING SPIRIT AND INNOVATION

Leading know-how and a distinct culture of innovation allow us to develop increasingly precise and powerful tools for the processing of wood and related materials. Around the world, we enable our partners to identify new opportunities in the wood processing industry. We can therefore guarantee a meaningful future for one of the oldest and most versatile raw materials. In doing so, we consider ourselves allies when it comes to the high demands of our customers.

Our tools and services make production processes more efficient and improve the quality of the results. New kinds of material developments, innovative applications, more efficient processes – success is determined where the tool meets material in order to shape it.

We therefore focus our research and development work precisely on these objectives, bundling our experience, industry expertise and pioneering spirit to do so. Our ultimate goal is to offer integrated solutions and intelligent services in the wood processing industry – along its entire processing chain.

PARTNERSHIP AND DIALOG

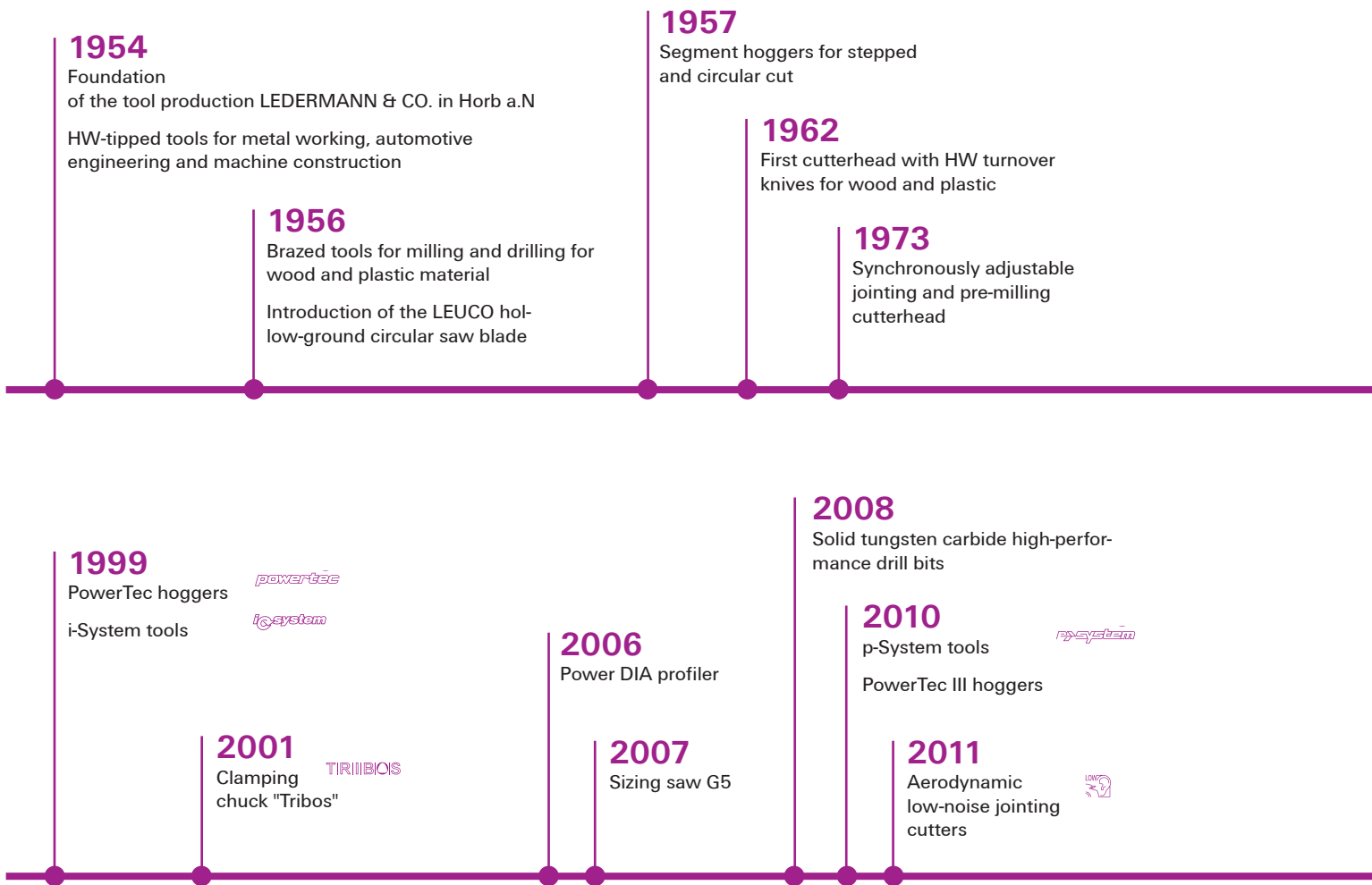
Open communication between equal partners is perhaps the most important requirement for improvements. Since its founding, LEUCO has stood for intensive cooperation between all parties involved in the value-added processes of the wood processing industry. We promote dialog, support the fight for quality and sustainability, thus advancing the power of innovation in our industry. Trust, personal contact, fairness and responsibility are critical for this process.

MAGENTIFY WOOD PROCESSING

Magentify is the word that characterizes LEUCO and stands for innovative tool solutions and application know-how for wood processing.

Our claim "Magentify Wood Processing" stands for our promise to provide our customers actively with a comprehensive support during their daily work.

WITH PIONEERING SPIRIT INTO THE FUTURE



With the founding of Ledermann und Co. in 1954, the engineer Josef Störzer and the businessman Willi Ledermann laid the foundation for the success of the LEUCO brand. Deeply rooted in their hometown Horb am Neckar, the two men pursued the ambitious goal of raising the bar in the wood processing industry by developing revolutionary tools.

In the years that followed, LEUCO deepened its reputation as a leading manufacturer of precision tools with its constant flow of new and innovative developments. The excellence of our products has enabled us to grow and made us one of the most highly sought-after partners in the wood processing industry around the world. Today, LEUCO combines leading tool technology and networked services to create a completely integrated portfolio.

Its product lines include circular saw blades, hoggers, bore-type and shank-type tools, drill bits, clamping elements and turnover knives.

Individual services, such as our sharpening service, application consulting and service packages combined under the term "Tool management" complete the product range. LEUCO sells directly to its customers. Our customers are sawmills, the building, furniture and paneling industries as well as interior fitters.

Around 1,200 employees work for LEUCO across the globe. The company has sales subsidiaries in Australia, Belgium, England, Japan, Malaysia, Poland, Russia, Singapore, Thailand, Ukraine, the US and Belarus. Sales and production companies are located in China, France, Switzerland and South Africa.

1975

s-System for circular saw blades and hoggers

LEUCO is the first tool manufacturer to present DIA tools on the LIGNA



1983

SuperProfiler with bore



1985

ps-System

1991

LEUCO DIAMAX

topline circular saw blade



1996

Tilted pre-trimming of laminate flooring

2013

LEUCO g5-System



Saw blades and grooving cutters with a tooth group combination of 5 teeth

2014

LEUCO nn-System low-noise saw blades



2015

LEUCO online catalog

Find tools – quickly and easily

2017

airStream-System

bores in the body optimize the aerodynamics



airFace

aerodynamic design of the body surface



2019

DIAREX DP saw blades for all cases: HR, DA-F-FA, TR-F-FA



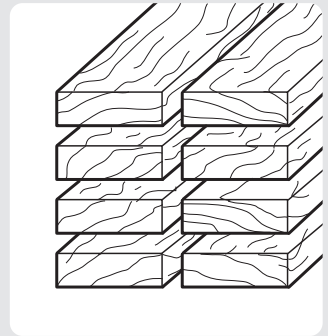
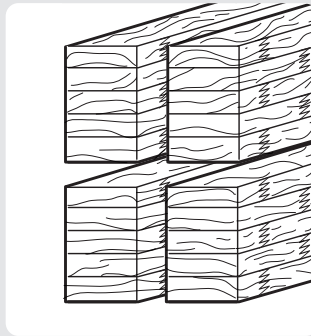
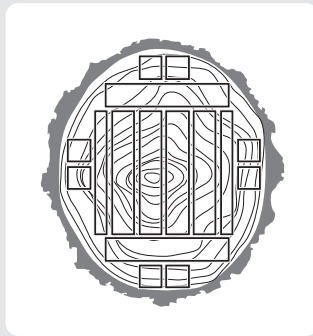
MAGENTIFY YOUR PROCESSING SKILLS

SOLID WOOD

Saw mills

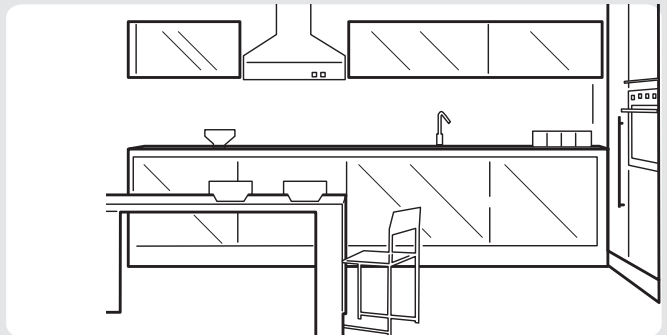
Beams and jointed products

Boards and planed material



PANEL

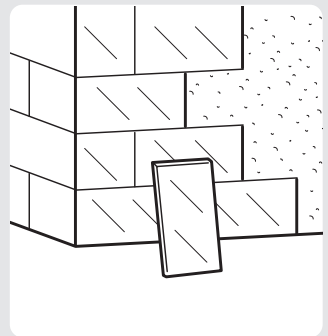
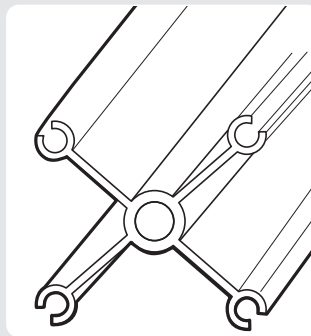
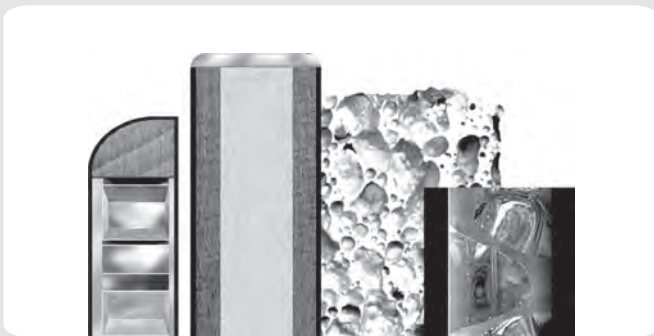
Kitchen



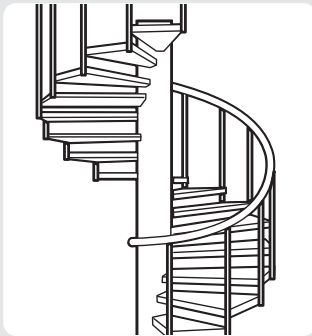
NON WOOD

Aluminum

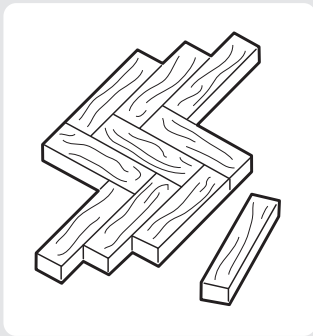
Facade materials



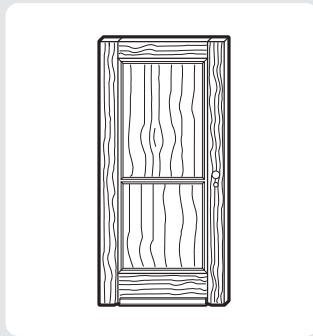
Staircase construction



Parquet



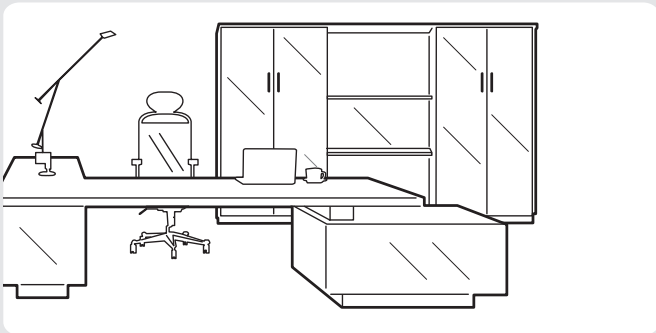
Doors



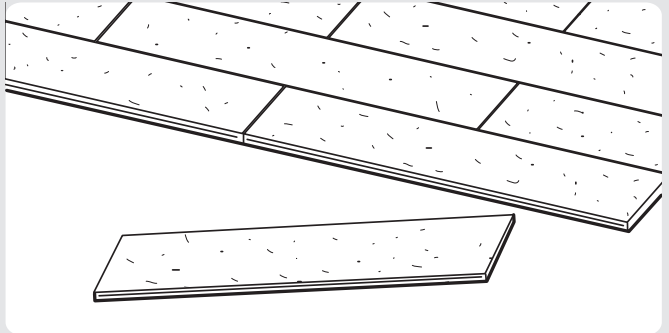
Solid wood furniture



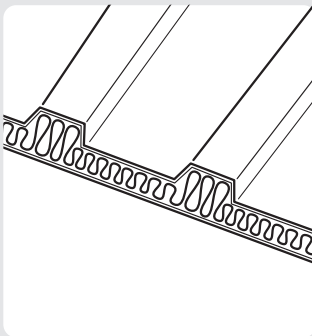
Office furniture



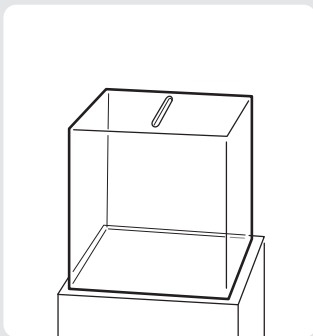
Laminate



Composite materials



Acrylics and plastics



SECTOR-SPECIFIC KNOW-HOW

LEUCO tools are used in the whole process chain of the woodworking and furniture industry, from the original material to the end product. The tools are perfectly adapted to the application parameters, performance data, processing sequences and demands of the different industry segments.

MAGENTIFY YOUR CUT

Extraordinary cutting performance. Large variety of applications.

U-Cut product family

MAGENTIFY YOUR SPEED

The new tungsten carbide-tipped U-Cut product family is ideal for the classic trimming cut. Perfect when maximum edge lives for individual or stack cuts of unfinished, veneered, plastic-coated panel materials are required.

U-Cut TR-F

The proven universal saw blade for all conventional panel materials, especially plastic-coated panels.

U-Cut Speed

For high-performance machines with high throughputs and stack cuts, starting at saw blade diameters of 520 mm.

See page 1-38



Q-Cut product family

MAGENTIFY YOUR QUALITY

The tungsten-carbide-tipped Q-Cut panel sizing saw blade family is used for finish cuts on horizontal panel sizing saws. Users obtain particularly clean, chip-free cutting edges for individual cuts and also, depending on the tooth geometry, even for stack cuts.

Q-Cut G6

For finish-cut quality with diameters ranging from 280 mm to 520 mm

Q-Cut TR-F K

For finish cut quality in anti-fingerprint materials and in plastics.

See page 1-34



Diamond - extra long edge lives

MAGENTIFY YOUR EFFICIENCY

The laser ornaments on the new diamond-tipped panel sizing circular saw blade family are arranged in a special vibration-damping sequence and additionally come with damping material. The better the tool body's vibrations are dampened, the quieter the blade cuts. Users are guaranteed to get better cutting performance and quality with much less noise throughout the entire service life of the saw blade. LEUCO is now offering all new diamond-tipped panel sizing saw blades with an optional "LEUCO topcoat" on the tooth sides. This prevents dirt from sticking and customers thus achieve edge lives for all applications never before seen in the industry.

See page 1-44

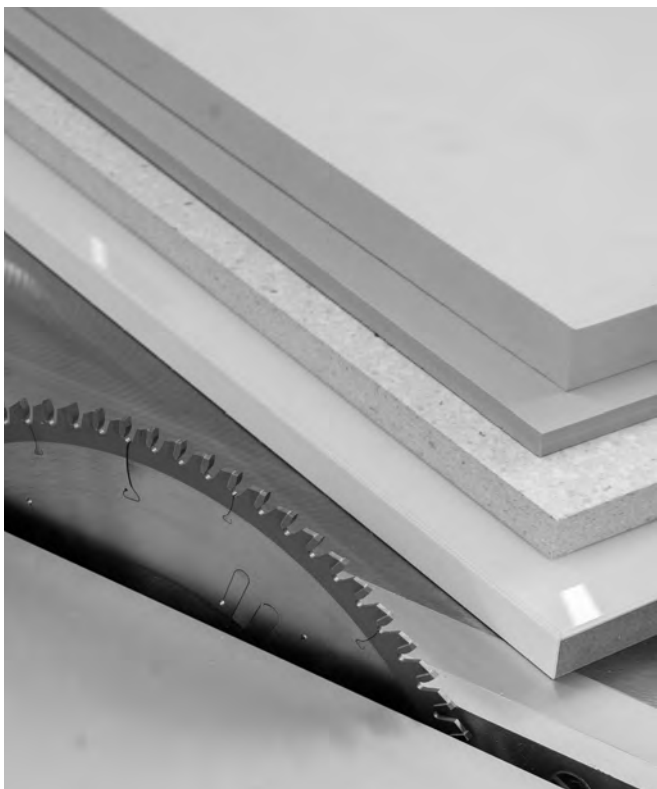
NEW DIAMOND-TIPPED SIZING SAW BLADES

Despite the higher purchase price compared to the price for HW tools, it also makes sound financial sense to use DIAREX DP saw blades on table saws and on vertical panel sizing saws.

In the long term, they are the more cost-effective option and score highly by achieving 20 times the service life of their less expensive counterparts. Parts can be cut to size in finish-cut quality.

DIAREX HR (right) is the all-rounder, suitable for universal applications. Recommended for wood fiberboard panels, abrasive and hard plastics such as CRP or GRP as well as magnet bond boards. DIAREX DA-F-FA saw blades (center) can achieve finish-cut quality on melamine-laminated or HPL-laminated wood-based panels. DIAREX TR-F-FA (left) is designed for raw chipboard and MDF.

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Excellent cutting quality of plastic material can be achieved with the new sizing saw blade of LEUCO. Plastic materials can be processed without almost no cutting marks and, in many cases, it is no longer necessary to rework the visible edges. It can be used on table saws and vertical panel saws. The new saw blade for plastic material is, above all, a specialist for all kinds of flat plastic panels such as glass laminate or many thermoplastics.

See page 1-27



MAGENTIFY YOUR EFFICIENCY

Highly efficient through-feed milling. Optimum quality.

PowerTec airFace hoggers

"LONG-DISTANCE RUNNERS" WITH PROLONGED EDGE LIVES

Thanks to its high productivity and the very long edge lives, the PowerTec is one of the most successful hogger manufactured by LEUCO. The most recent version in the airFace design has a prolonged tool life. The constant cutting width and its usability for panel materials with different coatings are further benefits of the PowerTec. The new version of the established PowerTec hogger allows feed rates of up to 100 m/min for panels with a thickness of at least 8 mm. The edge lives of the new PowerTec airFace could be improved by up to 15 percent thanks to a more advantageous tooth geometry.

See page 2-1



DIAREX airFace jointing cutters

JOINTING CUTTERS OFFERING MAXIMUM VERSATILITY

The wood-processing companies use an increasing variety of materials. The jointing cutter LEUCO DIAREX airFace is ideally suited for this challenge in the through-feed processing since, thanks to its cutting features, it has proven itself for a wide range of materials.

See page 3-93



The low noise level jointing cutter LEUCO DIAREX is the optimal choice for alternating materials in case of high quality demands.

JOINTING CUTTER LEUCO DIAMAX AIRSTREAM WITH HSK 32R CLAMPING

The combination "HSK 32R clamping on jointing aggregates" opens up new dimensions regarding quality in the industrial segment of compact machines:

The cutter combines the patented AirStream features, the quality of the LEUCO DIAMAX jointing cutters and the precision of the HSK 32R clamping. The HSK 32R interface with its precise traction and locking function is used for the first time for a jointing cutter. Available for the HOLZ-HER aggregates FG701.

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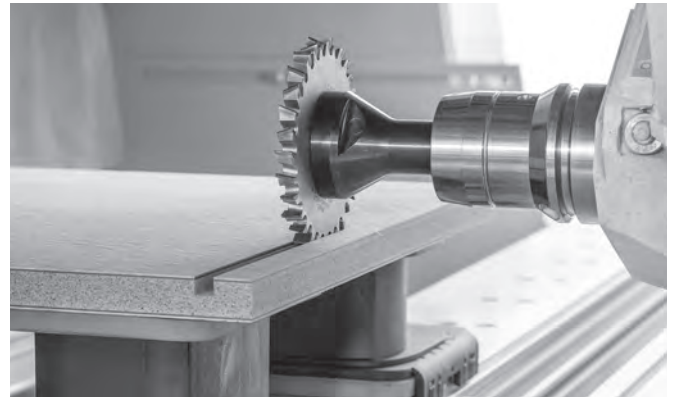
MAGENTIFY YOUR OPTIONS

Optimized performance. Innovative applications.

LEUCO grooving cutters with g5-System

QUICKER SAWING OF LARGE GROOVES

8.5 mm wide grooves in a single processing step with best cutting quality in a variety of materials, long edge lives and a pleasantly quiet noise level. The low cutting pressure of the carbide-tipped g5-System grooving cutter does not require a high motor output so that the grooving cutter can be used on every CNC machine. At the same time, the edge life of the tool is doubled. To obtain this width, a grooving cutter 5 mm and two passes have often been necessary.



See page 3-79

LEUCO nn-System, even for CNC manufacturing

HIGH CUTTING QUALITY ON CNC SYSTEMS

Due to the high quality of saw cuts and the low cutting pressure, the diamond-tipped nn-System DP flex blades are very well suited for use on CNC systems. For this category of machine, LEUCO can provide diameters of 180 to 300 mm. In addition to the hollow back geometry, the thin design of the core blade, with a width of just 2.5 mm, delivers great benefits in terms of cutting quality, for example on standard panels made of wood-based materials, with or without high-gloss coating, and on solid wood. The nn-System DP flex blades stand out due to their long edge lives..



LEUCO nn-System on a CNC machine: clean miter cut on blown glass with veneer on both sides

See page 1-28

New LEUCO DP shank-type cutters DIAMAX Z=1+1

STATE-OF-THE-ART TECHNOLOGY FOR ONE OF THE BEST-KNOWN CUTTERS IN THIS INDUSTRY SEGMENT

The new body design gives the tools an even higher stability which ensures a very smooth running. The diamond-tipped cutting edges of the new DIAMAX shank-type cutters have higher shear angles. Just like its predecessor, the new DIAMAX Z=1+1 is used for jointing, rabbeting, grooving and copying of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels. The new DIAMAX Z=1+1 can be resharpened several times.



New design: the new shank-type cutters have a higher shear angle

Previous design



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MAGENTIFY YOUR QUALITY

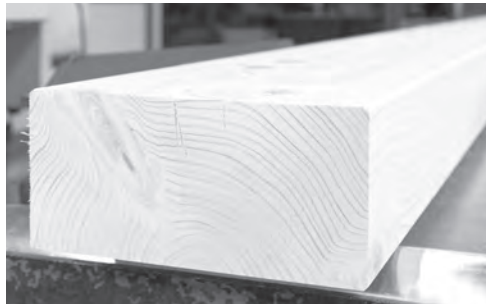
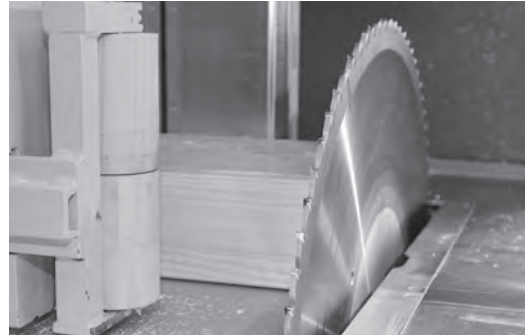
Chip-free, smooth surfaces. Reduced rework.

LEUCO saw blade with g5-System

EXCELLENT QUALITY FOR JOINERY MACHINES

LEUCO now also offers saw blades with tooth group configuration "G5" for joinery machines. They provide the typical advantages of this specific tooth geometry which include excellent cutting quality and significantly higher edge lives compared with the conventional saw blades. The distinctive "g5-System" tooth geometry group: flat tooth, alternate top bevel left, alternate top bevel right, alternate top bevel left, alternate top bevel right. It is not necessary to rework the accurate cuts which can be used as visible edges. The test customers of the saw blade used it for processes which, in the past, have been carried out with a cutter. The processing time on the joinery machine could therefore be reduced. A further benefit: the new saw blade is equally suitable for sawing along the grain and transverse to the grain direction.

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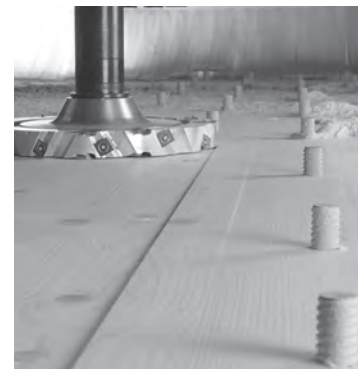
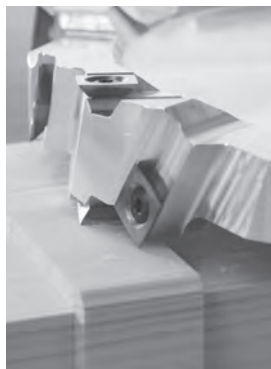


"LEUCO surfCut" cutterhead

TRIMMING IN FINISH QUALITY

Regardless of whether planing, rabbeting or grooving, the new trimming cutterhead "LEUCO surfCut" is sure to excite due to its smooth, chip-free surfaces normally even with branches, short machine downtimes and higher processing speeds. In addition, it can be used on the joinery centers of all machine manufacturers regardless of the machine brand. The tool geometry is optimized specifically for machining spruce and pine. For this work to go smoothly, the cutting pressure is crucial.

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Catalog "SW 02"

TOOLS FOR SAWING, FINGER JOINTING AND PLANING MILLS

The catalog "SW 02" combines the LEUCO tools for sawmills, joinery technique, door manufacturing, finger jointing, planing/profiling, clamping elements with HSK shank for tools with bore and suitable spare parts such as saw teeth, planing knives, turnover knives, trimming, measuring and clamping elements. The LEUCO tool specialists will be pleased to advise you.

TIP



MAGENTIFY YOUR EXPERTISE

Unique processing expertise in modern materials.

TIP

AT WWW.LEUCO.COM/PRODUCTS, YOU WILL FIND QUICKLY AND EFFECTIVELY THE TOOLS FOR YOUR MATERIAL

If you know the manufacturer and the product name of your material?

e.g. Egger, Fundermax, Pflaiderer etc*

Select by manufacturer and product

- | www.leuco.com/products > Select the filter "Workpiece material" **1**
- | Under "Workpiece type" select the manufacturer **2** and under "Workpiece material" **3** the respective product
- | Suitable saw blades, hoggers, cutters or drill bits are proposed to you
- | Select the desired tool **4**
- | Press the "Download" button to download the tool recommendation with application data (cutting speeds and feed rates) in form of a PDF file **5**
- | Making a price inquiry **6**



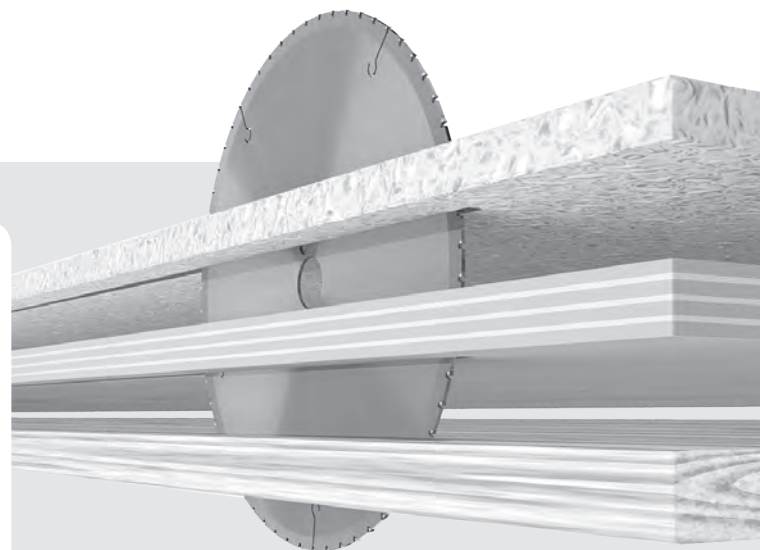
OR - DOWNLOAD THE TOOL RECOMMENDATION AS PDF FILE QUICKLY AND EASILY

- | www.leuco.com > Services > Downloads > Machining information
- | Select the manufacturer, select the product
- | Download the tool recommendation with application data (cutting speeds and feed rates)

You know the type of your workpiece material?

e.g. wood-based material, mineral-based material, composite material, etc.

- | www.leuco.com/products
- | Select the type of material in the filter "Workpiece material"
- | Narrow down the search for the kind and type of workpiece material
- | Suitable saw blades, hoggers, cutters or drill bits are proposed to you
- | Select the desired tool
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Circular Saw Blades

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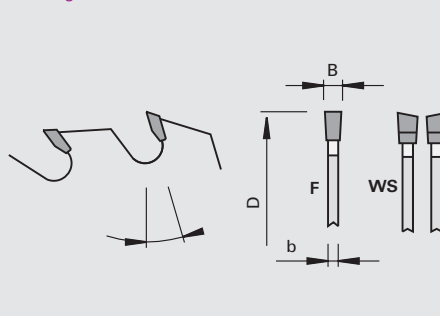
102317 / 102327

Thin-Kerf Saw Blades HW for parquet manufacturing

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | molders
- | splitting machines
- | for precise dividing cuts in trimmed solid woods

Design

- | specially treated tool body with Oxytop coating
- | tooth configuration:
 - | flat "F" for european hard woods (oak, beech, ...)
 - | alternate top bevel "WS" for exotic woods
- | cutting material: HW HL Board 06 plus

Advantages

- | optimum wood yield thanks to thin kerfs

Notes

- | also suitable for Hydro clamping bushing
- | bore extension to d=65 mm of edge saw blade for Schröder
- | packing unit 10 pieces

Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry		Ident-No.
180	1,0	0.8	65	24	18	3/11/80	F	Schröder	80254254 o
180	1,0	0.8	65	30	20	3/11/80	WS	Schröder	80254256 o
220	1,2	0.9	60	27	18	3/10/74	F	Weinig	80252288 o
220	1,2	0.9	65	27	18	3/11/80	F	Schröder	80252289 o
220	1,2	0.9	60	30	20	3/10/74	WS	Weinig	80252290 o
220	1,2	0.9	65	30	20	3/11/80	WS	Schröder	80252291 o
220	3,8/3,5	3.0	60	30	18	3/10/74 + 3/11/80	F	Weinig, Schröder	80252292 o
[mm]	[mm]	[mm]	[mm]		[°]				

Saw Blade Adapter Weinig HSK	Ø D	Ø d	Ø d1	L2	L1	Class-No.	PU	Ident-No.
	105	Weinig HSK	60	68		997300	1	182974 o
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	105x15xM58x1,5 [mm]	995290	1	182993 o
			[pc.]	

Hydro Clamping Bushing	Ø D	Ø d	Ø d1	L2	L1	Class-No.	PU	Ident-No.
	93	50	60	80	115	997300	1	182193 o
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	94	28	60	955520	1	182198 s
Spacers	94	30	65	955520	1	182199 s
Cover flange top with handhold	130	16	60	997300	1	182194 s
Cover flange top with handhold	130	16	65	997300	1	182196 s
Cover flange bottom	130	14	60	997300	1	182195 s
Cover flange bottom	130	14	65	997300	1	182197 s
Spacers	130	4,2	60	955520	1	182200 s
Spacers	130	4,3	60	955520	1	182201 s
Spacers	130	4,4	60	955520	1	182202 s
Spacers	130	4,5	60	955520	1	182203 s
Spacers	130	4,6	60	955520	1	182204 s
Spacers	130	4,7	60	955520	1	182205 s
Spacers	130	4,8	60	955520	1	182206 s
Spacers	130	4,9	60	955520	1	182207 s
	[mm]	[mm]	[mm]			

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	130	5,0	60	955520	1	182208 s
Spacers	130	4,5	65	955520	1	182209 s
Spacers	130	4,6	65	955520	1	182210 s
Spacers	130	4,7	65	955520	1	182211 s
Spacers	130	4,8	65	955520	1	182212 s
Spacers	130	4,9	65	955520	1	182213 s
Spacers	130	5,0	65	955520	1	182214 s
	[mm]	[mm]	[mm]			

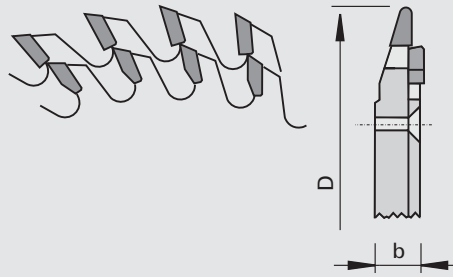
106352

Turnery saw blades HW

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | Special woodturning lathes (Zuckermann, Hempel, CMS-HIT)
- | for woodturning applications in solid wood

Design

- | carbide tipped
- | special tooth configuration
- | bore tolerance H7

Advantages

Notes

Ø D	b	Ø d	Z	NL	Ident-No.
350	11.3	60	2x64	6/11/170	185248 s
350	11.3	60	2x90	6/11/170	185249 s
[mm]	[mm]	[mm]			

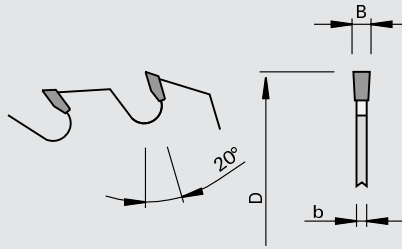
101310 / 101311

Gang-Rip Saw Blades HW "F"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- l molders
- l gang-rip saws with one or two shafts
- l for precise ripping cuts in dry and planed soft woods

Design

- l tooth configuration: flat "F"
- l cutting material: HW HL Board 20
- l type A and C with staggered double keyways

Advantages

- l staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- l larger bore (max. Ø 100 mm) available for a surcharge
- l for cutting height > 50 mm use version with HW rakers
- l for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Z	DKN	NL	Class-No.	Ident-No.
200	2,0	1.4	40	20			101311	188029
200	2,4	1.6	40	20			101311	188148
225	2,4	1.6	40	20			101311	188150
250	2,4	1.6	40	24			101311	188151
250	3,2	2.2	70	20	20x5		101310	189300
250	2,8	1.8	70	24	20x5		101311	188030
300	3,2	2.2	70	24	20x5		101310	189301
300	3,2	2.2	80	24	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	101310	189302
350	3,5	2.5	70	28	20x5		101310	189303
350	3,5	2.5	80	28	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	101310	188027 &
[mm]	[mm]	[mm]	[mm]		[mm]			

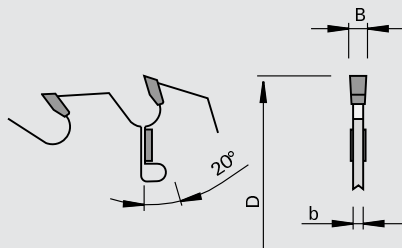
101715

Gang-Rip Saw Blades HW with HW-rakers - solid "F"

Product



Drawing



LEUCO
solid

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- l gang-rip saws with one or two shafts
- l for longitudinal cuts in wet and dry soft woods

Design

- l tooth configuration: flat "F"
- l cutting material: HW HL Board 20

Advantages

- l tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate

Notes

- l for inquiries / orders enclose specification sheet (see appendix)
- l for cutting height > 50 mm

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
300	3,0	2.0	50	90	130	20	2+2	189270
350	3,5	2.4	50	100	140	20	2+2	189271
400	4,2	3.0	50	100	150	24	2+2	189272
450	4,2	3.0	50	100	160	24	2+2	189273
500	4,6	3.3	50	100	180	28	2+2+2	189274
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

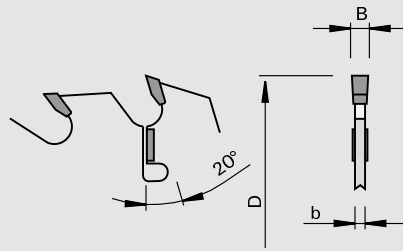
101315

Gang-Rip Saw Blades HW with HW-rakers "F"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | molders
- | gang-rip saws with one or two shafts
- | for longitudinal cuts in wet and dry soft woods

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 20
- | type A and C with staggered double keyways

Advantages

- | tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- | staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- | for inquiries / orders enclose specification sheet (see appendix)
- | for cutting height > 50 mm

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	DKN	NL	Ident-No.
180	2,4	1,6	40	55	95	16	2			188096
200	2,0	1,4	40	75	115	16	2			188097
200	2,4	1,6	40	75	115	16	2			188098
225	2,4	1,6	40	80	120	16	2			188100
250	2,4	1,6	40	80	125	16	2			188101
250	2,8	1,8	70		125	24	2	20x5		189290
300	3,2	2,2	70		120	16	2+2	20,0x5		189293
300	3,4	2,2	80		120	16	2+2	12,5x4,5		189296
300	3,2	2,2	70		120	28	2+2	20,0x5		189294
300	3,2	2,2	80		125	16	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189295
350	3,5	2,5	70		120	20	2+2	20x5		189297
350	3,8	2,5	80		125	20	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189299
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

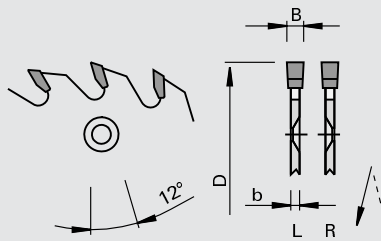
116410

Hogger Rings HW "F" - Linck

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

ØD	B	b	b1	D1	Ød	Z		Ident-No. [L]	Ident-No. [R]
576	4,5	3,5	6,0	531	422	52	Linck V25	80347850 s	80347849 s
724	4,5	3,5	6,0	684	586	64	Linck VM45	80371095 s	80371094 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

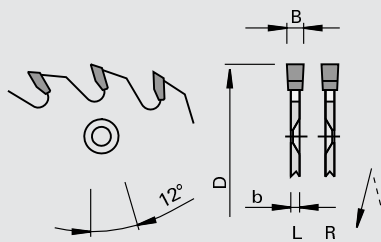
116410

Hogger Rings HW "F" - EWD

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

ØD	B	b	b1	D1	Ød	Z		Ident-No. [L]	Ident-No. [R]
745	6,6	5,0	6,0	700	520	60	EWD PF19	80291614 s	80291613 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

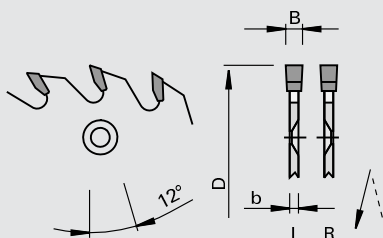
116410

Hogger Rings HW "F"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- chipping line rough and fine cut
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Solid 15 or HL Board 20

Advantages

- extremely high bending strength and hardness of the teeth

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	D1	Ø d	Z	Ident-No. [L]	Ident-No. [R]
560	5,0	3.6	5.8	485	405	48-4	80317242 s	80317243 s
605	4,4	3.2	6.0	540	440	48	80294208 s	80294209 s
620	5,0	3.8	5.0	540	450	60-3	80206577 s	80206581 s
630	4,4	3.2	6.0	539	440	48-3	80274257 s	80274262 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

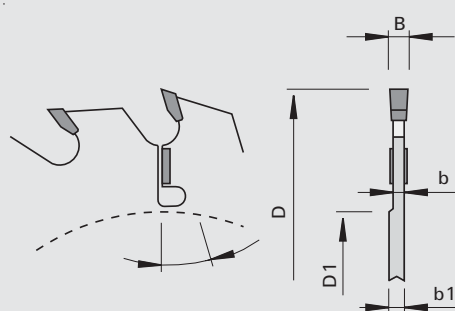
101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers "F" - Linck

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	NL	DKN	Ident-No. [L]	Ident-No. [R]
445	4,8	3,2	6,8	190	120	28	4	4/13/156	Linck VS	80250724 s	80250723 s
470	5,0	3,6	6,8	190	120	28	6	8/13/156	Linck VS	80290358 s	80290357 s
505	5,6	3,8	6,8	190	120	28	4	8/14,5/156	Linck VS	80281372 s	80281373 s
520	5,0	3,2			110	32	6	12/13/140	Linck VS	80269113 s	80269113 s
525	5,6	4,0	6,8	190	120	24	6	6/13/156	Linck VS	80307585 s	80307584 s
525	4,8	3,2	6,8	240	160	28	6	6/12/210	Linck VS	80279581 s	80279579 s
540	4,2	2,8	5,1	235	145	24	6	8/12,5/165	20x7 Linck CSMK 285	80245193 s	80245192 s
540	5,0	3,4	6,8	205	150	24	6	8/12/180	Linck CSMK 285	80268479 s	80268478 s
540	4,8	3,2	6,8	205	150	28	6	8/11/180	Linck CSMK 285	80283376 s	80283375 s
540	5,2	3,4	6,8	205	150	28	6	8/12/180	Linck CSMK 285	80333677 s	80333678 s
550	5,2	3,5			120	24	6	8/18/155	Linck VS	80254383 s	80254381 s
580	5,0	3,2	5,2	250	145	32	6	8/12/165	20x5 Linck CSMK 325	80333690 s	80333692 s
648	5,6	3,8	6,8	210	160	24	8	8/11/185	Linck CSMK 375	80250585 s	80250584 s
695	5,0	3,4	6,8	350	170	50	8	12/12/195	20x5 Linck CSMK 425	80258266 s	80258264 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		[mm]		

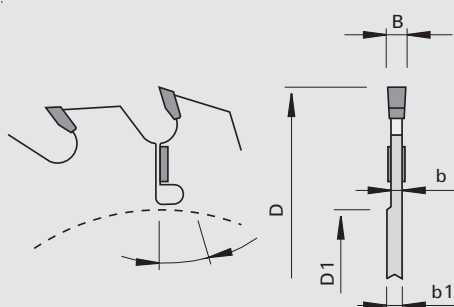
101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers "F" - EWD

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	NL	DKN		Ident-No. [L]	Ident-No. [R]
560	4,8	3,2	7,0	220	150	32	6	6/10,25/175		EWD FR 15	80291675 s	80291674 s
565	5,2	3,4	7,0	205	160	42	6	6/11/182,5 + 12/8,5/182,5	22,2x5,4	EWD DWK	80297832 s	80297833 s
580	4,1	2,8	5,5	300	160	32	6	6/12/182,5	23x6	EWD DWK	80309039 s	80309038 s
590	5,2	3,4	7,2	205	160	22	6	6/11/182,5 + 6/8,5/182,5	23x6	EWD FR 22	80309372 s	80309371 s
600	5,0	3,4	6,0	240	145	36	6	6/16/208 + 6/16/180	20x9,5	EWD VNK 300	80290174 s	80290175 s
610	5,0	3,2	6,0	240	145	36	6	6/16/208 + 6/16/180	20x9,5	EWD VNK 300	80306576 s	80306587 s
630	5,4	3,8	7,0	200	150	24	6	8/8,5/175 + 2/10,2/175	37x4	EWD FR 16	80143865 s	80143864 s
630	5,4	3,8	7,0	200	150	36	6	8/8,5/175	36,5x4	EWD FR 16	80359234 s	80359233 s
630	5,2	3,6	4,5	200	150	28	8		36,5x4	EWD FR 16	80300918 s	80300915 s
640	5,6	3,8	7,0	205	160	28	6	6/11/182,5 + 12/8,5/182,5	23x6	EWD DWK	80289037 s	80289036 s
700	5,2	3,8	6,0	190	125	32	6	8/16/160 + 4/18/165		EWD BNK 6	80278892 s	80278891 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		[mm]			

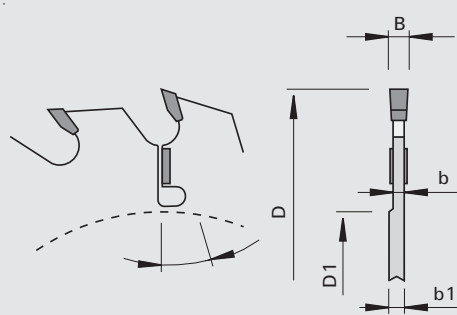
101317

Pre-Cut Gang-Rip Saw Blades HW with HW-rakers "F"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- primary machines with and without chippers
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

ØD	B	b	b1	D1	Ø d	Z	Number of rakers	NL		Ident-No. [L]	Ident-No. [R]
595	5,2	3,6	6,8	190	105	20	6	8/13/156	Möhringer	80293989 s	80293990 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]				

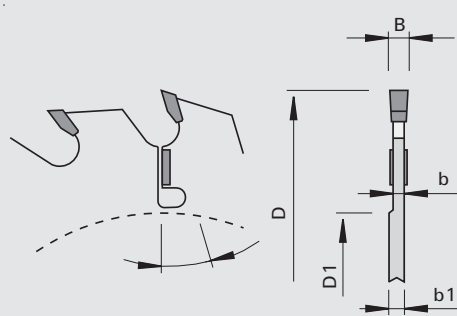
101316

Re-Cut Gang-Rip Saw Blades HW with HW-rakers "F" - Linck

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- multi-blade machines with or without chipper
- for longitudinal cuts in wet and dry soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 20
- type A and C with staggered double keyways

Advantages

- extremely high bending strength and hardness of the teeth
- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

ØD	B	b	b1	D1	Ø d	Z	Number of rakers	DKN		Ident-No.
520	3,6	2,2			150	36	4	37x10	Linck MKV	80231924 s
520	4,6	3,2			150	28	6	37x10	Linck MKV	80255324 s
540	4,8	3,4			150	24	4	37x10	Linck MKV	80254014 s
540	4,4	2,8	4,9	230	150	28	6	37x10	Linck MKV	80259614 s
540	3,2	2,0			150	46	4	37x10	Linck MKV	80273199 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

Ø D	B	b	b1	D1	Ø d	Z	Number of rakers	DKN		Ident-No.
540	3,4	2.1	3.9	345	150	45	6	37x10	Linck MKV	80337192 s
540	4,0	2.6			150	36	6	36,5x9	Linck MKV	80293102 s
540	4,0	2.6			150	30	6	36,5x9	Linck MKV	80307378 s
545	2,8	1.8			150	57	3	37x10	Linck MKV	80326780 s
570	4,8	3.4			150	20	6	37x10	Linck MKV	80270360 s
570	3,2	2.2	4.6	400	150	54	6	37x10	Linck MKV	80293546 s
570	2,9	1.9	3.9	400	150	56	6	37x10	Linck MKV	80332037 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

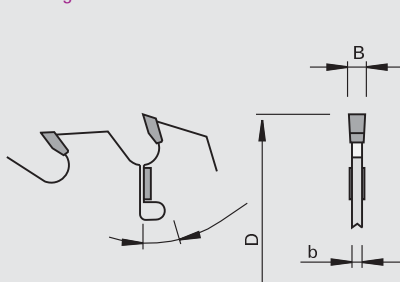
101316

Re-Cut Gang-Rip Saw Blades HW with HW-rakers "F" - EWD

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | multi-blade machines with or without chipper
- | for longitudinal cuts in wet and dry soft woods

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 20
- | type A and C with staggered double keyways

Advantages

- | extremely high bending strength and hardness of the teeth
- | tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- | staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- | the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- | Ident-No. is only for orientation

Ø D	B	b	Ø d	Z	Number of rakers	DKN		Ident-No.
450	3,8	2.5	110	24	4	17x8	EWD FR	80264025 s
450	4,2	2.7	150	36	4	37x7	EWD	80225333 s
500	4,4	3.0	150	24	4	37x7	EWD FR12	80236978 s
520	4,9	3.4	150	24	6	36,5x4	EWD FR12	80291680 s
520	4,9	3.4	150	48	6	36,5x4	EWD FR12	80291939 s
520	4,9	3.4	150	32	6	36,5x4	EWD FR12	80308059 s
[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

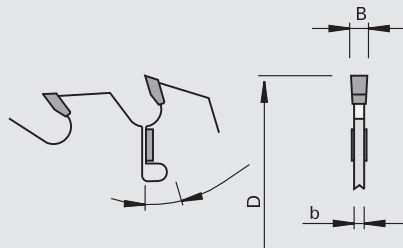
101316

Re-Cut Gang-Rip Saw Blades HW with HW-rakers "F" - HewSaw

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | multi-blade machines with or without chipper
- | for longitudinal cuts in wet and dry soft woods

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 20
- | type A and C with staggered double keyways

Advantages

- | extremely high bending strength and hardness of the teeth
- | tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- | staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- | the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- | Ident-No. is only for orientation

Ø D	B	b	Ø d	Z	Number of rakers		Ident-No.
351	4,4	3.2	70	24	2+2	HewSaw	192611
[mm]	[mm]	[mm]	[mm]		[pc.]		

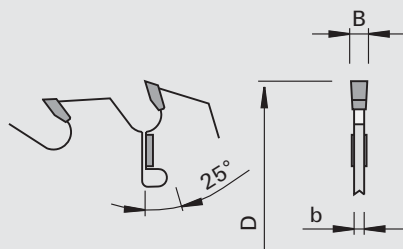
101315

Gang-Rip Saw Blades HW with HW-rakers "F" - for profiling aggregate HewSaw

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | profiling machines HewSaw
- | for longitudinal cuts in wet and dry soft woods

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 10
- | circular saw blades with different openings

Advantages

- | extremely high bending strength and hardness of the teeth

Notes

- |

Ø D	B	b	Ø d	Z	Number of rakers	NL	Ident-No.
351	4,6	3.2	70	24	2	1/6,3/100	80366486 s
351	4,6	3.2	70	24	2	1/6,3/100	80371233 s
[mm]	[mm]	[mm]	[mm]		[pc.]		

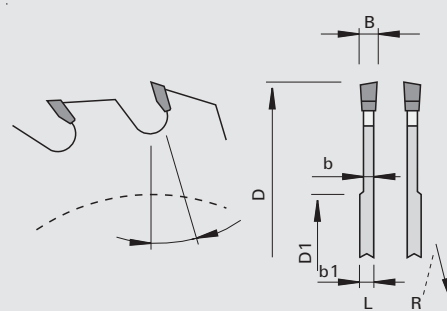
101353

Gang-Rip Saw Blades HW "ES" - for profiling aggregate HewSaw

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

l profiling machines HewSaw
l for longitudinal cuts in wet and dry soft woods

Design

l tooth configuration: top bevel "ES"
l cutting material: HW HL Board 20

Advantages

l extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	b1	D1	Ø d	Z	DKN	Free slots	Ident-No. [L]	Ident-No. [R]
250	5,2	3,6	6,0	115	70	24-6	20x8	3	80363728 s	80363727 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[pc.]		

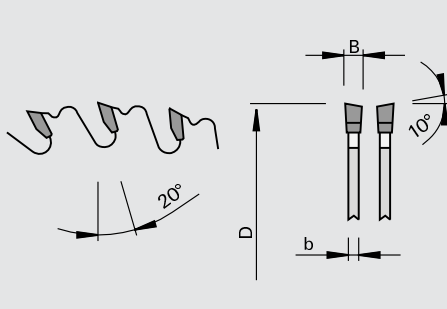
101725

Gang-Rip Saw Blades HW with internal HW-rakers - solid "WS"

Product



Drawing



LEUCO
solid

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l table saws
l climb-cutting rip saws
l suitable for manual feed
l for ripping and cross cuts in wet and dry solid woods

Design

l tooth configuration: alternate top bevel "WS"
l cutting material: HW HL Board 20
l 4 internal spurs HW

Advantages

l tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
l chip limiter design for universal application

Notes

l for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	NL	Ident-No.
350	3,5	2,5	30	70	140	24	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189643
400	3,5	2,5	30	80	160	28	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189644
450	4,2	2,8	30	80	160	36	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189645
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

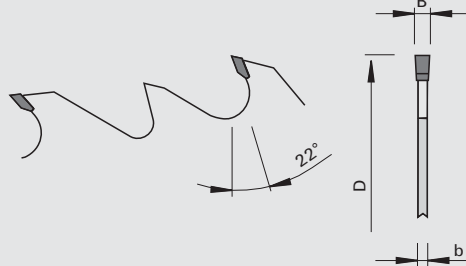
101715

Gang-Rip Saw Blades HW with HW-rakers - solid "F" for low feed rates

Product



Drawing



LEUCO
solid

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- gang rip machine with low feed rates
- for longitudinal cuts in wet solid woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 10
- with internal and external HW-rakers

Advantages

- tungsten carbide rakers prevent the sides of the wood from making contact with the steel plate
- optimal chip evacuation thanks to special design
- particularly robust design

Notes

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
400	4,4	3.2	50	100	150	18	2+2	192638
450	4,8	3.2	50	100	160	18	2+2	192639
500	5,0	3.5	50	100	180	18	2+2	192640
550	5,2	3.5	50	140	180	18	4+2	192641
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

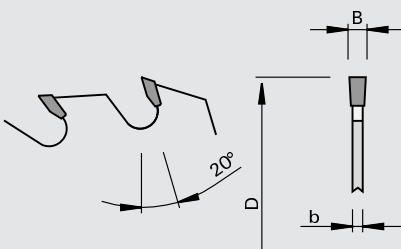
101310

Gang-Rip Saw Blades HW with cooling slots "F"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- molders
- gang-rip saw with one or two shafts (e.g. Raimann, Paul, Costa, ...)
- for precise ripping cuts in dry and planed hard woods

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 10

Advantages

- special design and tungsten carbide grade for highest cutting quality and very long edge lives

Notes

- for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of cooling slots	DKN	NL	Ident-No.
250	3,4	2.2	30	80	120	24	3			189275
300	3,4	2.2	80	100	140	28	4	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189276
300	3,4	2.2	30	100	130	28	4			189277
350	3,6	2.4	30	100	140	32	4			189279
350	3,6	2.4	80	100	140	32	4	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189280
500	4,0	2.8	30	100	165	40	4			189282
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

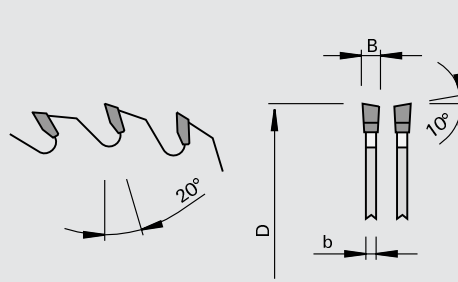
101320

Gang-Rip Saw Blades HW "WS"

Product



Drawing



LEUCO
toplina

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | molders
- | gang-rip saws with one or two shafts
- | for precise ripping cuts in dry and planed solid woods and wood-based materials

Design

- | staggered double keyways of type A and C
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06 for wood-based materials
- | cutting material: HW HL Board 20 for solid woods

Advantages

- | staggering the types (A-C-A etc.) on the shaft creates a cut division that puts less pressure on the machine

Notes

- | larger bore (max. Ø 100 in) available for a surcharge
- | for inquiries / orders enclose specification sheet (see appendix)

Ø D	B	b	Ø d	Z	DKN	NL	LEUCODUR	Ident-No.
190	3,4	2.2	30	20			HL Board 20	188049
200	3,2	2.2	60	34		Paul	HL Board 06	188038
200	3,2	2.2	60	42		Paul	HL Board 06	188041
210	3,2	2.2	100	34	12,5x4		HL Board 06	189283
220	3,4	2.2	50	24			HL Board 20	188051
300	3,2	2.2	80	28	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	HL Board 20	188054
300	3,2	2.2	70	36	20x5		HL Board 20	189285
300	3,2	2.2	80	36	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	HL Board 20	189286
300	3,2	2.2	70	48	20x5		HL Board 20	189287
[mm]	[mm]	[mm]	[mm]		[mm]			

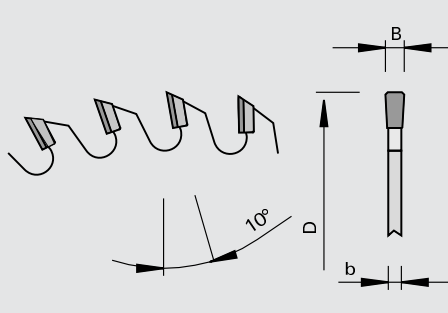
203040

Gang-Rip Saw Blades DP "F-FA" - Paul, Homag

Product



Drawing



LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

l gang-rip machines Paul, Homag
l for trimming cuts in raw and laminated panels and composite materials

Design

l tooth configuration: flat with chamfer "F-FA"
l resharpenable area 3.5 mm

Advantages

Notes

l for saw blade Ø d=110 mm please use hydro bushing
Ident-No. 183829 / 183821

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.6	60	36	4/9/74	189734 s
250	2,4	2.0	60	36	4/9/74	189735 s
250	1,6	1.3	60	36	4/9/74	189736 s
250	3,2	2.6	60	48	4/9/74	189725 s
250	2,4	2.0	60	48	4/9/74	189726 s
250	1,6	1.3	60	48	4/9/74	189727 s
[mm]	[mm]	[mm]	[mm]			

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.6	100	36	3/18/150	Paul, Homag 189731 s
250	2,4	2.0	100	36	3/18/150	Paul, Homag 189732 s
250	1,6	1.3	100	36	3/18/150	Paul, Homag 189733 s
250	3,2	2.6	100	48	3/18/150	Paul, Homag 189722 s
250	2,4	2.0	100	48	3/18/150	Paul, Homag 189723 s
250	1,6	1.3	100	48	3/18/150	Paul, Homag 189724 s
[mm]	[mm]	[mm]	[mm]			

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.6	110	36	8/8,5/130	Paul, Homag 189728 s
250	2,4	2.0	110	36	8/8,5/130	Paul, Homag 189729 s
250	1,6	1.3	110	36	8/8,5/130	Paul, Homag 189730 s
250	3,2	2.6	110	48	8/8,5/130	Paul, Homag 189719 s
250	2,4	2.0	110	48	8/8,5/130	Paul, Homag 189720 s
250	1,6	1.3	110	48	8/8,5/130	Paul, Homag 189721 s
[mm]	[mm]	[mm]	[mm]			

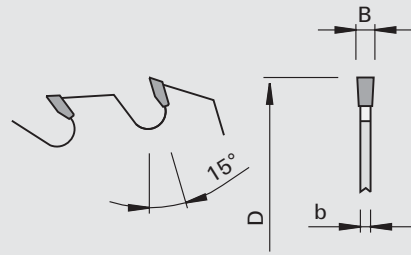
101310

Gang-Rip Saw Blades HW "F" - for Linck VPM profiling aggregate

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

| Linck VPM profiling aggregate
| for longitudinal cuts in wet and dry soft woods

Design

| tooth configuration: flat "F"
| cutting material: HW HL Board 20

Advantages

| extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	Ø d	Z	Ident-No.
566 [mm]	5,0 [mm]	4.0 [mm]	80 [mm]	36	80350084 s

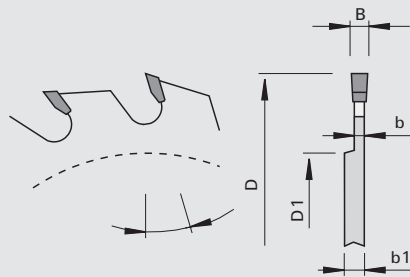
116200

HW Segments - for Linck VPM profiling aggregate

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Linck VPM profiling aggregate
for longitudinal cuts in wet and dry soft woods





Design

tooth configuration: flat "F"
cutting material: HW HL Board 20

Advantages

extremely high bending strength and hardness of the teeth

Notes

	Ø D	B	b	D1	b1	Z	Ident-No. [L]	Ident-No. [R]
	414 [mm]	3,5 [mm]	2.5 [mm]	360 [mm]	8 [mm]	10	80334874 s	80335077 s
	497 [mm]	3,5 [mm]	2.5 [mm]	446 [mm]	8 [mm]	8	80333596 s	80335075 s
	499.4 [mm]	3,5 [mm]	2.5 [mm]	446 [mm]	7 [mm]	10	80350396 s	80350395 s
	498.2 [mm]	3,5 [mm]	2.5 [mm]	447 [mm]	7 [mm]	11	80371097 s	80371098 s

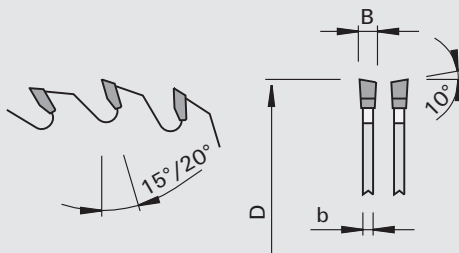
101620/107520

Trimming Saw Blades HW "WS"

Product



Drawing



LEUCO
highlight

LEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- table saws
- for sizing cuts in solid woods

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW HL Board 10

Advantages

- noise-reduction thanks to laser ornaments for saw blades of more than Ø 250 mm

Notes

- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
200	3,2	2,2	30	24	20	2/7/42	107520	189932
250	3,2	2,2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189933
250	4,4	2,8	30	20	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189934 s
300	3,2	2,2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189935
300	3,2	2,2	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189936
300	3,2	2,2	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189937
350	3,5	2,5	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189938
350	3,5	2,5	30	32	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189939
350	3,5	2,5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189940
350	4,4	2,8	30	28	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189941
400	3,5	2,5	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189942
400	3,5	2,5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189943
450	3,8	2,8	30	40	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189944
500	3,8	2,8	30	44	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189945
[mm]	[mm]	[mm]	[mm]		[°]			

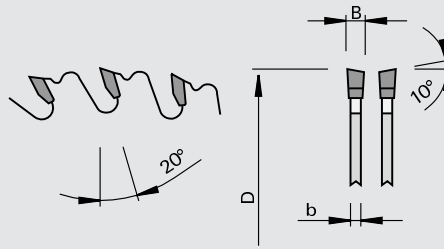
101620

Trimming Saw Blades HW - with chip limiter "WS"

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | table saws
- | special saws
- | for sizing cuts in solid woods
- | especially for knotty woods

Design

- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 10

Advantages

- | no chipped edges from knots thanks to chip limiter
- | noise-reduction thanks to laser ornaments

Notes

- | larger bore (max. Ø 50 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	189946
300	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189947 \$
315	3,2	2.2	30	28	2/7/42 + 2/9,5/46,5 + 2/10/60	189948
350	3,5	2.5	30	32	2/7/42 + 2/9,5/46,5 + 2/10/60	189949 \$
400	3,5	2.5	30	36	2/7/42 + 2/9,5/46,5 + 2/10/60	189950 \$
450	3,8	2.8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	189951
500	3,8	2.8	30	44	2/7/42 + 2/9,5/46,5 + 2/10/60	189952
[mm]	[mm]	[mm]	[mm]			

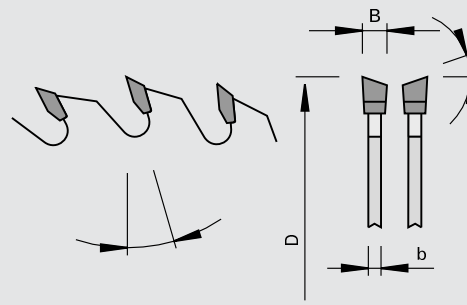
101320

Sizing Saw Blades HW "WS" - Weinmann

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- | joinery machines
- | special machines
- | for sizing cuts in wood-based panels
- | for clipping and miter cuts in solid woods and wood-based panels

Design

- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 20

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
[mm]	[mm]	[mm]	[mm]			[°]	[°]		
230	3,2	2.2	40	40	8/5,5/52	10	15	Weinmann	192427
240	3,0	2.0	40	30	8/6/52	10	15	Weinmann	192428

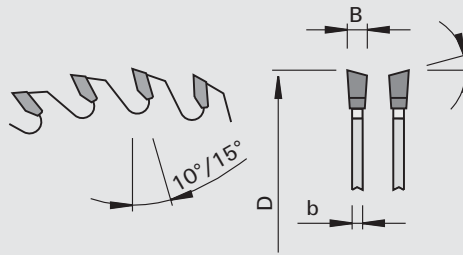
102620/102628/107520

Sizing Saw Blades HW "WS"

Product



Drawing

LEUCO
highlightLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- table saws
- special saws
- for sizing cuts in wood-based panels

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW
- Class-No. 107520 HL Board 10, hook angle 15°
- Class-No. 102620/102628 HL Board 06, hook angle 10°

Advantages

- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth
- noise-reduction thanks to laser ornaments from Ø 250 mm upwards

Notes

- larger bore (max. Ø 80 mm) available for a surcharge

Ø D	B	b	Ø d	Z	KN	NL	Class-No.	Ident-No.
150	3,2	2,2	30	24		2/7/42	107520	189953
150	3,2	2,2	30	36		2/7/42	102620	189954
150	3,2	2,2	30	48		2/7/42	102620	189955
180	3,2	2,2	30	30		2/7/42	107520	189956
180	3,2	2,2	30	54		2/7/42	102620	189957
200	3,2	2,2	30	34		2/7/42	107520	189958
200	3,2	2,2	30	48		2/7/42	102620	189959
200	3,2	2,2	30	64		2/7/42	102620	189960
250	3,2	2,2	30	40		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189961 \$
250	3,2	2,2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189962
250	3,2	2,2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189963
250	3,2	2,2	30	80		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189964
300	3,2	2,2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189965 \$
300	3,2	2,2	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189966 \$
300	3,2	2,2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189967 \$
300	3,2	2,2	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189968 \$
315	3,2	2,2	30	48		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189969
315	3,2	2,2	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189970
350	3,5	2,5	30	54		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189971 \$
350	3,5	2,5	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189972 \$
350	3,5	2,5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189973 \$
350	3,5	2,5	30	108		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189974 \$
400	3,5	2,5	30	60		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189975
400	3,5	2,5	30	84		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189976
400	3,5	2,5	30	96		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189977
400	3,5	2,5	30	120		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189978
400	3,5	2,5	50	60	8x8,2	2/10/60	102628	189979 €
450	3,8	2,8	30	66		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189980
500	3,8	2,8	30	72		2/7/42 + 2/9,5/46,5 + 2/10/60	102628	189981
[mm]	[mm]	[mm]	[mm]		[mm]			

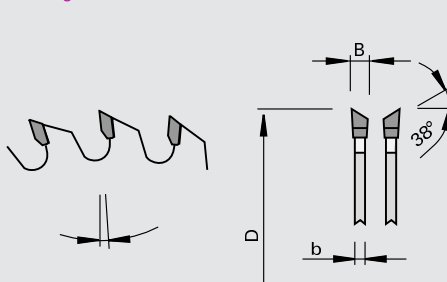
102628

Sizing Saw Blades HW “WS - profiles, ledges and plastic profiles

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- l chop and miter saws
- l table saws
- l for sizing and trimming cuts in wood-based panels

Design

- l tooth configuration: alternate top bevel “WS”
- l cutting material: HW HL Board 06

Advantages

- l chip-free cutting without using a scoring aggregate thanks to 38 degree ATB
- l noise-reduction thanks to laser ornaments

Notes

- l for profiles, ledges and plastic profiles

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	-2	189982
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	2	189983
[mm]	[mm]	[mm]	[mm]			[°]	

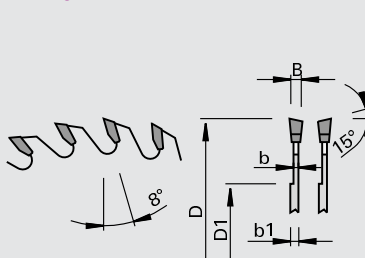
102323

Sizing Saw Blades HW - thin rim design of the steel plate “WS”

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- l table saws
- l machines Scheer FM
- l for sizing cuts in thin-walled plastic profiles and veneers

Design

- l extra thin rim design of the steel plate
- l tooth configuration: alternate top bevel “WS”
- l cutting material: HW HL Board 06

Advantages

- l improved stability thanks to relieved tool body

Notes

Ø D	B	b1	b	D1	Ø d	Z	NL	Ident-No.
160	1,8	2.2	1.0	80	16	48	2/7,5/31,5	188209
180	1,6	2.2	1.0	105	16	56	1/6/33	188210
250	1,7	2.2	1.0	170	30	80		188211
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

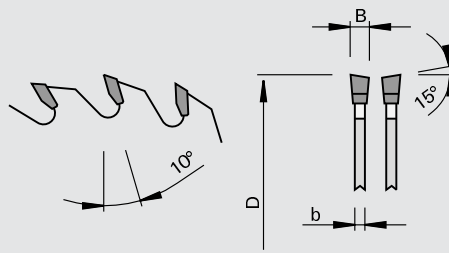
102321

Sizing Saw Blades HW - thin "WS" - wood-based panels

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | chop and miter saws
- | table saws
- | for clipping and miter cuts in solid woods, mainly in MDF
- | for cross cutting of profiles (e.g. plastic profiles)

Design

- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 03 plus

Advantages

- | long edge lives

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
150	2,4	1,8	30	48		189699
180	2,4	1,8	30	60		189700
200	2,4	1,8	30	64		189701
250	2,4	1,8	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189702
300	2,4	1,8	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189704
300	2,6	2,2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189705
350	2,6	2,2	30	108	2/7/42 + 2/9,5/46,5 + 2/10/60	189706
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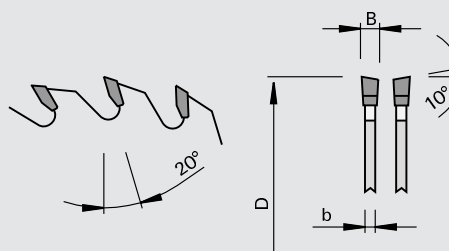
102321

Sizing Saw Blades HW - thin "WS" - solid woods

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | table saws
- | sizing saws
- | cut-off saws
- | for sizing and clipping cuts in solid woods

Design

- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
180	2,4	1,8	30	30		188064
200	2,4	1,8	30	32		188065
250	2,4	1,8	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	188067
300	2,4	1,8	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	188068
350	2,6	2,0	30	54	2/7/42 + 2/9,5/46,5 + 2/10/60	188069
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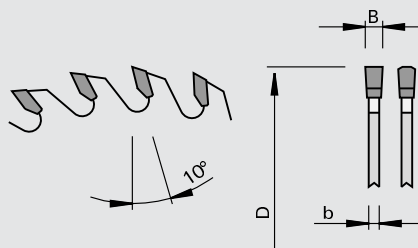
102678

Sizing Saw Blades HW "TR-F" - hook angle 10°

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for sizing cuts in plastic-laminated panels

Design

- | tooth configuration: triple chip / flat "TR-F"
- | cutting material: HW HL Board 06

Advantages

- | noise-reduction thanks to laser ornaments

Notes

- | larger bore (max. Ø 50 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189984 \$
300	3,2	2.2	30	72	2/7/42 + 2/9,5/46,5 + 2/10/60	189985 \$
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189986 \$
350	3,5	2.5	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189987
[mm]	[mm]	[mm]	[mm]			

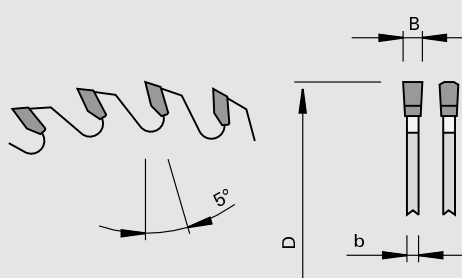
102678

Sizing Saw Blades HW "TR-F" - hook angle 5°

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for sizing cuts in plastic-laminated panels

Design

- | tooth configuration: triple chip / flat "TR-F"
- | cutting material: HW HL Board 06

Advantages

- | improved bottom edge (without scoring sawblade) thanks to 5 degree hook angle
- | noise-reduction thanks to laser ornaments

Notes

- | larger bore (max. Ø 50 mm) available for a surcharge

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	189988
300	3,2	2.2	30	96	2/7/42 + 2/9,5/46,5 + 2/10/60	189989 \$
[mm]	[mm]	[mm]	[mm]			

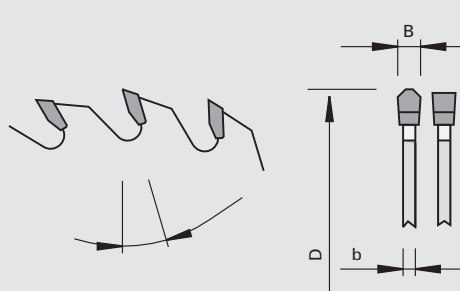
102378

Sizing Saw Blades HW "TR-F" - magnet bond boards

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- | table saws
- | horizontal panel sizing saws
- | for sizing cuts in magnet bond boards or panels with thin steel foils
- | for single or stack cuts

Design

- | tooth configuration: triple chip / flat "TR-F"
- | cutting material: special HW grade HL Steel 17

Advantages

- | noise reduction thanks to laser ornaments
- | spark-reduced cutting

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
350	3,2	2.5	30	110	2/7/42 + 2/9/46 + 2/10/60	5	192609
350	4,4	3.2	30	72		10	192610
[mm]	[mm]	[mm]	[mm]			[°]	

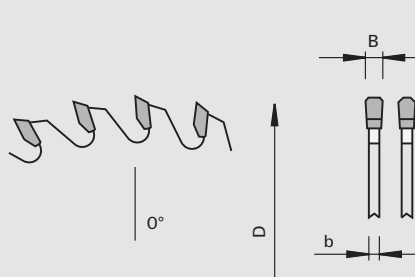
102388

Sizing Saw Blades HW - solid Surface "TR-F-FA"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- | table saws
- | vertical panel sizing saws
- | especially for the machining of solid surface materials and hard wood-based panels such as Corian, compact boards, ...

Design

- | with laser ornaments
- | tooth configuration: triple chip / flat with chamfer "TR-FA"
- | cutting material: HW HL Board 06

Advantages

- | less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.5	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193133
[mm]	[mm]	[mm]	[mm]			

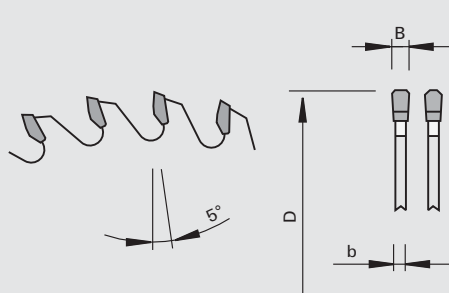
102388

Sizing Saw Blades HW "TR-F-FA" - plastics

Product



Drawing



Tungsten Carbide [HW]



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for finish cuts in varying thermoplastic materials

Design

- | with laser ornaments
- | tooth configuration: triple chip / flat with chamfer "TR-F-FA"
- | cutting material: HW HL Board 06

Advantages

- | less vibration and noise thanks to laser ornaments

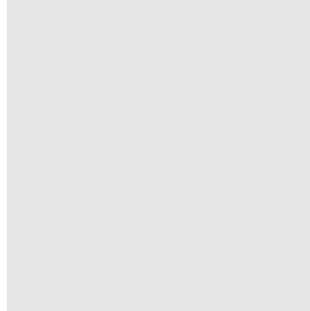
Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193109
[mm]	[mm]	[mm]	[mm]			

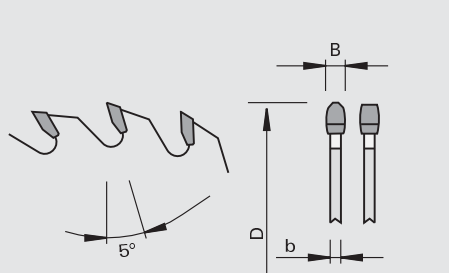
102388

Sizing Saw Blades HW "TR-F K" - anti fingerprint

Product



Drawing



Tungsten Carbide [HW]



Machine / Application

- | table saws
- | vertical panel sizing saws

Design

- | with laser ornaments
- | tooth configuration: TR-F K
- | cutting material: HW HL Board 04 plus

Advantages

- | excellent cutting quality in "anti fingerprint" materials and for conventional plastics
- | no scoring on the cutting surface due to convex tooth sides
- | no flares on the surface of sensible materials
- | less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	193195
[mm]	[mm]	[mm]	[mm]			

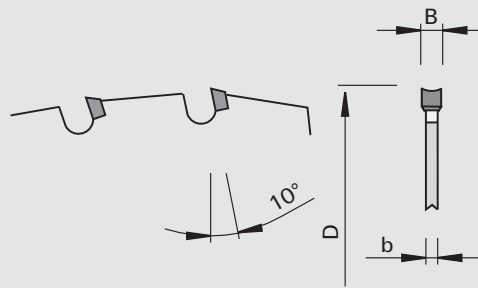
202289

Sizing Saw Blades DP "HR" - nn-System DP flex

Product



Drawing

LEUCO
nn-SYSTEMDP FLEX

Polycrystalline diamond [DP]

NO
WOOD

Machine / Application

- | sizing saws and table saws
- | Vertical panel sizing saws
- | clipping saws
- | for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- | for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design

- | resharpenable up to 2 times
- | small gullets
- | special cutting edge geometry
- | tooth configuration: hollow back tooth "HR"
- | cutting material: DP

Advantages

- | hardly perceivable noise level
- | highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- | reduced cutting pressure thanks to hollow back tooth geometry

Notes


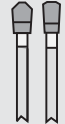
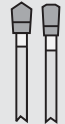



- | it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- | chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade
- | Attention! for these saw blades the thickness of the splitting wedge must range between 2.0 and 2.4 mm
- | included in delivery: splitting wedge must be ordered separately

Ø D	B	b	Ø d	Z	NL	Ident-No.
250	2,5	2.0	30	50	2/7/42 + 2/9/46 + 2/10/60	192440
254	2,5	2.0	15,875	50	2/7/42 + 2/9/46 + 2/10/60	192441
260	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192442
280	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192443
303	2,5	2.0	30	60	2/7/42 + 2/9/46 + 2/10/60	192444
315	2,5	2.0	30	64	2/7/42 + 2/9/46 + 2/10/60	192445
350	2,5	2.0	30	72	2/7/42 + 2/9/46 + 2/10/60	192446
[mm]	[mm]	[mm]	[mm]			




Accessories	B	For Ø D	for machine	Class-No.	PU	Ident-No.
Splitting wedge	2,25	300-350	Altendorf F45	985500	1	192425
Splitting wedge	2,25	240-250	HOLZ-HER Vertikal	985500	1	192429
Splitting wedge	2,25	300-350	Striebig Standard III Control Evolution	985500	1	192430
Splitting wedge	2,25	300-350	Striebig Standard Eco	985500	1	192431
Splitting wedge	2,25	300	Putsch	985500	1	192457
Splitting wedge	2,25	250-350	Martin T60A	985500	1	192535
	[mm]	[mm]				

202180

DIAREX Sizing Saw Blades DP

<p>Product</p> 	<p>Drawing</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> <p>TR-F-FA</p>  </div> <div style="text-align: center;"> <p>DA-F-FA</p>  </div> <div style="text-align: center;"> <p>HR-FA</p>  </div> </div>	 <p>Polycrystalline diamond [DP]</p> 
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<p>Machine / Application</p> <ul style="list-style-type: none"> table saws vertical panel sizing saws for finish cuts in varying materials 	<p>Design</p> <ul style="list-style-type: none"> resharpening area 2.0 mm cutting material: DP in different designs depending on the application 	<p>Advantages</p> <ul style="list-style-type: none"> long edge lives thanks to tooth group with higher number of quality-forming cutting edges less vibration and noise thanks to laser ornaments 	<p>Notes</p>
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 <p>TR-F-FA</p> <ul style="list-style-type: none"> - universal and robust geometry - for melamine-laminated or HPL-laminated wood-based materials as well as composites associated with scoring saw blades - very good suited for mineral materials 	 <p>DA-F-FA</p> <ul style="list-style-type: none"> for finish cuts in melamine-laminated and HPL-laminated wood-based plates associated with scoring saw blades 	 <p>HR-FA</p> <ul style="list-style-type: none"> - excellent cut quality (on top) thanks to pre-scoring effect and reduced cutting pressure - well suited for magnet bond boards - very well suited for thin plates made of CFRP and GFRP
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Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	3,2	2.2	30	48	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192955
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192957
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192960
350	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	192961
400	3,5	2.5	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	193100
303	3,2	2.2	30	70	2/7/42 + 2/9/46 + 2/10/60	DA-F-FA	192959
250	3,2	2.2	30	50	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192956
303	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192958
350	3,2	2.2	30	65	2/7/42 + 2/9/46 + 2/10/60	HR-FA	192962
[mm]	[mm]	[mm]	[mm]				

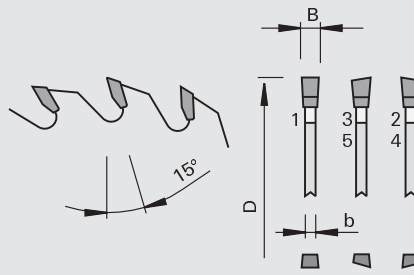
102348

Sizing Saw Blades HW "G5"

Product



Drawing

LEUCO
G5 systemLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- | table saws
- | chop and miter saws
- | for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

- | tooth configuration: G5
- | cutting material: HW HL Board 04 plus

Advantages

- | excellent cutting quality for cross cuts
- | excellent cutting quality thanks to special tooth geometry
- | extremely long edge lives
- | noise-reduction thanks to laser ornaments

Notes

- | pay attention to nmax!!!
- | NL** - Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42

Ø D	B	b	Ø d	Z	NL**	nmax	Ident-No.
200	3,0	2,2	30	65		7630	192789
220	3,0	2,2	30	70		6940	192790
240	3,0	2,2	30	75		6360	192791
250	3,0	2,2	30	80	Combi3	6110	192792
280	3,0	2,2	30	85	Combi3	5450	192793
300	3,0	2,2	30	100	Combi3	5090	192794
303	3,2	2,2	30	100	Combi3	5040	192795
315	3,0	2,2	30	100	Combi3	4850	192801
350	3,0	2,2	30	100	Combi3	4400	192796
380	3,0	2,2	32	120		3340	192802
400	3,0	2,2	30	120	Combi3	3340	192797
450	3,6	2,8	30	130	Combi3	3180	192798
500	3,6	2,8	30	145	Combi3 + 2/10/70	2670	192799
550	4,0	3,2	30	160	Combi3	2780	192803
[mm]	[mm]	[mm]	[mm]			[min-1]	

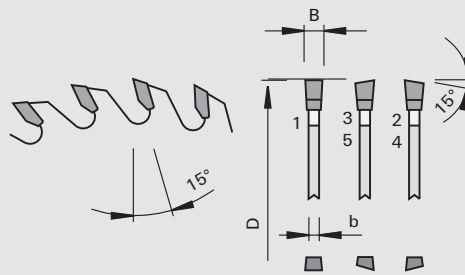
202380

Sizing Saw Blades DP "G5"

Product



Drawing



LEUCO
G5 system

LEUCO
DIA

Polycrystalline diamond [DP]

LOW
noise



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for chip-free sizing cuts as well as clipping and miter cuts in wood-based panels, and plastics (e.g. plastic profiles)

Design

- | resharpening area 3.5 mm
- | tooth configuration: G5

Advantages

- | excellent cutting quality for cross cuts
- | excellent cutting quality thanks to special tooth geometry
- | extremely long edge lives
- | noise-reduction thanks to laser ornaments

Notes

- | pay attention to nmax!!!

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189633 s
350	3,2	2.2	30	100	2/7/42 + 2/9,5/46,5 + 2/10/60	189634 s
[mm]	[mm]	[mm]	[mm]			

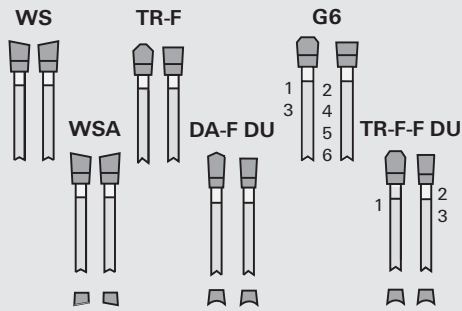
1023...

Sizing Saw Blades HW - LowNoise

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- | table saws
- | vertical panel sizing saws
- | for sizing cuts

Design

- | vibration and noise damping ornaments
- | additional expansion slots
- | cutting material: HL Board 04 plus and HL Board 06

Advantages

- | extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- | for each application case the correct tooth form

Notes

- | Ident-No. 189690: extremely straight steel plate for Striebig panel sizing saws with scoring device
- | NL** - Combi2 = 2/7/42 + 2/9/46 + 2/10/60
- | NL** - Combi3 = 2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60



WS

- HW HL Board 04 plus for raw and laminated panels
- HL Board 06 for solid woods in combination with scoring saw blade



TR-F

- for raw and laminated panels
- 10° hook angle in combination with scoring saw blade
- 5° hook angle improved bottom edge even without scoring saw blade



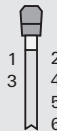
DA-F DU

- 10° hook angle for raw and laminated panels
- 6° hook angle for sizing cuts in plastic and solid wood profile ledges
- good quality of bottom edge even without scoring saw blade
- excellent cutting quality



WSA

- universal application
- in combination with scoring saw blade
- diagonal ground front for improvement of cutting quality



G6

- for raw and laminated panels
- in combination with scoring saw blade
- less cutting forces and very long edge lives thanks to innovative tooth group configuration



TR-F-F DU

- for raw and laminated panels
- good quality of bottom edge even without scoring saw blade
- longer edge life thanks to innovative tooth group configuration and cutting material HL Board 03

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom-etry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	36	10	2/7/42	WS	HL Board 06	102328	189664
250	3,2	2.2	30	40	10	Combi2	WS	HL Board 06	102328	189665
250	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189666
250	3,2	2.2	60	40	10		WS	HL Board 06	102328	189667
300	3,2	2.2	30	48	10	Combi2	WS	HL Board 06	102328	189668
300	3,2	2.2	30	60	10	Combi2	WS	HL Board 06	102328	189669
300	3,2	2.2	60	48	10		WS	HL Board 06	102328	188185 &
350	3,5	2.5	30	54	10	Combi2	WS	HL Board 06	102328	189670
350	3,5	2.5	30	72	10	Combi2	WS	HL Board 06	102328	189671
400	3,5	2.5	30	60	10	Combi2	WS	HL Board 06	102328	189672
400	3,5	2.5	30	84	10	Combi2	WS	HL Board 06	102328	189673
[mm]	[mm]	[mm]	[mm]		[°]					

Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	64	10	2/7/42	WS	HL Board 04 plus	102328	192763
250	3,2	2.2	30	60	10	Combi2	WS	HL Board 04 plus	102328	192764
250	3,2	2.2	30	80	10	Combi2	WS	HL Board 04 plus	102328	192765
300	3,2	2.2	30	72	10	Combi2	WS	HL Board 04 plus	102328	192766 \$
300	3,2	2.2	30	96	10	Combi2	WS	HL Board 04 plus	102328	192767 \$
350	3,5	2.5	30	84	10	Combi2	WS	HL Board 04 plus	102328	192768
350	3,5	2.5	30	108	10	Combi2	WS	HL Board 04 plus	102328	192769
350	3,5	2.5	35	84	10	Combi2	WS	HL Board 04 plus	102328	192770 &
400	3,5	2.5	30	96	10	Combi2	WS	HL Board 04 plus	102328	192771
400	3,5	2.5	30	120	10	Combi2	WS	HL Board 04 plus	102328	192772
450	4,0	2.8	30	132	10	Combi2	WS	HL Board 04 plus	102328	192773
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
300	3,2	2.2	30	96	10	Combi2	WSA	HL Board 04 plus	102328	192774
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	64	10	2/7/42	TR-F	HL Board 04 plus	102378	192775
250	3,2	2.2	30	60	10	Combi2	TR-F	HL Board 04 plus	102378	192776
250	3,2	2.2	30	80	5	Combi3	TR-F	HL Board 04 plus	102378	193196
250	3,2	2.2	30	80	10	Combi2	TR-F	HL Board 04 plus	102378	192777
300	3,2	2.2	30	72	10	Combi2	TR-F	HL Board 04 plus	102378	192778
300	3,2	2.2	30	96	5	Combi3	TR-F	HL Board 04 plus	102378	192779 \$
300	3,2	2.2	30	96	10	Combi2	TR-F	HL Board 04 plus	102378	192780 \$
350	3,5	2.5	30	84	10	Combi2	TR-F	HL Board 04 plus	102378	192781
350	3,5	2.5	30	108	10	Combi2	TR-F	HL Board 04 plus	102378	192782
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
250	3,2	2.2	30	60	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192785 &
250	3,2	2.2	30	80	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192786 &
300	3,2	2.2	30	72	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192787 &
300	3,2	2.2	30	96	10	Combi2	TR-F-FA	HL Board 04 plus	102378	192788 &
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
300	3,2	2.2	30	96	5	Combi3	G6	HL Board 04 plus	102378	192783
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2.2	30	42	10	2/7/42	DA-F DU	HL Board 06	102338	189688
250	3,2	2.2	30	48	10	Combi2	DA-F DU	HL Board 06	102338	189689 \$
303	3,2	2.2	30	60	10	Combi2	DA-F DU	HL Board 06	102338	189690
303	3,2	2.2	30	60	10	Combi2	DA-F DU	HL Board 06	102338	189617 \$
350	3,5	2.5	30	72	10	Combi2	DA-F DU	HL Board 06	102338	189691
400	3,5	2.5	30	84	10	Combi2	DA-F DU	HL Board 06	102338	189692
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
250	3,2	2.2	30	48	-6	Combi2	DA-F DU	HL Board 06	102338	189693
303	3,2	2.2	30	60	-6	Combi2	DA-F DU	HL Board 06	102338	189694
350	3,5	2.5	30	72	-6	Combi2	DA-F DU	HL Board 06	102338	189695
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL**	Tooth geom- etry	LEUCODUR	Class-No.	Ident-No.
303	3,2	2.2	30	60	10	Combi2	TR-F-F DU	HL Board 03	102338	189842
[mm]	[mm]	[mm]	[mm]		[°]					

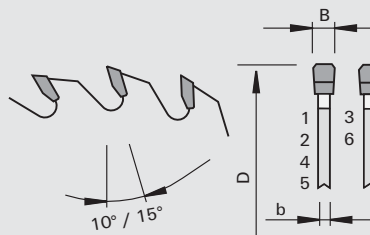
104248

Panel Sizing Saw Blades HW - Q-Cut "G6"

Product



Drawing



LEUCO
topline

Q-CUT G6

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

panel sizing saws
for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 80 mm cutting height

Design

vibration and noise damping ornaments
additional expansion slots
up to ØD=370, 10 degree hook angle
from ØD=380, 15 degree hook angle
tooth configuration: G6
cutting material: HW HL Board 04 plus

Advantages

for highest performance demands
impressive cutting quality thanks to exact and precise cuts
reduced cutting pressure and optimized cutting geometry G6
extremely low-noise and smooth running thanks to reinforced body and vibration and noise damping ornaments
clearly increased edge life thanks to improved HW grade

Notes

projection: min 20 - 25 mm
NL** - Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
NL** - Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
NL** - Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
280	3,2	2.2	30	60	Combi3 + 2/13/94	Panhans EURO 5	193136
300	4,4	3.3	60	72	Combi7	Homag (Holzma) HPP 230	193137
300	4,4	3.0	65	60	2/9/110	Selco EB 70	193138
300	4,4	3.0	75	60	2/9/110	Holzma CH03	193139 &
305	4,4	3.0	30	60	Combi3 + 2/13/94	Mayer, Panhans	193140
308	3,2	2.4	60	96	Combi7	Homag HPS 320	193141
320	4,4	3.3	30	60	Combi3 + 2/13/94	Mayer / Format 4	193142
320	4,4	3.3	65	60	2/9/110	Biesse, Selco EB 80	193143
330	4,4	3.3	50	60	8/13/80	Giben	193144 s
350	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193145
350	4,4	3.3	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193146
350	4,4	3.3	50	72	8/13/80	Giben Smart	193147 &
350	4,4	3.3	60	72	Combi7	Homag (Holzma) 72, HPP 350	193148
350	4,4	3.3	75	72		Homag Sawtech, Homag (Holzma) 250	193149
355	4,4	3.3	75	72		Giben	193150
355	4,4	3.3	80	72	4/8,5/100 + 2/7/110 + 2/14/110	Gabbiani PRIMA, SCM ALPHA	193152
360	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling	193153
360	4,4	3.3	75	72	4/15/105	Giben	193154 s
370	4,4	3.3	30	72	Combi3 + 2/13/94	Schelling FM	193155
380	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193156
380	4,4	3.3	50	72	4/13/80	Giben Onyx	193157
380	4,4	3.3	60	72	Combi7	Homag (Holzma)	193158
380	4,8	3.6	60	72	Combi7	Homag (Holzma)	193159
380	4,4	3.3	80	72	Combi5	SCM, Selco	193188
380	4,8	3.6	80	72	Combi5	SCM, Selco	193189
400	4,25	3.3	30	72	Combi3 + 2/13/94	Scheer	193160 &
400	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER, Irion, Mayer, Scheer, Schelling	193161
400	4,4	3.3	60	72	Combi7	Nanxing	193162 &
400	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	193163
400	4,4	3.3	80	72	Combi5	Gabbiani CLASS, SCM DELTA, Selco WN / EB	193164
430	4,4	3.3	30	72	Combi3 + 2/13/94	HOLZ-HER	193166
430	4,4	3.3	75	72	4/15/105 + 2/7/110	Giben Prismatic 2 old	193167
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL**		Ident-No.
430	4,4	3,3	80	72	Combi5	Selco WN	193168
430	4,8	3,6	70	72	4/11/130	Selco WN	193169
450	4,4	3,3	30	72	Combi3 + 2/13/94	Irion, Schelling	193170
450	4,4	3,3	75	72	2/7/110	Giben	193171
450	4,4	3,3	80	72	Combi5	Gabbiani ELITE	193172 &
450	4,65	3,6	30	72	Combi3 + 2/13/94	Scheer	193173 &
450	4,8	3,6	30	72	Combi3 + 2/13/94	Scheer	193174
450	4,8	3,6	60	72	Combi7	Homag (Holzma)	193175
450	4,8	3,6	80	72	Combi5	Selco WN	193176 &
460	4,4	3,3	30	72	Combi3 + 2/13/94	Schelling FL, FH6	193177
470	4,4	3,3	75	72	4/15/105	Giben	193178 s
470	4,8	3,6	70	72	4/11/130	Selco WN	193179 s
480	4,4	3,3	30	72	Combi3 + 2/13/94	Schelling FH6 from 2016	193180
480	4,8	3,6	60	72	Combi7	Homag (Holzma)	193181
480	4,8	3,6	70	72	4/11/130	Selco Series 750	193183 &
480	4,8	3,6	80	72	Combi5	Selco WN	193184
500	4,8	3,6	60	72	Combi7	Homag (Holzma) Typ 22	193185 s
520	4,8	3,6	30	72	Combi3 + 2/13/94	Schelling FH8	193186
520	4,8	3,6	60	72	Combi7	Homag (Holzma) 23 / 550	193187
520	4,8	3,6	70	72	4/11/130	Selco WN	193182
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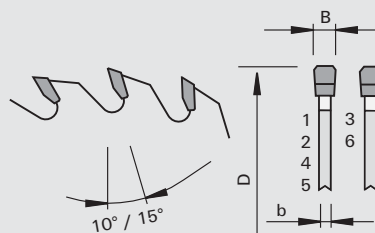
104249

Panel Sizing Saw Blades HW - Q-Cut "G6" - nn-System

Product



Drawing



LEUCO
nnsystem



Tungsten Carbide [HW]



Machine / Application

- panel sizing saws
- for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 80 mm cutting height

Design

- special nn-System gullet geometry
- tooth configuration: G6
- cutting material: HW HL Board 04 plus

Advantages

- especially low noise level
- noise reduction by up to approx. 6 dB(A) when idling
- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts without chippings
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- clearly increased edge life thanks to improved HW grade

Notes

- projection: min. 20 - 25 mm max. 40 mm
- NL** - Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
310	4,4	3,2	60	72	Combi7	Homag (Holzma BR200)	193190
350	4,4	3,2	60	72	Combi7	Homag (Holzma 72, 350, HPP 350)	193191
380	4,4	3,2	60	72	Combi7	Homag (Holzma)	193192
380	4,8	3,5	60	72	Combi7	Homag (Holzma 82, HPP 82, HPP 83, HPL 380)	193193
450	4,8	3,5	60	72	Combi7	Homag (Holzma 11510)	193194
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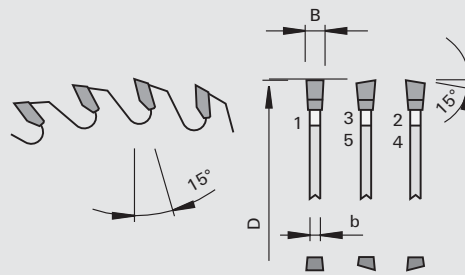
104258

Panel Sizing Saw Blades HW - Q-Cut "G5"

Product



Drawing



LEUCO
G5 system

Q-CUT G5

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

- horizontal panel sizing saws
- for sizing and finish cuts in wood core plywood, plywood boards, veneered or paper-laminated wood-based panels and honeycomb panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: G5
- cutting material: HW HL Board 04 plus

Advantages

- very low cutting pressure and small power consumption thanks to optimized cutting geometry
- excellent cutting quality in wood-based materials containing fibers
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes

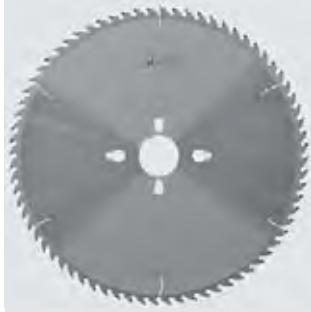
- Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8.4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,0	3.2	30	80	Combi3	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192813
350	4,0	3.2	60	80	Combi7	Homag (Holzma)	192814
380	4,0	3.2	60	80	Combi7	Homag (Holzma)	192815
400	4,0	3.2	30	85	Combi3 + 2/13/94		192816
430	4,0	3.2	30	85	Combi3 + 2/13/94		192817
430	4,0	3.2	80	90	Combi5	Selco	192818
450	4,0	3.2	60	90	Combi7	Homag (Holzma)	192819
460	4,0	3.2	30	90	2/13/94	Schelling	192820
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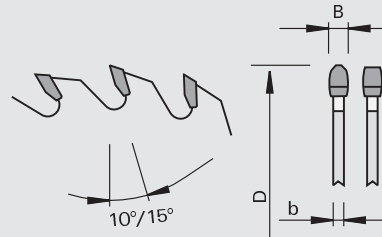
104278

Panel Sizing Saw Blades HW - Q-Cut "TR-F K"

Product



Drawing



Tungsten Carbide [HW]



Machine / Application

- | horizontal panel sizing saws
- | for micro cuts in new materials (special surfaces) and plastics

Design

- | vibration and noise damping ornaments
- | additional expansion slots
- | tooth configuration: TR-F K
- | cutting material: HW HL Board 04 plus

Advantages

- | excellent cutting quality in "anti fingerprint" materials and for conventional plastics
- | no scoring on the cutting surface due to convex tooth sides
- | no flares on the surface of sensible materials

Notes

- | Attention: when assigning the appropriate scoring saw blades, please take into account the cutting width reduction of 4 mm!
- | NL** - Combi3 = 2/10/60 + 2/9/46 + 2/9.5/46.5 + 2/7/42
- | NL** - Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
350	4,0	3.2	30	72	Combi3	Schelling, SCM, Panhans, Mayer; HOLZ-HER	192974
350	4,0	3.2	60	72	Combi7	Homag (Holzma)	192975
380	4,0	3.2	60	72	Combi7	Homag (Holzma)	192976
400	4,0	3.2	30	72	Combi3 + 2/13/94	Schelling	192977
450	4,0	3.2	60	72	Combi7	Homag (Holzma)	192978
460	4,0	3.2	30	72	2/13/94	Schelling	192979
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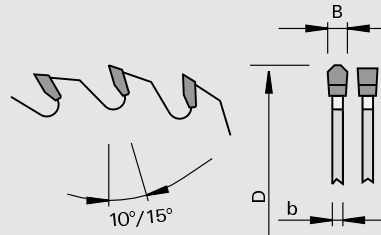
104378

Panel Sizing Saw Blades HW - U-Cut "TR-F"

Product



Drawing



LEUCO
topline

U-CUT TR-F

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- panel sizing saws
- for sizing cuts in plastic-laminated panels

Design

- up to ØD=360, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board O4 plus

Advantages

- improved cutting quality thanks to optimized cutting geometry
- noise-reduction thanks to laser ornaments

Notes


- specifically for plastic-laminated panels and plywood in single sheets and stacks
- NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,4	2.8	30	60	Combi3 + 2/13/94	Panhans Euro P8	192901
300	4,4	3.0	75	72	2/9/110	Homag Espana	192902
300	4,4	3.2	80	72	Combi5	Gabbiani, SCM	193111
305	3,2	2.2	30	60	Combi3 + 2/13/94	Scheer FM 16	192903
305	4,4	2.8	30	60	Combi3 + 2/13/94	Mayer, Panhans	192904
305	4,4	2.8	60	60		Hoggers	192905
320	4,4	3.2	65	60	2/9/110	Biesse, Selco EB 80	192906
320	4,4	3.2	75	72	3/13/95	Giben Smart	192907
320	4,4	3.2	80	60	Combi5	Gabbiani, SCM	193099
320	4,4	3.2	80	72	Combi5	SCM	193110
350	4,4	3.0	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192908 \$
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	192909
350	4,4	3.0	75	60		Giben MK Gamma	192910
355	4,4	3.2	65	72	2/9/110	Selco EB 95 / EB 100	193098
355	4,4	3.0	75	60		Giben Trend, Homag CH06+10	192912
355	4,4	3.0	75	72	4/15/105	Giben	192911
355	4,4	3.0	80	72	Combi5	Gabbiani PRIMA, SCM ALPHA, S.M.A., hoggers	192913
360	4,4	3.2	65	72	2/9/110	Selco	192914
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	192915
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	192916 \$
380	4,4	3.2	80	72	Combi5	Gabbiani, SCM, Selco	192969
380	4,8	3.5	80	72	Combi5	Gabbiani, SCM, Selco	192993
400	4,25	3.2	30	72	Combi3 + 2/13/94	Scheer	192917
400	4,4	3.2	30	96	Combi3 + 2/13/94		192918
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192919
400	4,4	3.2	60	72	Combi7	Anthon	192920
400	4,8	3.5	60	72	Combi7	Homag (Holzma) Typ 01	192923
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	192921 \$
400	4,4	3.2	80	72	Combi5	Selco WN / EB, S.M.A., Irion	192922
420	4,8	3.5	60	72	Combi7	Homag (Holzma)	192924
430	4,4	3.2	30	72	Combi3		192925
430	4,4	3.2	60	72	Combi7		192926
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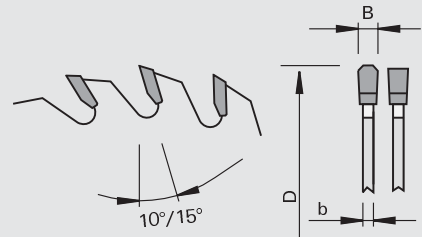
Ø D	B	b	Ø d	Z	NL**	Ident-No.	
430	4,4	3,2	75	96	4/15/105 + 2/7/110	Giben Prismatic 2 old	192927
430	4,4	3,2	80	72	Combi5	Selco WN	192928
450	4,4	3,2	30	72	Combi3 + 2/13/94	Irion, Schelling	192929
450	4,8	3,5	60	72	Combi7	Homag (Holzma)	192931 \$
450	4,4	3,2	80	72	Combi5	S.M.A., Irion	192930
450	4,8	3,5	80	72	Combi5	Selco WN	192932
460	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling FL, FH 6	192933
470	4,8	3,5	70	72	4/11/130	Selco WN	192936
470	4,4	3,2	75	96	4/15/105	Giben Prismatic 3	192934
470	4,4	3,2	75	72	4/15/105	Giben	192935
480	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling FL	192937
480	4,8	3,5	60	72	Combi7	Homag (Holzma) 530	192938
480	4,8	3,5	80	72	Combi5	Selco WN	192939
500	4,4	3,2	30	60	Combi3 + 2/13/94	Schelling, Irion	192940
500	4,8	3,5	60	72	Combi7	Homag (Holzma) Typ 22	192941
520	4,8	3,5	30	72	Combi3 + 2/13/94	Schelling FH 8	192942
520	4,8	3,5	60	72	Combi7	Homag (Holzma) Typ 23	192943
560	4,8	3,5	30	72	2/13/94	Schelling	193104
600	5,8	4,0	60	72	Combi7	Homag (Holzma) Typ 42	192944
650	6,2	4,0	40	72		Schelling	192945
[mm]	[mm]	[mm]	[mm]				



104378
Panel Sizing Saw Blades HW - U-Cut max "TR-F"

Product




Drawing



Tungsten Carbide [HW]



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> panel sizing saws for sizing cuts in plastic-laminated panels 	<ul style="list-style-type: none"> up to ØD=360, 10 degree hook angle from ØD=380, 15 degree hook angle tooth configuration: triple chip / flat "TR-F" cutting material: HW HL Board 04 plus 	<ul style="list-style-type: none"> higher edge life thanks to up to 6 times more resharpenings than U-Cut TR-F noise reduction thanks to laser ornaments 	<ul style="list-style-type: none"> specifically for plastic-laminated panels and plywood in single sheets and stacks NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**	Ident-No.	
350	4,4	3,2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, HOLZ-HER	193120 s
350	4,4	3,2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193121
350	4,4	3,2	75	72		Giben MK Gamma	193122
380	4,4	3,2	60	72	Combi7	Homag (Holzma)	193123
380	4,8	3,5	60	72	Combi7	Homag (Holzma)	193124
380	4,4	3,2	80	72	Combi5	Gabbiani, SCM, Selco	193125 s
380	4,8	3,5	80	72	Combi5	Gabbiani, SCM, Selco	193126 s
400	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling Mayer, Irion, Scheer, HOLZ-HER	193127 s
450	4,4	3,2	30	72	Combi3 + 2/13/94	Irion, Schelling	193128 s
450	4,8	3,5	60	72	Combi7	Homag (Holzma)	193129
470	4,8	3,5	70	72	2/11/130	Selco WN	193132
470	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben	193130 s
470	4,8	3,5	75	72	4/15/105 + 2/7/110	Giben	193131 s
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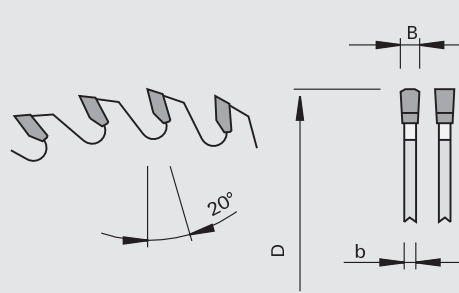
104270

Panel Sizing Saw Blades HW - U-Cut speed "TR-F"

Product



Drawing



LEUCO
topline

U-CUT SPEED

Tungsten Carbide [HW]

LOW NOISE

Machine / Application

horizontal panel sizing saws
for stack cuts in raw and plastic-laminated panels

Design

vibration and noise damping ornaments
additional expansion slots
tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board O4 plus

Advantages

for highest performance demands
reduced cutting pressure and power consumption thanks to optimized cutting geometry
extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
clearly increased edge life thanks to improved HW grade

Notes

stack height: Ident-No. 192629 up to max. 190 mm / Ident-No. 192631 up to max. 210 mm / Ident-No. 192633 up to max. 215 mm
recommended projection: 20-30 mm
NL** - Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
520	4,8	3,5	30	60	2/13/94	Schelling	192616
520	4,8	3,5	60	60	Combi7	Homag (Holzma) Typ 23	192617
530	5,0	3,5	30	60		Schelling	192618
530	5,8	4,0	60	60	Combi7		192619
565	4,8	3,5	80	60	2/8/110		192620
565	5,0	3,5	100	60		Giben	192621
570	4,8	3,5	60	60	Combi7	Homag (Holzma)	192622
575	5,8	4,0	60	60	Combi7	Homag (Holzma)	192664
600	5,8	4,0	60	60	Combi7	Homag (Holzma) Typ 42	192624
600	5,8	4,0	80	60	2/11/115 + 2/19/120		192625
620	6,2	4,0	80	60	4/15/143		192626
650	6,2	4,0	40	60		Schelling	192627 s
670	6,0	4,4	60	48	Combi7	Homag (Holzma) 66 (Tandem)	192628
680	6,2	4,2	80	60	2/11/130		192630
680	6,4	4,4	40	60	2/17/140 + 2/13/140	Schelling	192629
700	6,4	4,4	80	60	2/17/110	Anthon	192631
700	6,8	4,4	80	60	2/17/110		192632
720	6,4	4,4	40	60	2/13/114 + 2/13/140	Schelling	192633
730	6,4	4,4	60	60	Combi7	Homag (Holzma) 66 (Tandem)	192635
730	6,4	4,4	80	60	2/17/110	Anthon LNC	192634
750	6,5	4,6	40	72	2/13/140 + 2/13/114		192636
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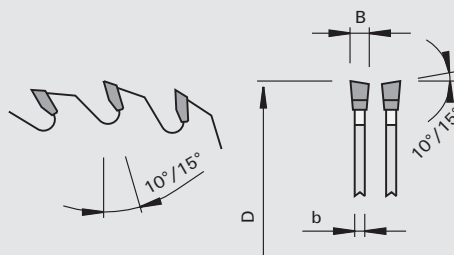
104320

Panel Sizing Saw Blades HW - U-Cut "WS"

Product



Drawing



LEUCO
topline



Tungsten Carbide [HW]

Machine / Application

- | panel sizing saws
- | double-end tenoners
- | for sizing cuts in raw and veneered particleboard, hardboard, MDF panels and high-density plywood in single sheets and stacks

Design

- | up to ØD=355, 10 degree hook angle and 15 degree corner angle
- | from ØD=400, 15 degree hook angle and 10 degree corner angle
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 04 plus

Advantages

Notes

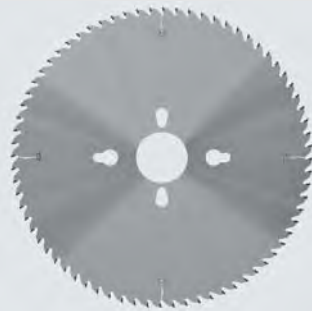
- | for main/scoring saw combinations see specifications (appendix)
- | on double-end tenoners in combination with large hoppers
- | NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- | NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- | NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Ø D	B	b	Ø d	Z	NL**		Ident-No.
305	4,4	2,8	30	48	Combi3 + 2/13/94	Mayer, Panhans	192821
305	4,4	2,8	60	48	Combi7		192822
320	4,4	3,2	30	50	Combi3	Mayer, Format 4	193215
350	4,4	3,0	30	54	Combi3 + 2/13/94	SCM, Panhans, Schelling	192823
350	4,4	3,0	60	54	Combi7	Holzma	193095
355	4,4	3,0	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion	192824
355	4,4	3,0	60	54	Combi7	Homag (Holzma)	192825
355	4,4	3,0	60	72	Combi7		192826
355	4,4	3,0	80	54	Combi5	S.M.A.	192827
355	4,4	3,0	80	72	Combi5	S.M.A.	192828
380	4,8	3,5	60	54	Combi7	S.M.A., Homag (Holzma)	192829
400	4,4	3,2	80	96	Combi5		192830
400	4,6	3,2	30	60	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192831
400	4,6	3,2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, HOLZ-HER	192832
400	4,6	3,2	80	72	Combi5	S.M.A.	192834 &
430	4,6	3,2	75	72	4/15/105	Giben Prismatic 2	192835
430	4,6	3,2	80	72	Combi5	S.M.A.	192836
450	4,6	3,2	30	54	Combi3 + 2/13/94	Panhans, Irion, Schelling	192837
450	4,6	3,2	80	72	Combi5	S.M.A., Irion	192838
500	4,6	3,2	30	60	Combi3 + 2/13/94	Schelling, Irion	192839
500	4,6	3,2	80	60	Combi5	Teutomatic	192840 &
500	4,8	3,5	60	60	Combi7	Homag (Holzma)	192999
550	5,0	3,5	80	60	Combi5	Teutomatic	192841
600	6,0	4,0	60	60	Combi7	Homag (Holzma)	192842
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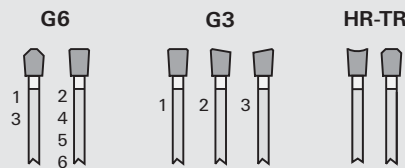
204380

Panel Sizing Saw Blades DP

Product



Drawing



Polycrystalline diamond [DP]

Machine / Application

| horizontal panel sizing saws

Design

- | vibration-optimized tool body design
- | LEUCODIA tipping quality
- | LEUCO topcoat: smooth surfaces for the reduction of deposits and adhesions on the cutting edges
- | G6: for finish cuts in unfinished and plastic-coated composite wood boards individually or in packages up to 80 mm
- | G3: for finish cuts in fibrous composite wood boards such as wood core plywood, veneer plywood and lightweight panels.
- | HR-TR: for finish cuts in HPL and solid core materials (only available with topcoat)

Advantages

- | extremely good vibration damping due to laser ornaments filled with damping material
- | the right tooth geometry for every application
- | short delivery times for "s" articles (without topcoat)
- | increased edge lives thanks to topcoat coating

Notes

- | NL**- Combi3 = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42
- | NL**- Combi5 = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120
- | NL**- Combi7 = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Tooth configuration G6

Ø D	B	b	Ø d	Z	NL**		Ident-No.
300	4,4	3.2	60	72	Combi7	Homag (Holzma) HPP 230	193000 s
350	4,4	3.2	75	72		Homag Sawtec, Homag (Holzma) 250	193002
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193004
350	4,4	3.2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, Scheer	193006
350	4,25	3.2	30	72	Combi3 + 2/13/94	Scheer	193008 s
355	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben	193010 s
355	4,4	3.2	80	72	Combi5	Selco EB 90	193012 s
380	4,4	3.2	60	72	Combi7	Homag (Holzma)	193014
380	4,8	3.5	60	72	Combi7	Homag (Holzma)	193016
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer	193018
400	4,4	3.2	60	72	Combi7	Anthon	193020 s
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben, Homag CH08+12	193022 s
400	4,4	3.2	80	72	Combi5	Selco WN / EB	193024 s
430	4,4	3.2	60	72	Combi7	Anthon	193026 s
430	4,4	3.2	80	72	Combi5	Selco WN	193028 s
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling	193030 s
450	4,4	3.2	80	72	Combi5	Gabbiani ELITE	193032 s
450	4,8	3.5	60	72	Combi7	Homag (Holzma)	193034
450	4,8	3.5	80	72	Combi5	Selco WN	193036 s
[mm]	[mm]	[mm]	[mm]				

Tooth configuration G3

Ø D	B	b	Ø d	Z	NL**	Ident-No.	
300	4,4	3,2	60	72	Combi7	Homag (Holzma) HPP 230	193001 s
350	4,4	3,2	75	72		Homag Sawtec, Homag (Holzma) 250	193003 s
350	4,4	3,2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193005 s
350	4,4	3,2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, Scheer	193007 s
350	4,25	3,2	30	72	Combi3 + 2/13/94	Scheer	193009 s
355	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben	193011 s
355	4,4	3,2	80	72	Combi5	Selco EB 90	193013 s
380	4,4	3,2	60	72	Combi7	Homag (Holzma)	193015 s
380	4,8	3,5	60	72	Combi7	Homag (Holzma)	193017 s
400	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer	193019 s
400	4,4	3,2	60	72	Combi7	Anthon	193021 s
400	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben, Homag CH08+12	193023 s
400	4,4	3,2	80	72	Combi5	Selco WN / EB	193025 s
430	4,4	3,2	60	72	Combi7	Anthon	193027 s
430	4,4	3,2	80	72	Combi5	Selco WN	193029 s
450	4,4	3,2	30	72	Combi3 + 2/13/94	Irion, Schelling	193031 s
450	4,4	3,2	80	72	Combi5	Gabbiani ELITE	193033 s
450	4,8	3,5	60	72	Combi7	Homag (Holzma)	193035 s
450	4,8	3,5	80	72	Combi5	Selco WN	193037 s
[mm]	[mm]	[mm]	[mm]				

Tooth configuration G6 - topcoat

Ø D	B	b	Ø d	Z	NL**	Ident-No.	
300	4,4	3,2	60	72	Combi7	Homag (Holzma) HPP 230	193038 s
350	4,4	3,2	75	72		Homag Sawtec, Homag (Holzma) 250	193041 s
350	4,4	3,2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193044 s
350	4,4	3,2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, Scheer	193047 s
350	4,25	3,2	30	72	Combi3 + 2/13/94	Scheer	193050 s
355	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben	193053 s
355	4,4	3,2	80	72	Combi5	Selco EB 90	193056 s
380	4,4	3,2	60	72	Combi7	Homag (Holzma)	193059 s
380	4,8	3,5	60	72	Combi7	Homag (Holzma)	193062 s
400	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer	193065 s
400	4,4	3,2	60	72	Combi7	Anthon	193068 s
400	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben, Homag CH08+12	193071 s
400	4,4	3,2	80	72	Combi5	Selco WN / EB	193074 s
430	4,4	3,2	60	72	Combi7	Anthon	193077 s
430	4,4	3,2	80	72	Combi5	Selco WN	193080 s
450	4,4	3,2	30	72	Combi3 + 2/13/94	Irion, Schelling	193083 s
450	4,4	3,2	80	72	Combi5	Gabbiani ELITE	193086 s
450	4,8	3,5	60	72	Combi7	Homag (Holzma)	193089 s
450	4,8	3,5	80	72	Combi5	Selco WN	193092 s
[mm]	[mm]	[mm]	[mm]				

Tooth configuration G3 - topcoat

Ø D	B	b	Ø d	Z	NL**	Ident-No.	
300	4,4	3,2	60	72	Combi7	Homag (Holzma) HPP 230	193039 s
350	4,4	3,2	75	72		Homag Sawtec, Homag (Holzma) 250	193042 s
350	4,4	3,2	60	72	Combi7	Homag (Holzma) 72, HPP 350	193045 s
350	4,4	3,2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, Scheer	193048 s
350	4,25	3,2	30	72	Combi3 + 2/13/94	Scheer	193051 s
355	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben	193054 s
355	4,4	3,2	80	72	Combi5	Selco EB 90	193057 s
380	4,4	3,2	60	72	Combi7	Homag (Holzma)	193060 s
380	4,8	3,5	60	72	Combi7	Homag (Holzma)	193063 s
400	4,4	3,2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer	193066 s
400	4,4	3,2	60	72	Combi7	Anthon	193069 s
400	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben, Homag CH08+12	193072 s
400	4,4	3,2	80	72	Combi5	Selco WN / EB	193075 s
430	4,4	3,2	60	72	Combi7	Anthon	193078 s
[mm]	[mm]	[mm]	[mm]				

Tooth configuration G3 - topcoat


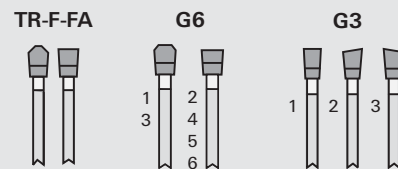



Ø D	B	b	Ø d	Z	NL**	Ident-No.
430	4,4	3.2	80	72	Combi5	Selco WN 193081 s
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling 193084 s
450	4,4	3.2	80	72	Combi5	Gabbiani ELITE 193087 s
450	4,8	3.5	60	72	Combi7	Homag (Holzma) 193090 s
450	4,8	3.5	80	72	Combi5	Selco WN 193093 s
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Tooth configuration HR-TR - topcoat

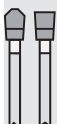
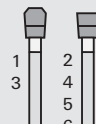
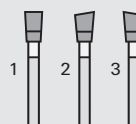
Ø D	B	b	Ø d	Z	NL**	Ident-No.
300	4,4	3.2	60	72	Combi7	Homag (Holzma) HPP 230 193040 s
350	4,4	3.2	75	72		Homag Sawtec, Homag (Holzma) 250 193043 s
350	4,4	3.2	60	72	Combi7	Homag (Holzma) 72, HPP 350 193046 s
350	4,4	3.2	30	72	Combi3 + 2/13/94	SCM, Panhans, Mayer, Schelling, Scheer 193049 s
350	4,25	3.2	30	72	Combi3 + 2/13/94	Scheer 193052 s
355	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben 193055 s
355	4,4	3.2	80	72	Combi5	Selco EB 90 193058 s
380	4,4	3.2	60	72	Combi7	Homag (Holzma) 193061 s
380	4,8	3.5	60	72	Combi7	Homag (Holzma) 193064 s
400	4,4	3.2	30	72	Combi3 + 2/13/94	Schelling, Mayer, Irion, Scheer 193067 s
400	4,4	3.2	60	72	Combi7	Anthon 193070 s
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben, Homag CH08+12 193073 s
400	4,4	3.2	80	72	Combi5	Selco WN / EB 193076 s
430	4,4	3.2	60	72	Combi7	Anthon 193079 s
430	4,4	3.2	80	72	Combi5	Selco WN 193082 s
450	4,4	3.2	30	72	Combi3 + 2/13/94	Irion, Schelling 193085 s
450	4,4	3.2	80	72	Combi5	Gabbiani ELITE 193088 s
450	4,8	3.5	60	72	Combi7	Homag (Holzma) 193091 s
450	4,8	3.5	80	72	Combi5	Selco WN 193094 s
[mm]	[mm]	[mm]	[mm]			

2043..

Panel Sizing Saw Blades DP - nn-System

Product 	Drawing 	 DP PANEL  Polycrystalline diamond [DP] 
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Machine / Application panel sizing saws for sizing cuts in raw and plastic-laminated panels	Design special NoNoise gullet geometry diamond cutting edges with polished design LEUCODIA tipping quality	Advantages especially low noise level noise reduction by approx. 6 dB(A) when idling for each application case the correct tooth form short delivery times interesting scaled prices	Notes all flat and alternate bevel teeth with protection chamfer further dimensions and tooth forms on request
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 TR-F-FA Single and book cuts, focus on universality	 G6 Improved edge live compared to TR-F-FA, reduced motor power	 G3 Reduced cutting pressure for veneered boards, plywood boards and honeycomb panels
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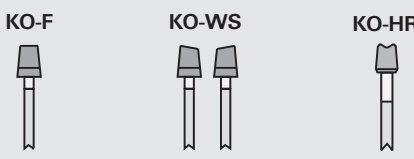


Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
308	3,2	2,4	60	96		TR-F-FA	Homag HPS 320	193103
350	4,4	3,2	75	72		TR-F-FA	Homag Sawtech, Holzma 250	192319 s
350	4,4	3,2	75	72		G6	Homag Sawtech, Holzma 250	192320 s
350	4,4	3,2	75	72		G3	Homag Sawtech, Holzma 250	192321 s
350	4,4	3,2	60	72	2/14/100	TR-F-FA	Holzma 72, HPP350	192322 s
350	4,4	3,2	60	72	2/14/100	G6	Holzma 72, HPP350	192323 s
350	4,4	3,2	60	72	2/14/100	G3	Holzma 72, HPP350	192324 s
350	4,4	3,2	50	72	8/12,5/80	TR-F-FA	Giben Smart	192325 s
350	4,4	3,2	50	72	8/12,5/80	G6	Giben Smart	192326 s
350	4,4	3,2	50	72	8/12,5/80	G3	Giben Smart	192327 s
350	4,4	3,2	30	72	2/10/60	TR-F-FA	SCM, Panhans, Mayer, Schelling, Scheer	192328
350	4,4	3,2	30	72	2/10/60	G6	SCM, Panhans, Mayer, Schelling, Scheer	192329 s
350	4,4	3,2	30	72	2/10/60	G3	SCM, Panhans, Mayer, Schelling, Scheer	192330 s
350	4,25	3,2	30	72	2/10/60	TR-F-FA	Scheer	192331 s
350	4,25	3,2	30	72	2/10/60	G6	Scheer	192332 s
350	4,25	3,2	30	72	2/10/60	G3	Scheer	192333 s
355	4,4	3,2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco EB 90	192334 s
355	4,4	3,2	80	72	4/19/120 + 2/8,4/130	G6	Selco EB 90	192335 s
355	4,4	3,2	80	72	4/19/120 + 2/8,4/130	G3	Selco EB 90	192336 s
355	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani PRIMA, SCM ALPHA	192337 s
355	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani PRIMA, SCM ALPHA	192338 s
355	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani PRIMA, SCM ALPHA	192339 s
355	4,4	3,2	75	72	4/15/105	TR-F-FA	Giben	192340 s
355	4,4	3,2	75	72	4/15/105	G6	Giben	192341 s
355	4,4	3,2	75	72	4/15/105	G3	Giben	192342 s
[mm]	[mm]	[mm]	[mm]					

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
380	4,8	3,5	60	72	2/14/100 + 2/14/125	TR-F-FA	Holzma	192343
380	4,8	3,5	60	72	2/14/100 + 2/14/125	G6	Holzma	192344 s
380	4,8	3,5	60	72	2/14/100 + 2/14/125	G3	Holzma	192345 s
400	4,4	3,2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	TR-F-FA	Selco WN / EB	192346 s
400	4,4	3,2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G6	Selco WN / EB	192347 s
400	4,4	3,2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G3	Selco WN / EB	192348 s
400	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA		192349 s
400	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6		192350 s
400	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3		192351 s
400	4,4	3,2	75	72	4/15/105	TR-F-FA	Giben, Homag CH08+12	192352 s
400	4,4	3,2	75	72	4/15/105	G6	Giben, Homag CH08+12	192353 s
400	4,4	3,2	75	72	4/15/105	G3	Giben, Homag CH08+12	192354 s
400	4,4	3,2	60	72		TR-F-FA	Anthon	192355 s
400	4,4	3,2	60	72		G6	Anthon	192356 s
400	4,4	3,2	60	72		G3	Anthon	192357 s
400	4,4	3,2	30	72	2/7/42 + 2/10/60	TR-F-FA	Schelling, Mayer, Irion, Scheer, HOLZ- HER	192358 s
400	4,4	3,2	30	72	2/7/42 + 2/10/60	G6	Schelling, Mayer, Irion, Scheer, HOLZ- HER	192359 s
400	4,4	3,2	30	72	2/7/42 + 2/10/60	G3	Schelling, Mayer, Irion, Scheer, HOLZ- HER	192360 s
430	4,4	3,2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	192361 s
430	4,4	3,2	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	192362 s
430	4,4	3,2	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	192363 s
430	4,4	3,2	80	72	2/8,3/130	TR-F-FA	S.M.A., hogggers	192364 s
430	4,4	3,2	80	72	2/8,3/130	G6	S.M.A., hogggers	192365 s
430	4,4	3,2	80	72	2/8,3/130	G3	S.M.A., hogggers	192366 s
430	4,4	3,2	75	72	4/15/105 + 2/7/110	TR-F-FA	Giben Prismatic 2 old	192367 s
430	4,4	3,2	75	72	4/15/105 + 2/7/110	G6	Giben Prismatic 2 old	192368 s
430	4,4	3,2	75	72	4/15/105 + 2/7/110	G3	Giben Prismatic 2 old	192369 s
430	4,4	3,2	60	72	1/11/85	TR-F-FA	Anthon	192370
430	4,4	3,2	60	72	1/11/85	G6	Anthon	192371 s
430	4,4	3,2	60	72	1/11/85	G3	Anthon	192372 s
430	4,4	3,2	30	72		TR-F-FA		192373 s
430	4,4	3,2	30	72		G6		192374 s
430	4,4	3,2	30	72		G3		192375 s
450	4,4	3,2	80	72	2/7/110 + 2/8,3/130	TR-F-FA	S.M.A., Irion	192376 s
450	4,4	3,2	80	72	2/7/110 + 2/8,3/130	G6	S.M.A., Irion	192377 s
450	4,4	3,2	80	72	2/7/110 + 2/8,3/130	G3	S.M.A., Irion	192378 s
450	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani ELITE	192379 s
[mm]	[mm]	[mm]	[mm]					




Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
450	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani ELITE	192380 s
450	4,4	3,2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani ELITE	192381 s
450	4,4	3,2	30	72	2/13/94	TR-F-FA	Irion, Schelling	192382 s
450	4,4	3,2	30	72	2/13/94	G6	Irion, Schelling	192383 s
450	4,4	3,2	30	72	2/13/94	G3	Irion, Schelling	192384 s
450	4,8	3,5	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	192385 s
450	4,8	3,5	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	192386 s
450	4,8	3,5	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	192387 s
450	4,8	3,5	60	72	2/14/125 + 2/19/120	TR-F-FA	Holzma	192388
450	4,8	3,5	60	72	2/14/125 + 2/19/120	G6	Holzma	192389 s
450	4,8	3,5	60	72	2/14/125 + 2/19/120	G3	Holzma	192390 s
[mm]	[mm]	[mm]	[mm]					

2053..

Scoring Saw Blades DP - flexible & quick

Product 	Drawing 	  Polycrystalline diamond [DP]
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Machine / Application Panel Sizing Saw Blades with scoring device for scoring of plastic-laminated panels	Design diamond cutting edges with polished design LEUCODIA tipping quality	Advantages for each application case the correct tooth form short delivery times interesting scaled prices	Notes application with feed
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	KO-F Universal use in melamine and laminated panels		KO-WS Veneered panels, reduced motor power		KO-HR Perfect Cutting quality in all different panel materials
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Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
160	4,4-5,2	3.2	45	30	3/11/70	KO-F	Giben Prismatic	189345 s
160	4,4-5,2	3.2	45	30	3/11/70	KO-WS	Giben Prismatic	189341 s
160	4,4-5,2	3.2	45	30	3/11/70	KO-HR	Giben Prismatic	189343 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-F	Gabbiani	189346 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-WS	Gabbiani	189342 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-HR	Gabbiani	189344 s
180	4,4-5,2	3.2	20	30		KO-F	Schelling, Anthon	189351 s
180	4,4-5,2	3.2	20	30		KO-WS	Schelling, Anthon	189355 s
180	4,4-5,2	3.2	20	30		KO-HR	Schelling, Anthon	189347 s
180	4,4-5,2	3.2	30	30	2/10/60	KO-F	Panhans	189352 s
180	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Panhans	189356 s
180	4,4-5,2	3.2	30	30	2/10/60	KO-HR	Panhans	189348 s
180	4,4-5,2	3.2	45	30		KO-F		189353 s
180	4,4-5,2	3.2	45	30		KO-WS		189357 s
180	4,4-5,2	3.2	45	30		KO-HR		189349 s
180	4,4-5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	189354 s
180	4,4-5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	189358 s
180	4,4-5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	189350 s
180	4,8-5,6	3.5	45	30		KO-F	Holzma	189360 s
180	4,8-5,6	3.5	45	30		KO-WS	Holzma	189361 s
180	4,8-5,6	3.5	45	30		KO-HR	Holzma	189359 s
200	4,4-5,2	3.2	30	30	2/10/60	KO-F	Panhans	189366 s
200	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Panhans	189370 s
200	4,4-5,2	3.2	30	30	2/10/60	KO-HR	Panhans	189362 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-F	Selco	189367 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-WS	Selco	189371 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-HR	Selco	189363 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-F		189368 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-WS		189372 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-HR		189364 s
200	4,4-5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	189369 s
200	4,4-5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	189373 s
200	4,4-5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	189365 s


[mm] [mm] [mm] [mm]

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
200	4,8-5,6	3.5	45	30		KO-F	Holzma	189376 s
200	4,8-5,6	3.5	45	30		KO-WS	Holzma	189378 s
200	4,8-5,6	3.5	45	30		KO-HR	Holzma	189374 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-F	Selco	189377 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-WS	Selco	189379 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-HR	Selco	189375 s
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205099


Scoring Saw Blades DP - nn-System

Product

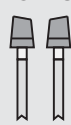


Drawing


KO-F



KO-WS




KO-HR




LEUCO
nn-system

DP PANEL




Polycrystalline diamond [DP]

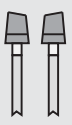
NO NOISE




Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> Panel Sizing Saw Blades with scoring device for scoring of plastic-laminated panels 	<ul style="list-style-type: none"> special NoNoise gullet geometry diamond cutting edges with polished design LEUCODIA tipping quality 	<ul style="list-style-type: none"> especially low noise level noise reduction by approx. 6 dB(A) when idling for each application case the correct tooth form short delivery times interesting scaled prices 	<ul style="list-style-type: none"> application with feed



KO-F
Universal use in melamine and laminated panels



KO-WS
Veneered panels, reduced motor power



KO-HR
Perfect Cutting quality in all different panel materials

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
160	4,4-5,2	3.2	45	30	3/11/70	KO-F	Giben Prismatic	192280 s
160	4,4-5,2	3.2	45	30	3/11/70	KO-WS	Giben Prismatic	192281 s
160	4,4-5,2	3.2	45	30	3/11/70	KO-HR	Giben Prismatic	192282 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-F	Gabbiani	192283 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-WS	Gabbiani	192284 s
160	4,4-5,2	3.2	55	30	3/6,5/66	KO-HR	Gabbiani	192285 s
180	4,4-5,2	3.2	20	30		KO-F	Schelling, Anthon	192286 s
180	4,4-5,2	3.2	20	30		KO-WS	Schelling, Anthon	192287 s
180	4,4-5,2	3.2	20	30		KO-HR	Schelling, Anthon	192288 s
180	4,4-5,2	3.2	30	30	2/10/60	KO-F	Panhans	192289
180	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Panhans	192290
180	4,4-5,2	3.2	30	30	2/10/60	KO-HR	Panhans	192291
180	4,4-5,2	3.2	45	30		KO-F		192292
180	4,4-5,2	3.2	45	30		KO-WS		192293 s
180	4,4-5,2	3.2	45	30		KO-HR		192294
180	4,4-5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	192295 s
180	4,4-5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	192296 s
180	4,4-5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	192297 s
180	4,8-5,6	3.5	45	30		KO-F	Holzma	192298
180	4,8-5,6	3.5	45	30		KO-WS	Holzma	192299 s
[mm]	[mm]	[mm]	[mm]					

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
180	4,8-5,6	3.5	45	30		KO-HR	Holzma	192300
200	4,4-5,2	3.2	30	30	2/10/60	KO-F	Panhans	192301 s
200	4,4-5,2	3.2	30	30	2/10/60	KO-WS	Panhans	192302 s
200	4,4-5,2	3.2	30	30	2/10/60	KO-HR	Panhans	192303 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-F	Selco	192304 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-WS	Selco	192305 s
200	4,4-5,2	3.2	65	30	2/9/100 + 2/9/110	KO-HR	Selco	192306 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-F		192307 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-WS		192308 s
200	4,4-5,2	3.2	20	30	2/11/66	KO-HR		192309 s
200	4,4-5,2	3.2	45	30		KO-HR	Holzma	193108
200	4,4-5,2	3.2	45	30		KO-WS	Holzma	193107
200	4,4-5,2	3.2	45	30		KO-F	Holzma	193106
200	4,4-5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	192310 s
200	4,4-5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	192311 s
200	4,4-5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	192312 s
200	4,8-5,6	3.5	45	30		KO-F	Holzma	192313
200	4,8-5,6	3.5	45	30		KO-WS	Holzma	192314 s
200	4,8-5,6	3.5	45	30		KO-HR	Holzma	192315 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-F	Selco	192316 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-WS	Selco	192317 s
200	4,8-5,6	3.5	65	30	2/9/100 + 2/9/110	KO-HR	Selco	192318 s
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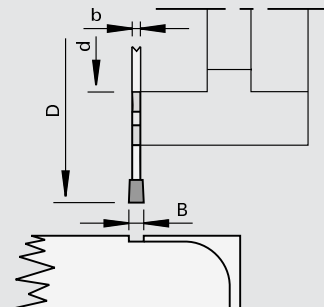
205010

Scoring Saw Blades DP for inlay profiles "F"

Product



Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

l machines Homag
l for chip-free scoring of inlay profiles in veneered panels

Design

l resharpenable area 4.0 mm
l n max = 24,000 min-1
l tooth configuration: flat "F"

Advantages

Notes

l application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,0	3,0	34	8	4/5,3/42	168473
75	3,2	2,2	22	10		168464 s
[mm]	[mm]	[mm]	[mm]			

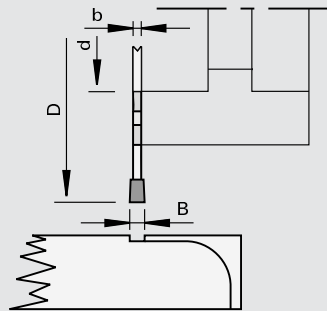
205080

Scoring Saw Blades DP for inlay profiles "KO-F"

Product



Drawing



Polycrystalline diamond [DP]

Machine / Application

l machines IMA
l for chip-free scoring of inlay profiles in melamine-faced and plastic-laminated panels

Design

l flanks 3 degrees conical
l resharpenable area 4.0 mm
l n max = 24,000 min-1
l tooth configuration: conical-flat "KO-F"

Advantages

Notes

l application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,0	3.0	34	8	4/5,3/42	181145 s
75	3,2	2.2	22	10		181146 s
[mm]	[mm]	[mm]	[mm]			

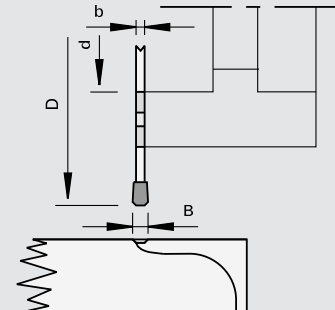
205080

Scoring Saw Blades DP for inlay profiles "F-FA"

Product



Drawing



Polycrystalline diamond [DP]

Machine / Application

l machines Homag
l for chip-free scoring of softforming profiles

Design

l n max = 24,000 min-1
l resharpenable area 3.0 mm
l tooth configuration: flat with two-sided chamfer 1.5 x 45 degrees "F-FA"

Advantages

Notes

l for Homag flange
l application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,3	3.0	34	8	4/5,3/42	168474 s
[mm]	[mm]	[mm]	[mm]			

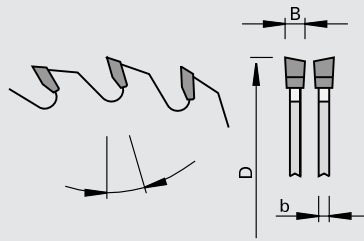
105320

Scoring Saw Blades HW "WS"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

l panel sizing saws with controllable scoring device
l for scoring of plastic-laminated postforming panels

Design

l tooth configuration: alternate top bevel "WS"
l cutting material: HW HL Board 06

Advantages

Notes

l cutting width consistently .2 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
180	3,3	2.2	22	36		10	15	Altendorf	192973 s
250	4,55	3.5	30	48	2/10/60	10	15	HOLZ-HER Cut 85	181999
250	4,55	3.5	45	48		10	15	Holzma HVP 120	189221 B
280	4,55	3.5	45	84		10	30	Holzma HPP 230+Hpp 250	189324
280	5,0	3.5	45	84		15	30	Holzma Typ 350/380	182081
340	5,0	3.5	45	48		10	20	Holzma	188500
340	5,0	3.5	45	108		0	20	Holzma	188501
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

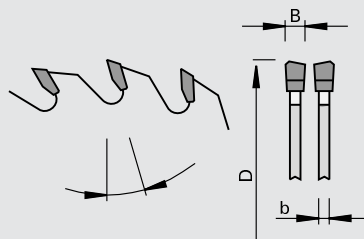
105320

Scoring Saw Blades HW "WS-FA"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

l panel sizing saws with controllable scoring device
l for scoring of plastic-laminated postforming panels

Design

l tooth configuration: alternate top bevel with chamfer "WS-FA"
l cutting material: HW HL Board 06

Advantages

Notes

l cutting width consistently .2 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	NL	Corner		Ident-No.
180	4,55	3.2	30	36		15	Schelling	193096
300	4,6	3.2	65	72	2/8,4/110 + 2/9/100	5	Selco	188497
[mm]	[mm]	[mm]	[mm]			[°]		

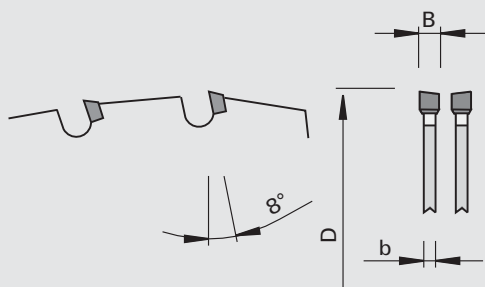
205229

Scoring Saw Blades DP "WS" - nn-System DP flex

Product



Drawing



LEUCO
nn-system



Polycrystalline diamond [DP]

Machine / Application

- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- resharpenable up to 2 times
- small gullets
- special cutting edge geometry
- tooth configuration: alternate top bevel "WS"
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes

- cutting width consistently 0.1 mm wider than the main saw kerf

Ø D	B	b	Ø d	Z	Ident-No.
120	2,6	2.0	22	24	192447
120	2,6	2.0	20	24	192448
125	2,6	2.0	20	24	192449
180	2,6	2.0	22	36	192964
[mm]	[mm]	[mm]	[mm]		

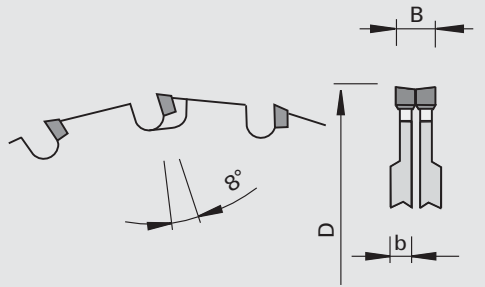
205289

Scoring Saw Blades DP "ES" - adjustable, nn-System DP flex

Product



Drawing



LEUCO
nn-system



Polycrystalline diamond [DP]

Machine / Application

- sizing saws and table saws
- for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

- resharpenable up to 2 times
- small gullets
- tooth configuration: top bevel "ES"
- cutting material: DP

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping

Notes

- split version - cutting width adjustable with spacers
- Ident-No. 192452 and 192455 automatic kerf adjustment

Ø D	B	b	Ø d	Z	Ident-No.
120	2,4-3,2	2.2	20	12+12	192450
120	2,4-3,2	2.2	22	12+12	192451
120	2,4-3,2	2.2	50	12+12	Altendorf RAPIDO 192452
[mm]	[mm]	[mm]	[mm]		

Ø D	B	b	Ø d	Z	Ident-No.
120	2,8-3,6	2.2	20	12+12	192453
120	2,8-3,6	2.2	22	12+12	192454
120	2,8-3,6	2.2	50	12+12	Altendorf RAPIDO 192455
[mm]	[mm]	[mm]	[mm]		

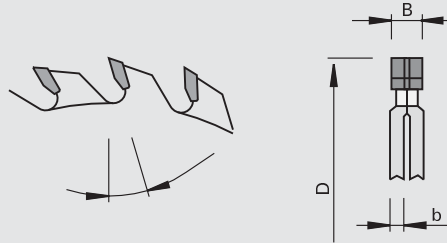
105318

Scoring Saw Blades HW - adjustable "F"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | table saws
- | panel sizing saws
- | panel sizing saws with controllable scoring device
- | for scoring of plastic-laminated panels

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 03

Advantages

- | universally applicable

Notes

- | split version - cutting width adjustable with spacers
- | for main/scoring saw combinations see specifications (Technical Appendix)
- | X = Original Striebig Scoring Saw Blades, cutting width adjustable by means of attachment screws and spring ring

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
70	2,8-3,6	2.2	20	2x8	2/3,2/32	12	Putsch	192647
70	2,8-3,6	2.2	20	2x10		12	Putsch	192231
80	2,8-3,6	2.2	20	2x6	2/4/34	10	Striebig	X 9201253
80	2,8-3,6	2.2	20	2x10	2/3,8/42	12	Striebig	192227
120	2,8-3,6	2.2	20	2x12	2/3,8/42	12	SCM	192228 \$
120	2,8-3,6	2.2	22	2x12	2/3,8/42	12	Altendorf, Martin	192229 \$
125	2,8-3,6	2.2	20	2x12	2/3,8/42	12	HOLZ-HER, SCM	192230
[mm]	[mm]	[mm]	[mm]			[°]		

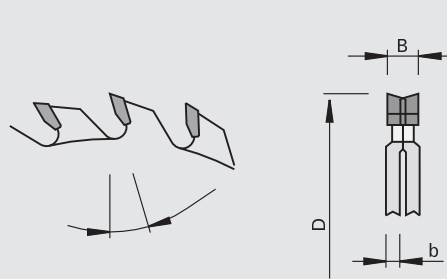
105325 / 105328

Scoring Saw Blades HW - adjustable "ES"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | table saws
- | panel sizing saws
- | panel sizing saws with controllable scoring device
- | for scoring of plastic-laminated panels

Design

- | tooth configuration: top bevel "ES"
- | cutting material: HW HL Board 03

Advantages

- | low motor output thanks to tooth configuration "ES"

Notes

- | split version - cutting width adjustable with spacers
- | for main/scoring saw combinations see specifications (appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
100	2,8-3,6	2.2	20	2x10		12	Schelling	105328	192232 \$
100	2,8-3,6	2.2	22	2x10		12	Altendorf, Martin, Panhans, Striebig	105328	192233
120	2,8-3,6	2.2	20	2x12		12	SCM	105328	192234 \$
120	2,8-3,6	2.2	22	2x12	2/3,1/42	12	Altendorf, Martin	105328	192235 \$
120	2,8-3,6	2.2	22	2x12	2/3,8/42 + 4/4,6/55 + 4/4,6/39	12	Martin NC-adjustment	105328	192236
120	2,8-3,6	2.2	50	2x12		12	Altendorf RAPIDO	105328	192237 \$
125	4,0-4,8	1.6	45	2x20		12	Giben, Mayer	105325	192238
140	2,8-3,6	2.0	36	2x12	2/6,2/51 + 3/ 4,2/55 + 3/9/55	12	Martin T75 PreX	105328	192239
145	2,8-3,6	3.0	50	2x12		10	Panhans QuickStep	105328	192240 s
160	2,8-3,6	2.2	30	2x16		12	Bäuerle	105328	192242 s
180	2,8-3,6	2.2	30	2x18		10	Koelle	105328	192241 s
300	4,2-4,7	1.8	50	2x32	3/15/80	12	Giben Prismatic + Starmatic	105325	192243
340	4,4-5,6	2.5	45	2x24		15	Holzma	105325	192244 s
[mm]	[mm]	[mm]	[mm]			[°]			
Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
120	2,8-3,6	2.2	20	2x22	2/3,2/42	10	SCM	105328	192245
120	2,8-3,6	2.2	22	2x22	2/3,2/42	10	Altendorf, Martin	105328	192246
120	2,8-3,6	2.2	50	2x18		10	Altendorf RAPIDO	105328	192247 s
180	2,8-3,6	2.2	22	2x18	2/3,2/42	12	Altendorf	105328	192972
180	3,0-3,8	2.2	50	2x18		12	Altendorf-Verstelleinheit	105328	192248
[mm]	[mm]	[mm]	[mm]			[°]			

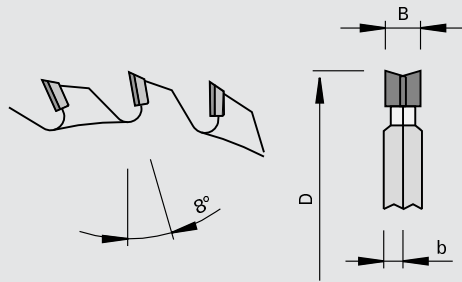
205088

Scoring Saw Blades DP - adjustable "ES"

Product



Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

table saws
for chip-free scoring of
melamine-, paper- or HPL-lami-
nated panels

Design

tooth configuration: top bevel
"ES"

Advantages

Notes

application with feed
split version - cutting width
adjustable with spacers
Ident-No. 189104 automatic
kerf adjustment
X = for Striebig "Compact",
"Evolution", "Control",
adjustable by means of spring
ring and attachment screw

Ø D	B	b	Ø d	Z	NL		Ident-No.
80	2,8-3,6	2.2	20	2x6	2/4/34	Striebig	X 9201163
120	2,8-3,6	2.2	20	2x12	2/3,2/42	SCM	192422
120	2,8-3,6	2.2	22	2x12	2/3,8/42	Altendorf, Martin	189101
120	2,8-3,6	2.0	50	2x12	3/5,5/63 + 3/9/63	for LEUCO adjustment unit	189652 s
120	2,8-3,8	2.2	50	2x12	4/6,2/62	Altendorf adjustment unit	189104
[mm]	[mm]	[mm]	[mm]				

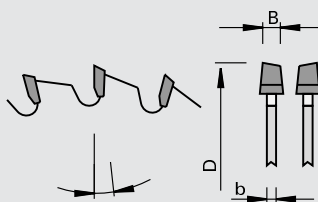
105390

Scoring Saw Blades HW "KO-WS"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: conical / alternate top bevel "KO-WS"
- cutting material: HW HL Board 04 plus

Advantages

- low motor output thanks to tooth configuration "KO-WS"
- for longer edge lives compared to HL Board 03 plus
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- optimum scoring depth 1.0 - 2.0 mm

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
100	3,2-4,0	2.2	20	20		8	Schelling
120	3,1-3,9	2.2	20	24		8	Lasari
120	3,1-3,9	2.2	22	24		8	Altendorf
125	4,45-5,25	3.2	20	20		0	Panhans
125	4,45-5,25	3.2	22	20		0	Martin
125	4,45-5,25	3.2	45	20		0	Giben, Homag CH03
125	3,0-3,8	2.2	20	24		8	192721 s
125	3,2-4,0	2.8	20	24		8	SCM, SICAR, Panhans
125	3,0-3,8	2.5	22	24		0	Martin, Altendorf
125	4,45-5,25	3.2	45	24		8	Homag Espana
150	4,45-5,25	3.2	30	24		8	Irion, Mayer
150	4,45-5,25	3.2	45	24		8	Homag CH06,08,10,12
150	4,45-5,25	3.2	45	28		8	Homag Espana
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic
160	4,45-5,25	3.2	55	36	3/6,5/66	8	Gabbiani
180	4,45-5,25	3.2	20	30	2/9/60	8	Schelling, Anthon
180	5,8-6,6	4.0	20	30		8	Anthon
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans
180	5,2-6,0	3.5	55	30		0	Giben
180	4,45-5,25	3.2	45	36		8	Holzma
180	4,85-5,65	3.5	45	36		8	Holzma Typ 11
180	4,45-5,25	3.2	50	44	3/13/80	10	Giben Smart
200	4,35-5,15	6.0	20	24	2/11/66	8	Schelling
200	5,0-5,8	3.5	20	34	2/11/66	8	Schelling
200	4,85-5,65	3.5	20	34	2/11/66	8	Schelling FH 8
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer
200	4,85-5,65	3.5	45	36		8	Holzma
200	5,9-6,6	4.0	45	36		8	Holzma
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN / EB
200	4,4-5,2	3.2	50	42	3/13/80	8	Giben Smart
215	4,45-5,25	3.2	50	42	3/15/80 + 2/7/80	8	Giben Prismatic + Starmatic
280	4,85-5,65	3.5	45	72		8	Holzma
300	4,45-5,25	3.2	30	48	2/11/73 + 2/13/94	8	Schelling FX-H 430
300	4,45-5,25	3.2	50	48	3/15/80	8	Giben Prismatic
300	4,45-5,25	3.2	65	48	2/8,4/100 + 2/8,4/110	8	Selco EB
[mm]	[mm]	[mm]	[mm]			[°]	

Suitable for Panel Sizing Saw Blades Q-Cut G5 + Q-Cut TR-F K

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.	
180	4,05-4,85	3.2	20	36		0	Schelling, Anton	192754 s
180	4,05-4,85	3.2	30	36	2/10/60	0	Panhans	192755 s
180	4,05-4,85	3.2	45	36		0	Holzma	192756
180	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192757 &
200	4,05-4,85	3.2	20	36	2/11/66	0	Schelling	192758
200	4,05-4,85	3.2	30	36	2/10/60	0	S.M.A., Panhans, Scheer	192759 &
200	4,05-4,85	3.2	45	36		0	Holzma	192760
200	4,05-4,85	3.2	50	36	3/13/80	0	Giben Smart	192761 &
200	4,05-4,85	3.2	65	36	2/8,4/100 + 2/8,4/110	0	Selco	192762 s
[mm]	[mm]	[mm]	[mm]			[°]		

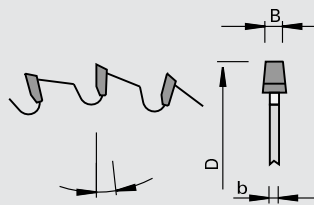
105390

Scoring Saw Blades HW "KO-F"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- panel sizing saws with scoring device
- for scoring of plastic-laminated panels

Design

- tooth configuration: conical-flat "KO-F"
- cutting material: HW HL Board 04 plus

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.17 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm
- for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.	
180	6,7-7,5	4.4	20	30		8	Anthon	192713
200	6,7-7,5	4.4	20	34	2/11/66	8	Schelling	192714
220	6,7-7,5	4.4	20	36	2/11/66	8	Schelling FS-H / AS-H	192716
220	3,25-4,0	2.4	45	60		8	Holzma HPS 320	192715
[mm]	[mm]	[mm]	[mm]			[°]		

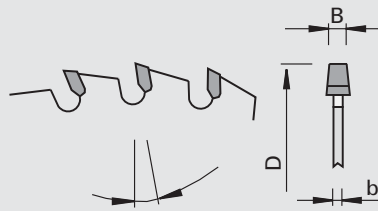
105399

Scoring Saw Blades HW "KO-F" - nn-System

Product



Drawing



LEUCO
nn-system

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

- | panel sizing saws with scoring device
- | for scoring of plastic-laminated panels

Design

- | special NoNoise gullet geometry
- | tooth configuration: conical-flat "KO-F"
- | cutting material: HW HL Board 04 plus

Advantages

- | quick adjustment
- | universally applicable
- | optimum cutting quality thanks to improved runout accuracy
- | reduction of the scoring depth
- | especially low noise level
- | noise reduction by approx. 6 dB(A) when idling
- | excellent cutting quality in all common coatings
- | long edge lives provide for the necessary productivity and economic efficiency

Notes

- | height adjustable to kerf of main saw blade
- | 1 mm scoring depth = 0.21 mm cutting width
- | optimum scoring depth 1.0 - 2.0 mm
- | for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
120	3,1-3,9	2.5	20	24		8 SCM	192970
120	3,1-3,9	2.5	22	24		8 Altendorf, Martin	192971
125	3,1-3,9	2.2	20	24		8 SCM, SICAR, Panhans	192698
150	4,45-5,25	3.2	45	28		8 Holzma Typ 130	192699
180	4,45-5,25	3.2	30	36		8 HOLZ-HER	192700
180	4,45-5,25	3.2	45	36		8 Holzma	192701
180	4,85-5,65	3.5	45	36		8 Holzma Typ 11	192702
200	4,45-5,25	3.5	20	36	2/11/66	8 Schelling	192703
200	4,45-5,25	3.0	45	36		8 Homag Sawtech	192704
200	4,85-5,65	3.5	45	36		8 Holzma	192705
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8 Selco	192706
200	4,45-5,25	3.5	80	36	2/11/66 + 2/14/110	8 SCM	192707
200	4,85-5,65	3.5	80	36	2/14/110	8 SCM	192708
200	3,2-4,0	2.2	30	60		15 Scheer	192709
250	4,45-5,25	3.5	30	42	2/10/60	8 Panhans, HOLZ-HER	192710
280	4,45-5,25	3.2	30	48	2/10/60 + 2/11/66	8 HOLZ-HER	192711
280	4,45-5,25	3.2	45	72		8 Holzma HP 300, HKL 300	192712
[mm]	[mm]	[mm]	[mm]			[°]	

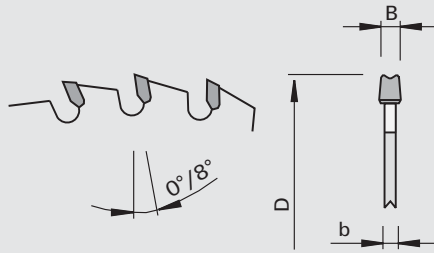
105399

Scoring Saw Blades HW "KO-HR" - nn-System

Product



Drawing

LEUCO
nn-SYSTEMLEUCO
DUR

Tungsten Carbide [HW]

NO
NOISE

Machine / Application

- Panel Sizing Saw Blades with scoring device
- for chip-free scoring of plastic coated, paper laminated as well as veneered panels

Design

- special NoNoise gullet geometry
- cutting material: HW HL Board 04 plus
- tooth configuration: conical hollow back "KO-HR"

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

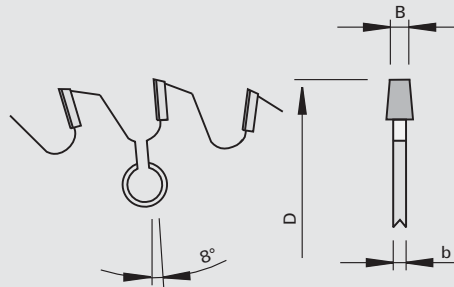
Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
160	4,45-5,25	3.2	45	28	3/11/70	8	Giben Prismatic 192686
180	4,45-5,25	3.2	30	30	2/10/60	8	Panhans 192687
180	4,05-4,85	3.2	45	36		0	Holzma 192688
180	4,45-5,25	3.2	45	36		8	Holzma 192689
180	4,85-5,65	3.5	45	36	2/9/110	8	Holzma Typ 11 192690
200	4,45-5,25	3.5	20	36	2/11/66	8	Schelling 192691
200	4,45-5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer 192692
200	4,05-4,85	3.2	45	36		0	Holzma 192693
200	4,45-5,25	3.2	45	36		8	Holzma 192694
200	4,85-5,65	3.5	45	36	2/9/110	8	Holzma 192695
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco 192696
200	4,85-5,65	3.5	65	36	2/9/110	8	Selco WN/EB 192697
[mm]	[mm]	[mm]	[mm]			[°]	

205090

Scoring Saw Blades DP "KO-F" - Homag HPS 320

Product

Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

Panel Sizing Saw Blades with scoring device
for scoring of plastic-laminated panels

Design

diamond cutting edges with polished design
LEUCODIA tipping quality
tooth configuration: conical-flat "KO-F"

Advantages

suitable for high feed rates

Notes

application with feed

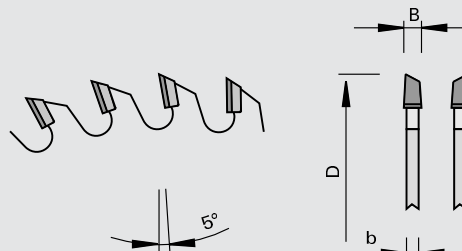
Ø D	B	b	Ø d	Z		Ident-No.
220	3,4 - 4,2	2.4	45	60	Homag HPS 320	193105
[mm]	[mm]	[mm]	[mm]			

205091

Scoring Saw Blades DP "KO-WS"

Product

Drawing



LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

table saws
for chip-free scoring of melamine-, paper- or HPL-laminated panels

Design

tooth configuration: conical / alternate top bevel "KO-WS"

Advantages

Notes

application with feed
kerf "B" = kerf of the main saw blade

Ø D	B	b	Ø d	Z		Ident-No.
120	3,1-3,9	2.2	22	16	Altendorf, Martin	178766
[mm]	[mm]	[mm]	[mm]			

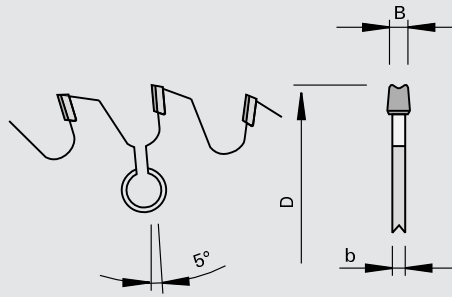
205082

Scoring Saw Blades Holzma DP "KO-HR-FA"

Product



Drawing

LEUCO
toplineLEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

| panel sizing saws
 | table saws
 | for chip-free scoring of
 melamine-, paper- or HPL-lami-
 nated panels

Design

| tooth configuration: conical
 hollow back with chamfer
 "KO-HR-FA"

Advantages

| long edge lives
 | excellent cutting quality

Notes

| application with feed

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	4,8-5,6	3.5	45	36		Holzma	182283
180	4,4-5,2	3.2	45	36		Holzma	189234 s
200	4,4-5,2	3.2	20	36	2/11/66	Schelling	189232 s
200	4,8-5,6	3.5	45	36		Holzma	189231 s
200	4,4-5,2	3.2	65	36	2/9/100 + 2/9/110	Selco	189230 s
200	4,8-5,6	3.5	65	36	2/9/100 + 2/9/110	Selco WN/EB	189233 s
[mm]	[mm]	[mm]	[mm]				

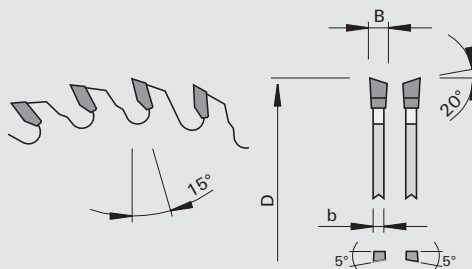
101320

Double Clipping Saw Blades HW with cooling slots "WSA"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- joinery machines
- double clipping saws
- table saws
- for chop cuts (one-sided, double-sided) for precise lengths of boards, lamellas, etc.

Design

- positive hook angle
- proven asymmetric chip evacuation gap geometry and additional cooling elements
- tooth configuration: alternate top bevel with shear angle "WSA"
- cutting material: HW HL Board 10
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

Notes

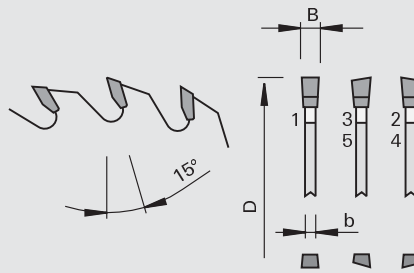
Ø D	B	b	Ø d	Z	DKN	NL	Ident-No.
350	4,0	2.6	30	54		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189788
400	4,4	3.0	30	60		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189789
450	4,4	3.0	30	72		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189790
500	4,8	3.2	30	72		2/10/80	189792
500	4,8	3.2	30	108		2/10/80 + 2/15/63	189794
500	4,0	3.2	70	108	20x6		192954
550	4,8	3.2	30	72		2/10/80	189795
600	5,4	4.0	30	72		2/10/80 + 2/15/63	189796 s
630	5,4	4.0	40	72		2/10/60	189797
650	5,6	4.0	30	96		2/10/80 + 2/15/63	189798
650	5,6	4.0	30	54		2/10/80 + 2/15/63	189799 s
720	6,2	4.4	30	48		Hundegger 2/8,5/90	189800 s
720	6,2	4.4	30	72		Hundegger 2/8,5/90	189801
735	6,2	4.4	30	48		Hundegger 2/8,5/90	189802 s
735	6,2	4.4	30	72		Hundegger 2/8,5/90	189803 s
760	6,2	4.4	30	48		Hundegger 2/14/400 + 4/8,5/90	189804 s
760	6,2	4.4	30	72		Hundegger 2/14/400 + 4/8,5/90	189805 s
760	6,2	4.4	30	96		Hundegger 2/14/400 + 4/8,5/90	189806
800	6,2	4.4	30	48		Paul	189807 s
[mm]	[mm]	[mm]	[mm]		[mm]		

101380

Clipping Saw Blades HW - crosscut- and shifter cuts "G5"

Product

Drawing



LEUCO
G5 system

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for joinery machines
for clipping-, crosscut- and shifter cuts in solid wood

Design

positive hook angle
tooth configuration: "G5"
cutting material: HW HL Board 10

Advantages

excellent cutting quality thanks to special tooth geometry
extremely quiet during operation due to the low cutting pressure

Notes

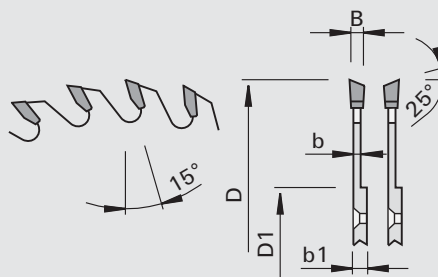
Ø D	B	b	Ø d	Z	NL	Ident-No.
800	6,5	5.0	30	80	4/9/90 + 2/14/400	Hundegger 193097
[mm]	[mm]	[mm]	[mm]			

101327

Clipping Saw Blades HW with cooling slots - crosscut- and shifter cuts "WS"

Product

Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for joinery machines
for clipping-, crosscut- and shifter cuts in solid wood

Design

positive hook angle
with cooling elements
tooth configuration: alternate top bevel "WS"
cutting material: HW HL Board 20

Advantages

extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	b1	D1	Ø d	Z	NL	Ident-No.
555	5,2	3.6	6.0	115	55	54	6/6,6/75 Weinmann	192656
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

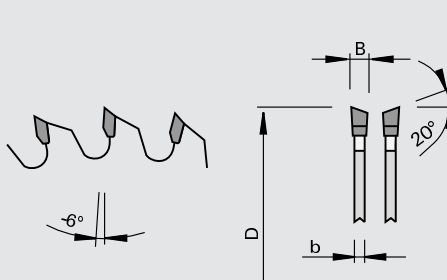
101322

Clipping Saw Blades HW "WS"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- chop and cross-cutting saws
- for cross cuts in solid woods

Design

- negative hook angle
- tooth configuration: alternate top bevel "WS"
- cutting material: HW HL Solid 15

Advantages

Notes

Ø D	B	b	Ø d	Z	Ident-No.
450	4,4	3,2	30	54	188045
500	4,4	3,2	30	60	188046
[mm]	[mm]	[mm]	[mm]		

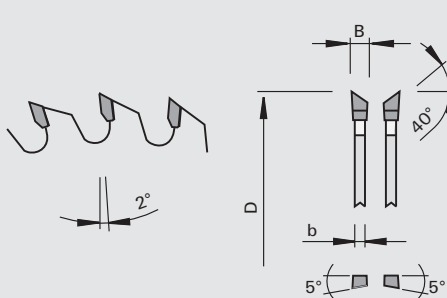
101322

Clipping Saw Blades HW for wood optimization "WSA"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- optimizing chop saws
- undertable cross-cut saws
- push-feed saws
- through-feed saws
- for cross cuts in solid woods

Design

- positive hook angle
- tooth configuration: alternate top bevel with shear angle "WSA"
- cutting material: HW HL Board 06
- extremely high bending strength and hardness of the teeth

Advantages

- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
400	3,4	2,8	30	120	2/10/60	DIMTER QUANTUM 189896
400	4,6	3,5	30	120	2/10/60	DIMTER 189833
450	4,6	3,5	30	132	2/15/63	DIMTER 189834
500	4,6	3,5	30	144	2/15/63	DIMTER 189835
520	4,6	3,5	30	144	2/15/63	DIMTER 189836
550	4,6	3,5	120	156	6/10,2/240	Paul 189837
600	5,2	3,8	30	172	2/15/63	DIMTER 189838
630	5,4	4,0	30	180	2/15/63	DIMTER 189839
[mm]	[mm]	[mm]	[mm]			

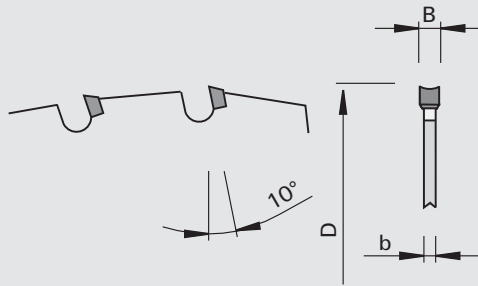
206289

Chop Saw Blades DP "HR" - nn-System DP flex

Product



Drawing



LEUCO
nn-SYSTEM

DP FLEX

Polycrystalline diamond [DP]

NO
10000

Machine / Application

- | CNC machining centers and aggregates
- | for precise cutting in all common wood-based panels such as raw and laminated particle and MDF boards, plywood boards, HDF, WPC, cement and gypsum fiber boards, mineral composites, Alucobond, ...
- | for ripping and cross cuts in solid wood, glued laminated timber, thermotreated wood

Design

- | resharpenable up to 2 times
- | small gullets
- | special cutting edge geometry
- | tooth configuration: hollow back tooth "HR"
- | cutting material: DP

Advantages

- | hardly perceivable noise level
- | highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- | reduced cutting pressure thanks to hollow back tooth geometry

Notes

- | it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
- | chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	2,5	2.0	30	36	4/6/52	Homag, Weeke	192432
200	2,5	2.0	30	40	8/6/52	Homag	192433
200	2,5	2.0	30	40	2/6,2/42 + 4/6,6/60	IMA	192434
220	2,5	2.0	30	44			192435
220	2,5	2.0	40	44	8/6/52	Homag, Weeke	192436
240	2,5	2.0	30	50	8/6/52	Homag	192437
240	2,5	2.0	40	50	8/6/52	Homag, Weeke	192438
240	2,5	2.0	30	50	2/6,2/42 + 4/6,6/60	IMA	192439
[mm]	[mm]	[mm]	[mm]				

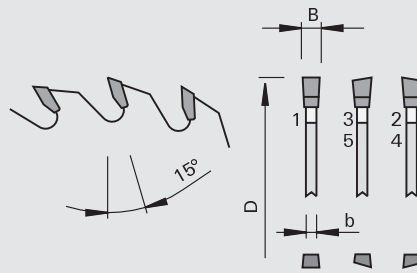
102348

Clipping Saw Blades HW "G5"

Product



Drawing



LEUCO
G5 system

LEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

l CNC machining centers and aggregates
l for chip-free sizing cuts as well as clipping and mitre cuts in wood-based panels, solid woods and plastics

Design

l tooth configuration: G5
l cutting material: HW HL Board O4 plus

Advantages

l excellent cutting quality for cross cuts
l excellent cutting quality thanks to special tooth geometry
l extremely long edge lives
l noise reduction thanks to laser ornaments

Notes

l pay attention to nmax!!!

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	3,0	2.2	30	60	4/6/52	Homag, Weeke	192804
180	3,0	2.2	40	60	8/6/52	Homag, Weeke	192805 &
200	3,0	2.2	30	65	8/6/52	Homag	192806
200	3,0	2.2	30	65	2/6,2/42 + 4/6,6/60	IMA	192807 &
220	3,0	2.2	40	70	8/6/52	Homag, Weeke	192808
240	3,0	2.2	30	75	8/6/52	Homag	192809 &
240	3,0	2.2	40	75	8/6/52	Homag, Weeke	192810
240	3,0	2.2	30	75	2/6,2/42 + 4/6,6/60	IMA	192811 &
280	3,0	2.2	30	85	8/6/52	Homag	192812 &
[mm]	[mm]	[mm]	[mm]				

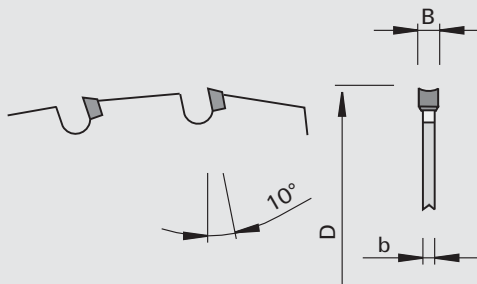
206289

Clipping Saw Blades DP for edge trimming "HR" - nn-System DP flex

Product



Drawing



LEUCO
nn-SYSTEM

DP FLEX

Polycrystalline diamond [DP]

NO
2002

Machine / Application

edge banders
for trimming of plastic-, veneer- and solid wood edges

Design

small gullets
special cutting edge geometry
tooth configuration: hollow back tooth "HR"
cutting material: DP
resharpenable up to 2 times

Advantages

hardly perceivable noise level
highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
reduced cutting pressure thanks to hollow back tooth geometry

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	2,5	2.0	22	20	2/4/30	EBM, Felder, Lohmeyer	192543 s
100	2,5	2.0	32	30		Brandt	192544 s
110	2,5	2.0	22	24		Reich	192551 s
110	2,5	2.0	22	20		Reich	192552 s
120	2,5	2.0	40	24	8/6/52	Homag	192541 s
120	2,5	2.0	40	36	2x4/5,5/52	Homag	192553 s
125	2,5	2.0	30	36	2x4/6,5/48	Homag BAZ	192554 s
125	2,5	2.0	40	24	2x4/5,8/60	Brandt	192549 s
140	2,5	2.0	16	36		Ott	192545 s
160	2,5	2.0	22	36		IMA	192546 s
160	2,5	2.0	22	48		IMA	192547 s
160	2,5	2.0	30	24	2/7/42	HOLZ-HER	192555 s
170	2,5	2.0	30	36	4/5,5/52	Homag	192542 s
180	2,5	2.0	22	42		IMA	192550 s
180	2,5	2.0	30	54	4/6/52	Homag BAZ	192556 s
200	2,5	2.0	30	64	4/6,6/60 + 2/6,2/42	IMA	192548 s
[mm]	[mm]	[mm]	[mm]				

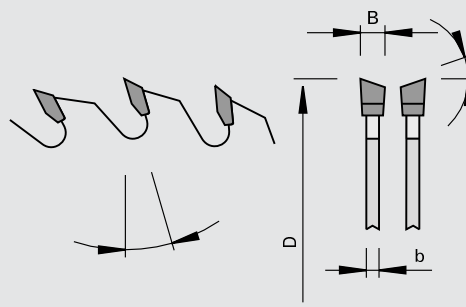
106320

Clipping Saw Blades HW for edge trimming "WS" - without countersink

Product



Drawing



LEUCO
topLine

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | edge banders
- | edge trimming machines
- | for trimming of plastic-, veneer- and solid wood edges

Design

- | positive or negative hook angle
- | with or without shear angle
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06

Advantages

Notes

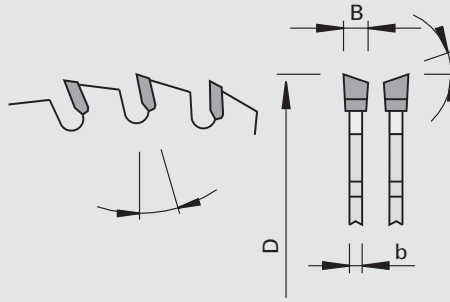
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner	Shear		Ident-No.
125	2,4	1.6	32	24		15	30	0	Brandt	192900
160	3,5	2.5	22	36		-5	15	5	IMA	188662
180	3,5	2.5	22	42		-6	15	5	IMA	189996
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

106329

Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink

Product

Drawing

LEUCO
nn-systemLEUCO
DUR

Tungsten Carbide [HW]

NO
noise

Machine / Application

- | edge banders
- | edge trimming machines
- | for trimming of plastic-, veneer- and solid wood edges

Design

- | special NoNoise gullet geometry
- | positive or negative hook angle with or without shear angle
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06

Advantages

- | especially low noise level
- | noise reduction by approx. 6 dB(A) when idling

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠	Shear∠		Ident-No.
90	3,0	2,0	30	20		8	10	0	Reich	192471
100	2,4	1,6	22	12		15	10	5	HOLZ-HER	192472
100	2,4	1,6	22	20	2/4/30	-8	10	5	EBM	192473
100	3,6	2,2	32	20		8	30	5	Wilmsmeyer	192474 s
100	3,2	2,2	22	20		8	15	0	Felder	192475
100	2,6	1,6	32	30		10	15	5	Brandt	192476
110	3,6	2,5	22	20		8	30	5	HOLZ-HER, Reich	192477
110	3,6	2,5	32	20		8	30	5	Homag	192478
115	3,2	2,2	56	30	3/7,1/68 + 3/7,1/68	15	15	0	Biesse Akron 400	192482 s
120	3,2	2,2	32	20		10	10	5	Homag	192483
140	3,2	2,2	16	36		10	15	5	Ott	192489
140	3,2	2,2	22	36		10	15	5	HOLZ-HER	192488
150	3,2	2,2	22	48		10	10	5	IMA	192493
160	3,0	2,5	22	36		-5	15	0	IMA	192456
160	3,2	2,2	20	48	2/5/32	10	10	5	HOLZ-HER	192497
160	3,2	2,2	22	48		-8	10	5	IMA	192498
160	3,2	2,2	30	24	2/7/42	15	10	5	HOLZ-HER	192495
160	3,2	2,2	40	30	4/5,5/52	-8	20	10	HOLZ-HER	192496
170	3,2	2,2	30	36	4/5,5/52	10	20	0	Homag	192464
200	3,2	2,2	30	64	4/6,6/60 + 2/6,2/42	10	15	0	IMA	192501
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

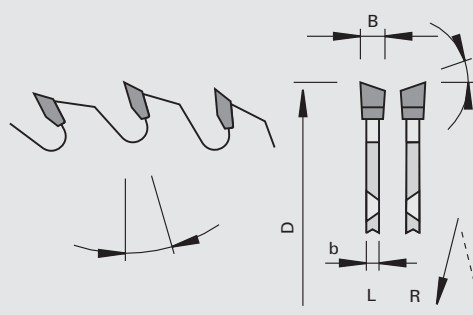
106320

Clipping Saw Blades HW for edge trimming "WS" - with countersink

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel "WS"
- cutting material: HW HL Board 06

Advantages

Notes

- Ident-No. 189259
- NL=2/10/60 have no countersink
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner	Shear		Ident-No.
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		
350	3,6	2,5	30	16	2/10/60 + 8/6/90	20	10	0	Homag BAZ	R 189259

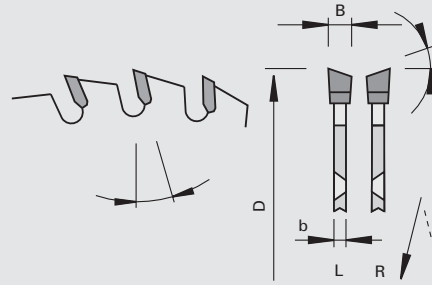
106329

Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink

Product



Drawing

LEUCO
nn-systemLEUCO
DUR

Tungsten Carbide [HW]

NO
noise

Machine / Application

edge trimming machines
for trimming of plastic-, veneer-
and solid wood edges

Design

special NoNoise gullet
geometry
positive hook angle
with or without shear angle
pin holes with countersink
tooth configuration: alternate
top bevel "WS"
cutting material: HW HL Board
06

Advantages

especially low noise level
noise reduction by approx. 6
dB(A) when idling

Notes

Ident-No. 192494
NL=4/5,5/52 have no
countersink
sense of rotation according to
DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner	Shear		Ident-No.
110	3,2	2,5	40	20	4/5,5/52	10	45	5	Homag	L 192480
110	3,2	2,5	40	20	4/5,5/52	10	45	5	Homag	R 192479
110	3,2	2,2	40	30	4/6/52	10	45	0	Homag BAZ	R 192481
120	3,6	2,8	40	24	2x4/6/52	8	30	0	Homag	N 189751
120	3,2	2,5	40	36	2x4/5,5/52	10	45	5	Homag	N 192484
120	3,6	2,8	40	36	2x4/6/52	12	20	0	Homag	N 192485 s
125	2,4	1,6	40	24	2x4/5,8/60	15	30	0	Brandt	N 192486
125	2,4	1,6	30	36	2x4/6,5/48	10	30	0	Homag BAZ	N 192487
140	3,2	2,2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	L 192491 &
140	3,2	2,2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	R 192490 &
150	3,6	2,8	40	30	4/6/52	8	30	0	Biesse Akron 600/800	N 192492
150	3,2	2,2	30	48	4/6/48 + 4/5,5/52	10	15	0	Homag BAZ	R 192494
180	3,2	2,2	30	54	4/6/52	10	30	5	Homag BAZ	L 192500
240	3,5	2,2	30	54	8/6,1/52	10	20	0	Homag BAZ	L 192502 s
240	3,5	2,2	40	54	8/6,1/52	10	20	0	Homag BAZ Flex 5, Weeke	L 192503 s
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

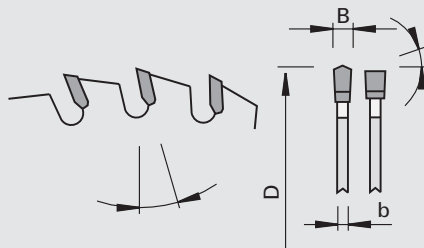
106379

Clipping Saw Blades HW for edge trimming "TR-F" - nn-System

Product



Drawing



LEUCO
nn-system

LEUCO
DUR

Tungsten Carbide [HW]

NO
noise

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- special NoNoise gullet geometry
- without shear angle
- positive hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

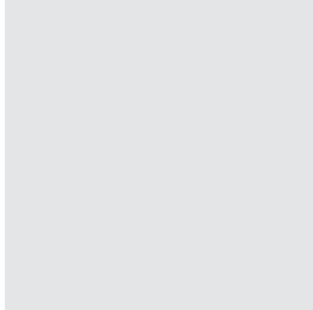
Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
[mm]	[mm]	[mm]	[mm]			[°]	[°]		
110	1,7	1,2	40	30	4/6/52	10	45	Homag BAZ	192504

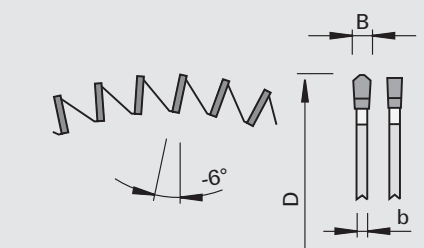
106370

Clipping Saw Blades HW for edge trimming "TR-F"

Product



Drawing



LEUCO
teoptima

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- edge banders
- edge trimming machines
- for trimming of plastic-, veneer- and solid wood edges

Design

- without shear angle
- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 10

Advantages

-

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
[mm]	[mm]	[mm]	[mm]			[°]	[°]		
140	2,2	2,0	52	70	4/5,5/65	-6	45	IMA	192998

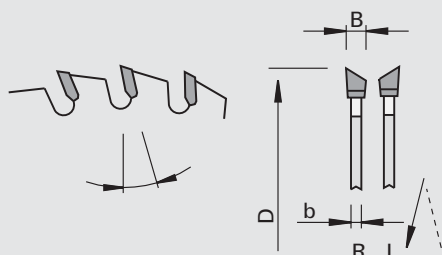
106329/106359

Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink

Product



Drawing



LEUCO
nn-system

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

- | edge banders
- | edge trimming machines
- | for trimming of thin plastic-, veneer- and solid wood edges

Design

- | special NoNoise gullet geometry
- | positive or negative hook angle with and without shear angle
- | tooth configuration: top bevel "ES (right + left)"
- | cutting material: HW HL Board 06

Advantages

- | especially low noise level
- | noise reduction by approx. 6 dB(A) when idling

Notes

- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∟	Shear∟		Ident-No. [L]	Ident-No. [R]
100	3,2	2,2	32	20		-6	30	5	Homag	192507 #	192508 s
100	3,0	2,2	32	20		8	30	5	Wiltsmeyer	192505	192506
100	2,6	2,0	32	30		-10	15	0	Brandt	192510	192509
100	2,6	2,0	32	30		10	15	0	Homag CN	192514	192513
100	2,6	1,6	32	30		10	10	0	Brandt	192511	192512
150	3,5	2,2	22	30		-6	15	5	IMA	192521 s	192522 s
150	3,5	2,2	30	30		12	15	5	SCM-IDM	192519 s	192520 s
150	3,5	2,2	30	44	4/5,5/52	-12	45	10	Homag Powerline	192524	192523
160	3,6	2,5	40	18		8	30	0	HOLZ-HER	192525 s	192526 s
170	3,5	2,2	30	48	4/5,5/52	-12	45	10	Homag Powerline	192528	192527
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

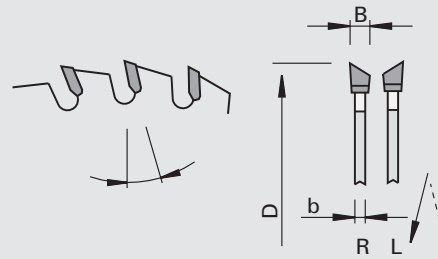
106329/106359

Clipping Saw Blades HW for edge trimming "ES" - nn-System, with countersink

Product



Drawing



LEUCO
nn-system

LEUCO
DUR

Tungsten Carbide [HW]

NO
noise

Machine / Application

- | edge banders
- | edge trimming machines
- | for trimming of thin plastic-, veneer- and solid wood edges

Design

- | special NoNoise gullet geometry
- | positive or negative hook angle with and without shear angle
- | pin holes with countersink
- | tooth configuration: top bevel "ES (right + left)"
- | cutting material: HW HL Board 06

Advantages

- | especially low noise level
- | noise reduction by approx. 6 dB(A) when idling

Notes

- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠	Shear∠		Ident-No. [L]	Ident-No. [R]
110	3,2	2,5	40	20	4/6/52	-6	45	5	Homag	192515 s	192516
120	3,2	2,5	40	20	4/6/52	-6	45	5	Homag	192517	192518
130	3,6	2,8	30	20+4	4/7,4/46	10	30	0	Biesse	192530 s	192529 s
140	3,6	2,8	30	20+4	4/7,4/46	-20	30	0	Biesse	192532 s	192531 s
150	3,8	2,5	35	24+6	4/6/50	10	15	0	SCM-Stefani	192534 s	192533 s
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

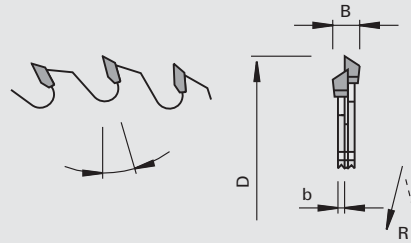
106354

Clipping Saw Blades HW for edge trimming - adjustable "ES"

Product



Drawing



LEUCO
topLine

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | edge banders
- | edge trimming machines Homag, Brandt, Raimann, Reich, Ott, SCM-Stefani
- | for trimming and chamfering of plastic-, veneer- and solid wood edges

Design

- | positive hook angle
- | L - left hand bevel "ES-L" / R - right hand bevel "ES-R"
- | cutting material: HW HL Board 06

Advantages

Notes

- | LEUCODUR HW
- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Shear∠		Ident-No. [L]	Ident-No. [R]
[mm]	[mm]	[mm]	[mm]			[°]	[°]			
100	5,8	2.2	32	2x20		8	5		169980	169983
125	6,2	2.0	30	2x20	2/3,1/42	10	0	SCM-Stefani	189329	189332

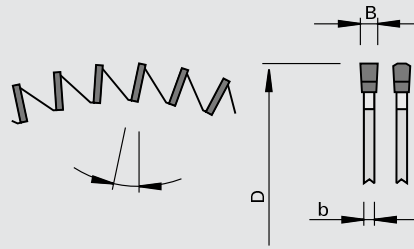
102370

NF-Chop Saw Blades HW "TR-F"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- chop and miter saws
- for cross cuts in thin-walled plastic and aluminum profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 10

Advantages

- smooth running and no chipping of edges of the workpiece thanks to the high number of teeth

Notes

Ø D	B	b	Ø d	Z	Hook angle	Ident-No.
200	2,2	2.0	30	100	-6	188388
250	2,2	1.6	30	126	-6	189709
[mm]	[mm]	[mm]	[mm]		[°]	

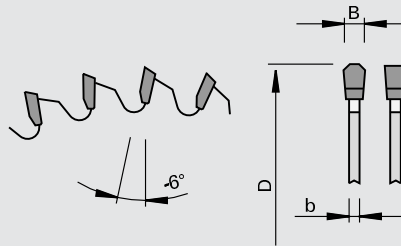
108672

NF-Chop Saw Blades HW - negative hook angle "TR-F" highline

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]

LOW
VIBRATION

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 10

Advantages

- noise-reduction thanks to laser ornaments

Notes

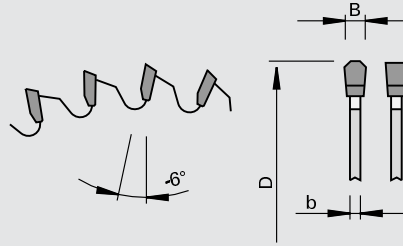
Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	60	2/7/42	DeWALT, ELU, Haffner, Makita	189846
250	2,8	2.2	30	80	2/7/42	ELU, Mafell, Metabo, Festo, Haffner, Hitachi	189847
250	3,2	2.5	30	80	2/7/42	DeWALT, ELU, Haffner, Makita	189848 \$
250	3,2	2.5	32	80		Kaltenbach TL 250, ELU TGS 71, 171, 172, Baier, Fezer, Ulmia, Trennjäger	189849 &
275	3,2	2.5	40	88	4/12/64 + 2/9/55	Eisele LMS I new, Graule, Trennjäger, Weidmann	189850
300	3,2	2.5	30	72	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189851
300	3,2	2.5	32	72		ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189852 &
300	2,8	2.2	30	96	2/7/42 + 2/10/60		189853
300	3,2	2.5	30	96	2/7/42 + 2/10/60	DeWALT, Fezer, Schleicher	189854 \$
300	3,2	2.5	32	96		ELU MGS 73, Rapid, Trennjäger, Fezer, Berg&Schmid	189855 &
330	3,2	2.5	30	96	2/10/60 + 2/9/46 + 2/7/42	ELU, Haffner	189856
330	3,2	2.5	32	96	2/10/60 + 2/9/46 + 2/7/42	ELU	189857 &
[mm]	[mm]	[mm]	[mm]				

108372

NF-Chop Saw Blades HW - negative hook angle "TR-F" topline

Product

Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- chop and miter saws
- for clipping and mitre cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 06

Advantages

- noise-reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,8	3.2	40	84	4/12/64 + 2/9/55	Eisele LMS II, LMS II - P V, VA - L, Graule, Ulmia, Weidmann	193115
350	3,2	2.5	30	90	2/10/60	DeWALT, Haffner, Pfeiffer	193116
350	3,2	2.5	30	96	2/10/60		193117
350	3,2	2.5	30	108	2/9/55 + 2/10/60 + 4/12/64		193118 \$
350	3,2	2.5	40	108	4/12/64 + 2/9/55	Eisele LMS II, LMS II - PV, VA - L, Graule, Ulmia, Weidmann	193119 &
400	3,8	3.2	30	96	2/12/64 + 4/15/80	DeWALT, Haffner	189863
400	3,8	3.2	50	96	4/15/80	Kaltenbach TL 400	189864 &
420	4,0	3.2	30	96		Rapid, ELU	189865
450	3,8	3.2	30	96	4/12/64 + 2/12/80	DeWALT, Haffner	189866
500	4,0	3.4	30	120	2/10/70	Pfeiffer, Rapid	189867
[mm]	[mm]	[mm]	[mm]				

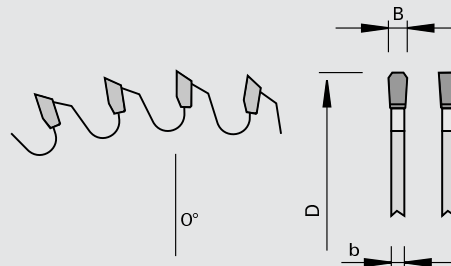
108370

NF-Chop Saw Blades HW - neutral hook angle "TR-F"

Product



Drawing



Tungsten Carbide [HW]



Machine / Application

- | chop and miter saws
- | table saws
- | for clipping and mitre cuts in aluminum profiles

Design

- | neutral hook angle
- | tooth configuration: triple chip / flat "TR-F"
- | cutting material: HW HL Board 08

Advantages

- | burr-free cuts in profiles with low roughness
- | noise-reduction thanks to laser ornaments

Notes

- | tight workpiece clamping required
- | Kaltenbach as counter-bore type

Ø D	B	b	Ø d	Z	NL		Ident-No.
380	3,6	3,0	32	90		Elumatec	189111
420	3,8	3,2	30	102	2/10/70	Rapid, Elumatec	189074
500	4,0	3,4	30	114	2/10/70	Rapid, Elumatec	189075
500	4,0	3,4	32	114	2/12/64	Eisele LMS SCA	189076
550	4,4	3,8	30	126	2/10/70	Elumatec, Kaltenbach, Rapid	189113
[mm]	[mm]	[mm]	[mm]				

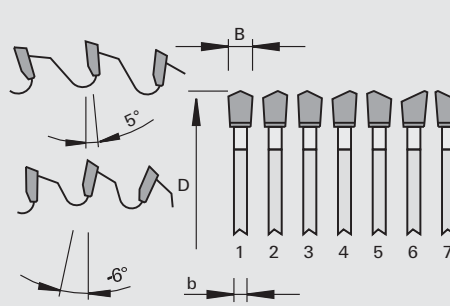
108351 / 108352

NF-Chop Saw Blades HW - profiles "G7"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- | clipping and miter saws
- | table saws
- | clipping and miter cuts in PVC profiles
- | for burr-free and smooth cuts in aluminum window and façade profiles

Design

- | positive or negative hook angle
- | tooth configuration: "G7"
- | cutting material: HW HL Board O6

Advantages

- | reduced cutting pressure thanks to group tooth geometry
- | excellent burr-free cuts with low roughness thanks to tooth partition
- | extremely noise-reduced thanks to special laser ornaments
- | increased edge life compared to chop saw blades with tooth configuration "TR-F"
- | increased performance and economic efficiency

Notes

- | Secure workpiece clamping required
- | Max. wall thickness 5 mm

Ø D	B	b	Ø d	Z	Hook angle	NL	Ident-No.
300	3,2	2,5	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70	192663
350	3,2	2,5	30	98	5	2/7/42 + 2/9/46 + 2/10/60	192662
400	3,8	3,2	30	98	5	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64	192659
420	3,8	3,2	30	98	5		192660
500	4,0	3,4	30	126	5	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64	192661
[mm]	[mm]	[mm]	[mm]		[°]		
Ø D	B	b	Ø d	Z	Hook angle	NL	Ident-No.
250	3,2	2,5	30	84	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	192965
300	3,2	2,5	30	98	-6	2/11/70	192568
350	3,2	2,5	30	112	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	192275
350	3,5	2,8	30	98	-6	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	DeWALT, Haffner, Pfeiffer, Rotox 192274
350	3,8	3,2	40	84	-6	4/12/64 + 2/9/55	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann 192273
380	3,8	3,2	32	112	-6		Elumatec 192567
400	3,8	3,2	30	98	-6	2/10/60 + 2/12/64 + 4/15/80	DeWALT, Haffner 192276
420	4,0	3,2	30	98	-6	2/10/60 + 2/11/70	Rapid, ELU 192277
450	3,8	3,2	30	112	-6	2/12/64 + 4/15/80	DeWALT, Haffner 192278
500	4,0	3,4	30	126	-6	2/11/70 + 2/10/60	Pfeiffer, Rapid 192279
550	4,0	3,4	30	133	-6	2/10/60 + 2/12/64 + 4/15/80	Pfeiffer, Rapid 192392
[mm]	[mm]	[mm]	[mm]		[°]		

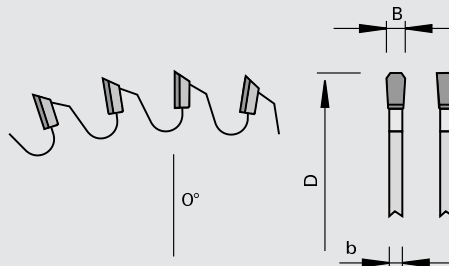
208170

DIAREX NF-Chop Saw Blades DP - Profile "TR-F"

Product



Drawing



Polycrystalline diamond [DP]



Machine / Application

l chop and miter saws
l for clipping and mitre cuts in aluminum profiles

Design

l neutral hook angle
l tooth configuration: triple chip / flat "TR-F"

Advantages

l excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes

l tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
275	3,4	2.8	32	60	4/9/50	Wagner 1994	189868 s
285	3,4	2.8	32	60	4/9/50	Wagner	189869 s
380	3,6	3.0	32	84	4/9/50	Elumatec	189870 s
400	3,8	3.2	40	90	2/12/80	Eisele VA-L 350 NC1	189871 s
500	4,0	3.4	30	114	2/10/70	Elumatec	189872 s
550	4,2	3.6	30	120		Elumatec MGS	189873 s
[mm]	[mm]	[mm]	[mm]				

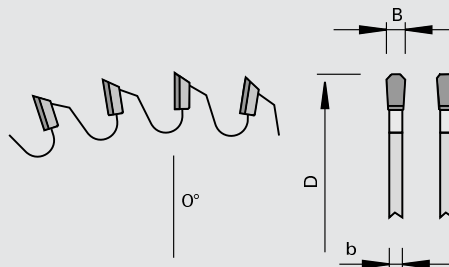
208180

DIAREX NF-Chop Saw Blades DP - Solid "TR-F-FA"

Product



Drawing



Polycrystalline diamond [DP]



Machine / Application

l chop and miter saws
l for miter cuts in solid aluminum materials

Design

l neutral hook angle
l tooth configuration: inverted-v / flat with chamfer "TR-F-FA"

Advantages

l excellent burr-free cuts with low roughness thanks to special laser ornaments and tooth partition

Notes

l tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
500	4,0	3.4	50	90	4/15/80	Kaltenbach RKL 550	189874 s
500	4,0	3.4	30	90		Elumatec	189875 s
550	4,4	3.8	50	96	4/15/80	Kaltenbach RKL 550	189876 s
[mm]	[mm]	[mm]	[mm]				

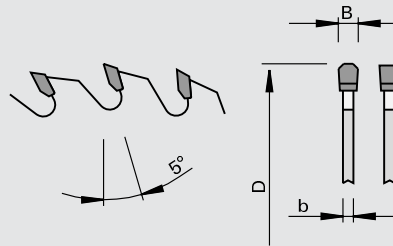
108671

NF-Chop Saw Blades HW - positive hook angle "TR-F" highline

Product



Drawing



LEUCO
highline

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

table saws
for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian, Noblan, Varicor and HPL)

Design

positive hook angle
tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board 10

Advantages

noise-reduction thanks to laser ornaments

Notes

tight workpiece clamping required

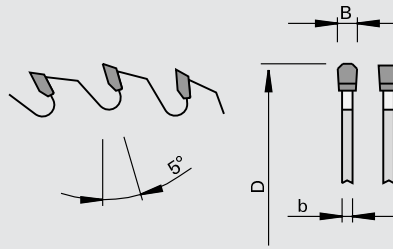
Ø D	B	b	Ø d	Z	NL	Ident-No.
250	3,2	2.5	30	80	2/7/42 + 2/9/46 + 2/10/60	Haffner, ELU, Makita 189877
300	3,2	2.5	30	72	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid 189878
300	3,2	2.5	30	96	2/7/42 + 2/9/46 + 2/10/60	Fezer, Rapid 189879
300	3,2	2.5	32	96		189880 &
[mm]	[mm]	[mm]	[mm]			

108371

NF-Chop Saw Blades HW - positive hook angle "TR-F" topline

Product

Drawing



Tungsten Carbide [HW]



Machine / Application

table saws
for dividing and miter cuts in aluminum and plastic profiles as well as for wood-based panels (Corian, Noblan, Varicor and HPL)

Design

positive hook angle
tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board 06

Advantages

noise-reduction thanks to laser ornaments

Notes

tight workpiece clamping required

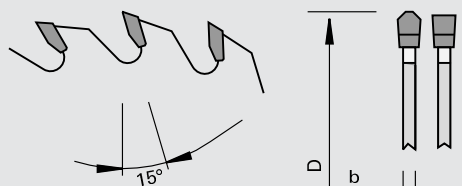
Ø D	B	b	Ø d	Z	NL		Ident-No.
350	3,2	2.5	30	108	2/7/42 + 2/9/46 + 2/10/60	Haffner, Rapid, Pfeffer	193114
350	3,2	2.5	32	92	2/12/64		193113
350	3,2	2.5	32	108	2/12/64		193112
400	3,8	3.2	30	96	4/12/64 + 2/12/80		189882
400	3,8	3.2	40	96	4/12/64 + 2/12/80	Eisele LMS II, LMS III	189883 &
420	3,8	3.2	30	96		ELU DG 102, 104, DLG, MGS 105, Rapid SAT	189884
450	3,8	3.2	40	108	4/12/64 + 2/12/80	Eisele	189885
500	4,0	3.4	30	120	2/10/70 + 2/12/64	Pfeifer, Rapid, BKS	189886
[mm]	[mm]	[mm]	[mm]				

108373

NF-Panel Sizing Saw Blades HW - positive hook angle "TR-F"

Product

Drawing



Tungsten Carbide [HW]



Machine / Application

horizontal panel sizing saws
for dividing cuts in aluminum block materials

Design

tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board 09

Advantages

noise-reduction thanks to laser ornaments

Notes

for stack heights up to 200 mm (for large saw diameters)

Ø D	B	b	Ø d	Z	NL	H		Ident-No.
450	4,5	3.2	40	60	2/13/114	-100	Schelling	189887 s
450	4,8	3.5	60	60	2/14/125 + 2/19/120	-100	Holzma	189891 s
620	5,5	4.2	40	60	2/13/114	110-160	Schelling	189888 s
680	5,8	4.5	40	60	2/13/114	-200	Schelling	189889 s
720	6,0	4.8	40	60	2/13/114	150-220	Schelling	189890 s
[mm]	[mm]	[mm]	[mm]			[mm]		

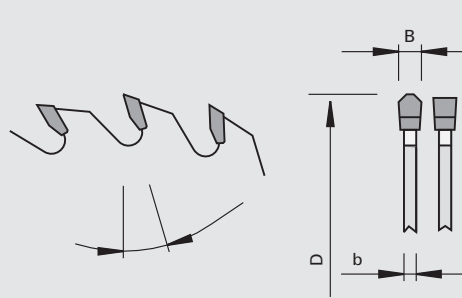
108271

NF-Thin-Kerf-Chop Saw Blades HW - positive hook angle "TR-F"

Product



Drawing



Tungsten Carbide [HW]



Machine / Application

chop saws
for dividing and trimming of aluminum profiles (bars, tubes, ...)

Design

with laser ornaments
tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board O8

Advantages

less vibration and noise thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	Hook angle	NL	Ident-No.	
285	2,0	1,6	32	60	5	4/9/50 + 4/11/63	Kasto Speed C9, Kasto WAC-70, Tsune, Nishijima, Rhobi, Everising, I.T.E.C	189655 s
360	3,4	2,6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189657 s
360	3,4	2,6	50	80	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Kaltenbach KMR-100AP Tsune, Nishijima, Sinico, Endo	189656 s
425	3,4	2,6	50	50	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189658 s
425	3,4	2,6	50	60	5	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15	189659 s
460	3,4	2,6	50	50	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189660 s
460	3,4	2,6	50	60	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189662 s
460	3,4	2,6	50	80	8	4/16/80	Kasto Speed C14/C15, Kasto Variospeed C14/C15, Everising, Noritake	189661 s
[mm]	[mm]	[mm]	[mm]		[°]			

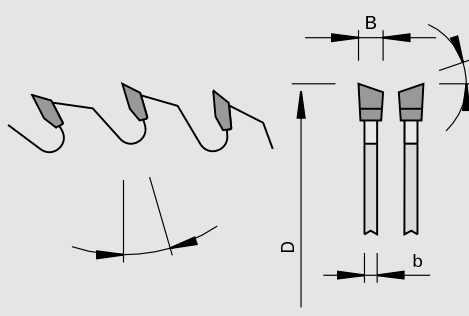
107520

Portable Saw Blades HW "WS"

Product



Drawing



LEUCO
euroline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | portable saws
- | chop and miter saws
- | for ripping and cross cuts in solid woods and wood-based panels

Design

- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board
- 10

Advantages

Notes

- | lower numbers of teeth for solid woods
- | higher numbers of teeth for wood-based panels

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
100	2,4	1.4	12	30		10	50110001
100	2,4	1.4	22	30		10	50110003
105	2,4	1.4	22	30		10	50110006
120	1,8	1.3	20	24		15	50104061
125	2,4	1.6	20	20	2/5,5/30	15	50110011
125	2,4	1.6	20	36	2/6/32,5	10	50110012
130	2,4	1.6	20	20	2/6/32,5	15	50110017
130	2,4	1.6	20	36	2/6/32,5	10	50110018
140	2,4	1.6	20	12	2/6/32,5	20	50110242
140	2,4	1.6	20	20	2/6/32,5	15	50110028
140	2,4	1.6	20	36	2/6/32,5	10	50110029
150	2,6	1.6	20	12	2/6/32,5	20	50110243
150	2,6	1.6	20	24	2/6/32,5	15	50110039
150	2,6	1.6	20	36	2/6/32,5	15	50110040
150	2,6	1.6	20	48	2/6/32,5	10	50110041
150	2,6	1.6	30	24	2/7/42	15	50110042
160	2,6	1.6	16	24	2/6/32,5	15	50110051
160	2,6	1.6	16	48	2/6/32,5	10	50110053
160	2,2	1.6	20	12	2/6/32,5	20	50110244
160	2,2	1.6	20	24	2/6/32,5	15	50110054
160	2,2	1.6	20	36	2/6/32,5	15	50110055
160	2,2	1.6	20	48	2/6/32,5	10	50110056
160	2,6	1.6	30	24	2/7/42	15	50110057
160	2,6	1.6	30	36	2/7/42	15	50110058
160	2,6	1.6	30	48	2/7/42	10	50110059
165	2,6	1.6	20	24	2/6/32,5	15	50110060
165	2,6	1.6	20	36	2/6/32,5	15	50110061
165	2,6	1.6	20	48	2/6/32,5	10	50110062
165	2,6	1.6	30	24	2/7/42	15	50110130
170	2,6	1.6	30	24	2/7/42	20	50110069
170	2,6	1.6	30	36	2/7/42	15	50110070
170	2,6	1.6	30	48	2/7/42	10	50110071
180	2,6	1.6	16	24	2/6/32,5	15	50110081
180	2,6	1.6	16	48	2/6/32,5	10	50110183
180	2,6	1.6	20	14	2/6/32,5	20	50110247
180	2,6	1.6	20	24	2/6/32,5	20	50110075
180	2,6	1.6	20	40	2/6/32,5	15	50110076
180	2,6	1.6	30	14	2/7/42	20	50110248
180	2,6	1.6	30	24	2/7/42	20	50110078
180	2,6	1.6	30	40	2/7/42	15	50110079
180	2,6	1.6	30	54	2/7/42	10	50110080
190	2,6	1.6	16	24	2/6/32,5	15	50110153
[mm]	[mm]	[mm]	[mm]			[°]	

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
190	2,6	1.6	16	30	2/6/32,5	15	50110083
190	2,6	1.6	16	42	2/6/32,5	10	50110084
190	2,6	1.6	20	24	2/6/32,5	15	50110154
190	2,6	1.6	20	30	2/6/32,5	15	50110086
190	2,6	1.6	20	48	2/6/32,5	10	50110087
190	2,6	1.6	30	16	2/7/42	20	50110251
190	2,6	1.6	30	24	2/7/42	20	50110155
190	2,6	1.6	30	30	2/7/42	15	50110089
190	2,6	1.6	30	48	2/7/42	10	50110090
190	2,6	1.6	30	60	2/7/42	10	50110091
200	2,8	1.8	30	18	2/7/42	20	50110252
200	2,8	1.8	30	30	2/7/42	15	50110095
200	2,8	1.8	30	48	2/7/42	15	50110096
200	2,8	1.8	30	60	2/7/42	10	50110097
205	2,6	1.8	18	30		15	50110286
210	2,8	1.8	30	18	2/7/42	20	50110253
210	2,8	1.8	30	30	2/7/42	15	50110104
210	2,8	1.8	30	48	2/7/42	15	50110105
210	2,8	1.8	30	60	2/7/42	10	50110106
216	2,8	1.8	30	30	2/7/42	20	50110107
216	2,8	1.8	30	48	2/7/42	15	50110108
216	2,8	1.8	30	60	2/7/42	10	50110109
220	2,8	1.8	30	24	2/7/42	15	50110164
220	2,8	1.8	30	36	2/7/42	15	50110110
220	2,8	1.8	30	48	2/7/42	15	50110111
220	2,8	1.8	30	64	2/7/42	10	50110112
225	2,8	1.8	30	24	2/7/42	15	50110165
225	2,8	1.8	30	34	2/7/42	15	50110228
225	2,8	1.8	30	48	2/7/42	10	50110237
230	2,8	1.8	30	18	2/7/42	20	50110255
230	2,8	1.8	30	24	2/7/42	15	50110168
230	2,8	1.8	30	36	2/7/42	15	50110113
230	2,8	1.8	30	48	2/7/42	15	50110114
230	2,8	1.8	30	64	2/7/42	10	50110115
235	2,8	1.8	30	18	2/7/42	20	50110256
235	2,8	1.8	30	24	2/7/42	15	50110170
235	2,8	1.8	30	36	2/7/42	15	50110117
240	2,8	1.8	30	24	2/7/42	20	50110174
240	2,8	1.8	30	36	2/7/42	15	50110123
240	2,8	1.8	30	48	2/7/42	15	50110124
235	2,8	1.8	30	48	2/7/42	15	58110121
235	2,8	1.8	30	64	2/7/42	10	58110118
250	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58120060
250	3,2	2.2	30	30	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58120061
250	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100018
250	3,2	2.2	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100026
250	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100031
250	3,2	2.2	30	80	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100038
254	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58120067
254	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58120068
260	3,2	2.2	30	32	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58110185
260	3,2	2.2	30	40	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110175
260	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58100254
[mm]	[mm]	[mm]	[mm]			[°]	

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
270	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58110176
270	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110182
280	3,2	2.2	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110136
[mm]	[mm]	[mm]	[mm]			[°]	

108472

Portable Saw Blades HW "TR-F"

Product	Drawing	LEUCO proline
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable saws for ripping and cross cuts in wood-based panels, NF-metals and solid woods 	<ul style="list-style-type: none"> negative hook angle tooth configuration: triple chip / flat "TR-F" cutting material: HW HL Board 10 		

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
150	2,8	2.2	20	42	2/6/32,5	-6	58115002
160	2,2	1.6	20	42	2/6/32,5	-6	58115004
160	2,2	1.6	20	56	2/6/32,5	-6	58115042
160	2,8	2.2	30	42	2/7/42	-6	58115026
180	2,8	2.2	20	48	2/6/32,5	-6	58115007
180	2,8	2.2	30	48	2/7/42	-6	58115008
190	2,8	2.2	20	54	2/6/32,5	-6	58115009
190	2,8	2.2	30	54	2/7/42	-6	58115010
200	2,8	2.2	30	54	2/7/42	-6	58115011
210	2,8	2.2	30	54	2/7/42	-6	58115012
216	2,8	2.2	30	60	2/7/42	-6	58115024
216	2,8	2.2	30	80	2/7/42	-6	58115034
220	2,8	2.2	30	54	2/7/42	-6	58115021
230	2,8	2.2	30	64	2/7/42	-6	58115014
235	2,8	2.2	30	64	2/7/42	-6	58115018
[mm]	[mm]	[mm]	[mm]			[°]	

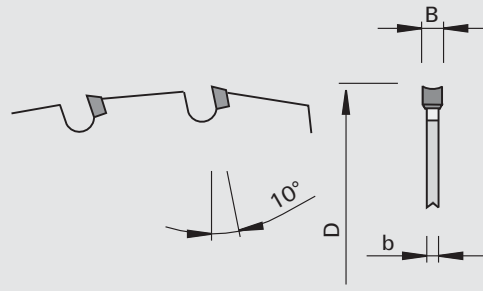
207289

Portable Saw Blades DP "HR" - nn-System DP flex

Product



Drawing



LEUCO
nn-system



Polycrystalline diamond [DP]



Machine / Application

- | portable saws
- | clipping saws
- | for precise cutting in all common wood-based panels and ledges
- | for ripping and cross cuts in solid woods
- | suitable for many materials including façade boards

Design

- | tooth configuration: hollow back tooth "HR"
- | cutting material: DP
- | special cutting edge geometry
- | small gullets

Advantages

- | highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- | reduced cutting pressure thanks to hollow back tooth geometry

Notes



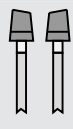

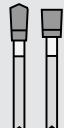

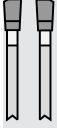

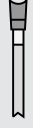
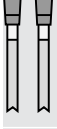

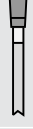
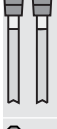
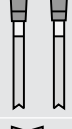
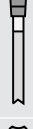


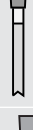


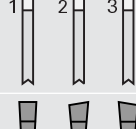


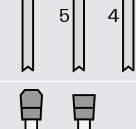

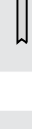
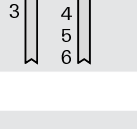
- | Clean your nn-System DP flex saw blades regularly. You will profit from a long-lasting and precise cutting quality and maximize the edge lives of your innovative saw blades many times over.

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
160	2,2	1.6	20	20	2/6/32,5	10	192980
160	2,2	1.8	20	30	2/6/32,5	10	192981
216	2,5	2.0	30	40		10	192982
[mm]	[mm]	[mm]	[mm]			[°]	

Tooth configuration

The tooth design has a big influence on the edge quality and is depending on the following factors:

- | workpiece material
- | mode of application (with and across the grain)
- | direction of cut (along / across the grain)

	F	Flat		DA	Inverted-v		KO-WS	Conical-alternate bevel
	F-FA	Flat with chamfers on both sides		DA-F	Inverted-v + flat		KO-HR-FA	Conical hollow back with chamfer
	F-WFA	Flat with alternating chamfer		DA-F-FA	Inverted-v + flat with chamfer		D	Hollow-ground
	WS	Alternate top bevel		DA-D	Inverted-v + hollow-ground		D-FA	Hollow-ground with two-sided chamfer
	WS-FA	Alternate top bevel with chamfer		DA-D-FA	Inverted-v + hollow-ground with chamfer		HR	Hollow back
	TR	Triple-chip		ES	Top bevel		HR-FA	Hollow back with chamfer
	TR-F	Triple-chip + flat		ES-L	Top bevel, left		G3	G3
	TR-F-FA	Triple-chip + flat with chamfer		ES-R	Top bevel, right		G5	G5
	TR-TR	Triple-chip + triple-chip		KO-F	Conical-flat		G6	G6

Number of teeth

The number of cutting edges subject to feed rate is to be found in section tool description on the respective pages. It is depending on the following criteria:

- | feed
- | RPM of the spindle
- | diameter of the circular saw blade
- | workpiece material
- | cutting quality (sizing cut / finish cut)
- | cutting height (single boards / stack)
- | stack height (no. of single boards)
- | pass

Cutting speed (standard values)

HW Saw Blades

Workpiece material	Cutting speed vc [m/s]
Al-Mg-Cu	40 - 60
Al-Si alloys	15 - 40
Panels veneered both sides	60 - 90
Thermosets (Pertinax®, Restitex®, etc.)	15 - 50
Exotic woods	50 - 85
Veneers	70 - 100
Gypsum plaster boards	40 - 65
Hardboards	50 - 80
Hard woods	60 - 100
Plastic laminated particle boards	60 - 80
Plastic profiles without filling	30 - 70
Pressed laminated woods	40 - 65
Pure aluminum	60 - 80
Raw particle boards	50 - 80
Laminated boards	60 - 80
Laminates, hard paper, fabric	50 - 70
Particle boards	60 - 80
Plywood boards	50 - 80
Thermoplastic (PA, PE, PMMA etc.)	30 - 70
Wood core plywood	50 - 90
Condensed woods	40 - 65
Soft fiber boards	60 - 100
Soft woods	60 - 100
Cement bonded boards	40 - 60

DP Saw Blades

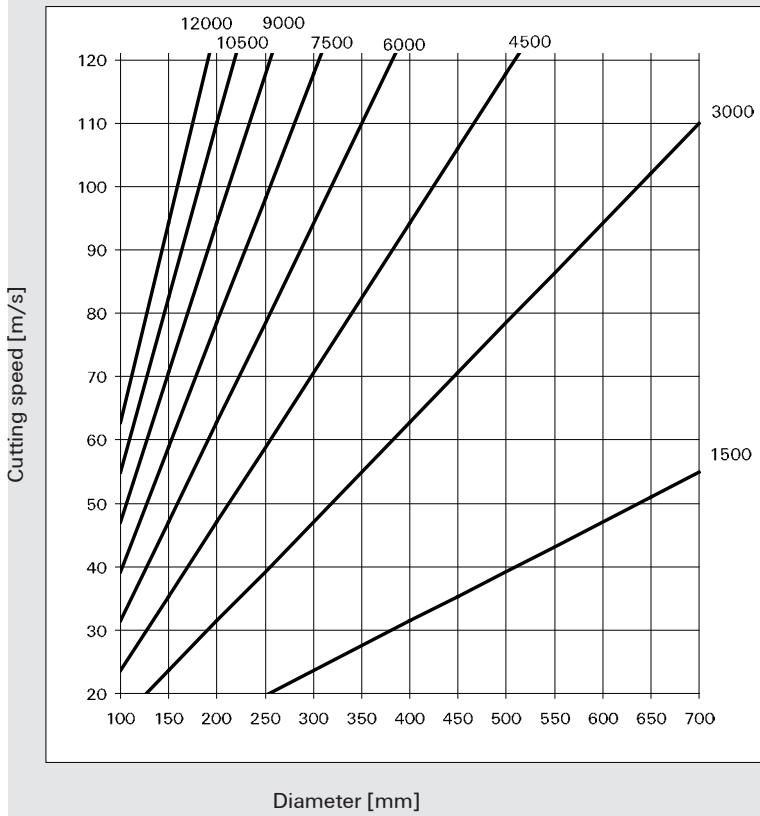
Workpiece material	Cutting speed vc [m/s]
CFRP, GFRP	40 - 60
Thermosets (Pertinax®, Restitex®, etc.)	50 - 80
Polymer bound boards (Corian®, Varicor®)	60 - 90
Pressed laminated woods	40 - 60
Laminated particle boards and MDF boards	50 - 80
Foil-coated particle boards and MDF boards	64 - 100
Veneered particle boards and MDF boards	65 - 100
Raw particle boards and MDF boards	65 - 100
Plywood boards	65 - 100
Thermoplastic (PA, PE, PMMA etc.)	60 - 90
Wood core plywood	60 - 80
Condensed woods	70 - 100
	50 - 80

Feed rate per tooth

HW Saw Blades

Workpiece material	Feed rate per tooth fz [mm]
Al-Mg-Cu	0,05 - 0,12
Al-Si alloys	0,03 - 0,08
Panels veneered both sides	0,03 - 0,10
Thermosets (Pertinax®, Restitex®, etc.)	0,02 - 0,05
Hardboards	0,03 - 0,08
Plastic laminated particle boards	0,03 - 0,15
Plastic profiles without filling	0,03 - 0,15
Solid wood with the grain	0,10 - 0,50
Solid wood across the grain	0,02 - 0,20
Polymer bound boards (Corian®, Varicor®)	0,05 - 0,15
Pure aluminum	0,05 - 0,12
Particle boards, MDF boards	0,05 - 0,25
Plywood boards	0,05 - 0,25
Thermoplastic (PA, PE, PMMA etc.)	0,05 - 0,08

Determination of RPM [min-1]



Order / Inquiry for Special Tools: Circular Saw Blades

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	<input type="radio"/>
Company:	_____	Inquiry:	<input type="radio"/>
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Maker: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Flange diameter [mm]: _____

Motor output [kW]: _____

Type of machine:

One shaft	<input type="radio"/>
Two shafts	<input type="radio"/>

Mode of application:

Against feed:

From top	<input type="radio"/>
From bottom	<input type="radio"/>

With feed:

From top	<input type="radio"/>
From bottom	<input type="radio"/>

Workpiece

Description: _____

Cut height [mm]: _____

Type of cut:

Single	<input type="radio"/>
Stack	<input type="radio"/>

Cutting quality:

Coarse	<input type="radio"/>
Trimming cut	<input type="radio"/>
Finish cut	<input type="radio"/>

For solid wood:

With grain	<input type="radio"/>
Across grain	<input type="radio"/>

For wood-based panels:

Sizing	<input type="radio"/>
Trimming	<input type="radio"/>

Tool

Cutting diameter D [mm]: _____

Cutting width B [mm]: _____

Saw plate thickness b [mm]: _____

Bore diameter d [mm]: _____

Countersinks and recesses

No. of countersinks: _____

Bore diameter db [mm]: _____

Countersink diameter ds [mm]: _____

Position angle α [°]: _____

Boring circle diameter Dt [mm]: _____

No. of recesses:

Double keyway:		Width bk	Height hk
Keyway:		Width bk	Height hk

Pin holes:

No.	Ø NL	Ø TK

Countersinks (per drawing):

Cut-outs for hoggers (per drawing):

No. of teeth [pcs.]: _____

Rakers:

Tooth configuration:

Flat	<input type="radio"/>
Alternate top bevel	<input type="radio"/>
Top bevel	<input type="radio"/>
Hollow-ground	<input type="radio"/>
Triple-chip	<input type="radio"/>
Inverted-v	<input type="radio"/>
Conical-alternate bevel	<input type="radio"/>
Hollow-ground / chamfer	<input type="radio"/>
Triple chip / flat	<input type="radio"/>
ATB / flat	<input type="radio"/>

With relieved tool body:

Hub location (per drawing):

A	<input type="radio"/>	B	<input type="radio"/>
---	-----------------------	---	-----------------------

Hub diameter D1 [mm]: _____

Hub width b1 [mm]: _____

Sense of rotation:

Right	<input type="radio"/>	Left	<input type="radio"/>
Single	<input type="radio"/>	Set	<input type="radio"/>

Check if applicable

Order / Inquiry for Special Tools: Circular Saw Blades

Name: _____ City and Date: _____

Product line

- topline
- proline
- euroline (only portable saw blades)

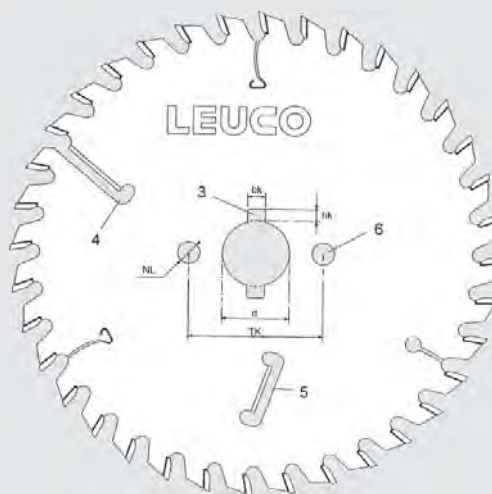
Cutting material

- Carbide
- Diamond
- Stellite
- HS

Please indicate additional dimension and markings in the schematic drawing.

Tool body

- 3 Double keyway
- 6 Pin hole
- d
- bk Width of keyway
- hk Height of keyway
- TK Reference diameter
- NL Pin hole diameter

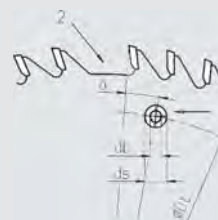


Additional tool body elements:

- 4 Raker with carbide cutting edge enclosed
- 5 Raker with carbide cutting edge open

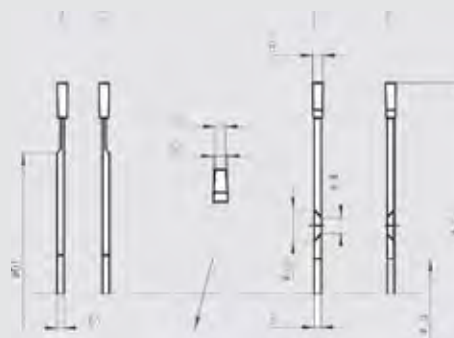
Countersink and cut-out for hoggers

- 1 Countersink for countersunk flat headed screw
- 2 Cut-out for hoggers
- db Bore diameter
- ds Countersink diameter
- α Position angle
- Dt Boring circle diameter



Tool body

- D Cutting diameter
- b Saw plate thickness
- d Bore
- D1 Hub diameter
- b1 Hub width
- B1 Cutting width
- B2 Cutting width
- A/B Hub location
- db Bore diameter
- ds Countersink diameter



Sense of rotation

- L Left
- R Right

Checklist for NF customers

Customer-no.:	_____	Contact partner:	_____
Company:	_____	Function:	_____
Plant:	_____	Phone:	_____
Street:	_____	Fax:	_____
Zip / City:	_____	E-mail:	_____
Country:	_____		_____

Machine data

Maker: _____

Model: _____

Year of manufacture: _____

Driving power [kW]: _____

RPM [min-1]: Min _____ Max _____

Type of feed: MAN MEC

Cutting speed vc [m/min] max: _____

Type of machine:

Panel sizing saw: panel height [mm]: _____

Chop saw: Saw Blade From top _____

From bottom _____

Other _____

Workpiece

Workpiece material: _____

Workpiece material No.: _____

Workpiece clamping: _____

Workpiece form: _____

(E.g. round, tube, profile, block, etc.)

Dimension: _____

For profiles, wall thickness [mm]: _____

Application data

Feed rate vf [m/min]: _____

Cooling (spraying, dry, etc.): _____

Cutting speed vc [m/min]: _____

Rotations per minute (RPM) [min-1] _____

Saw Blade in current application

Maker: _____

Diameter [mm]: _____

Bore [mm]: _____

Cutting height [mm]: _____

No. of teeth [pcs.]: _____

Hook angle [°]: _____

Cutting material: _____

Flange diameter [mm]: _____

Pin holes: _____

Saw plate thickness b [mm]: _____

Tooth configuration:

Uneven pitch: Yes No

Low-noise design: Yes No

Requirements with regards to cutting quality

Cutting time [sec]: _____

Surface quality: _____

Tool life (no. of cuts): _____

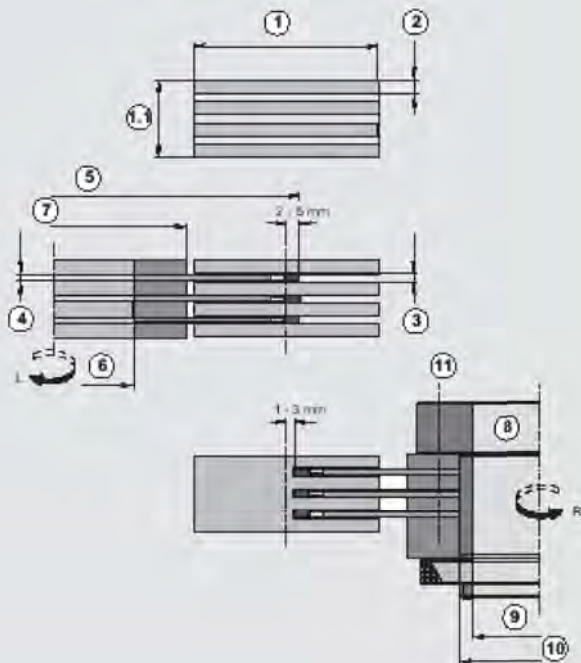
Misc.: _____

Notes

503-01.0106

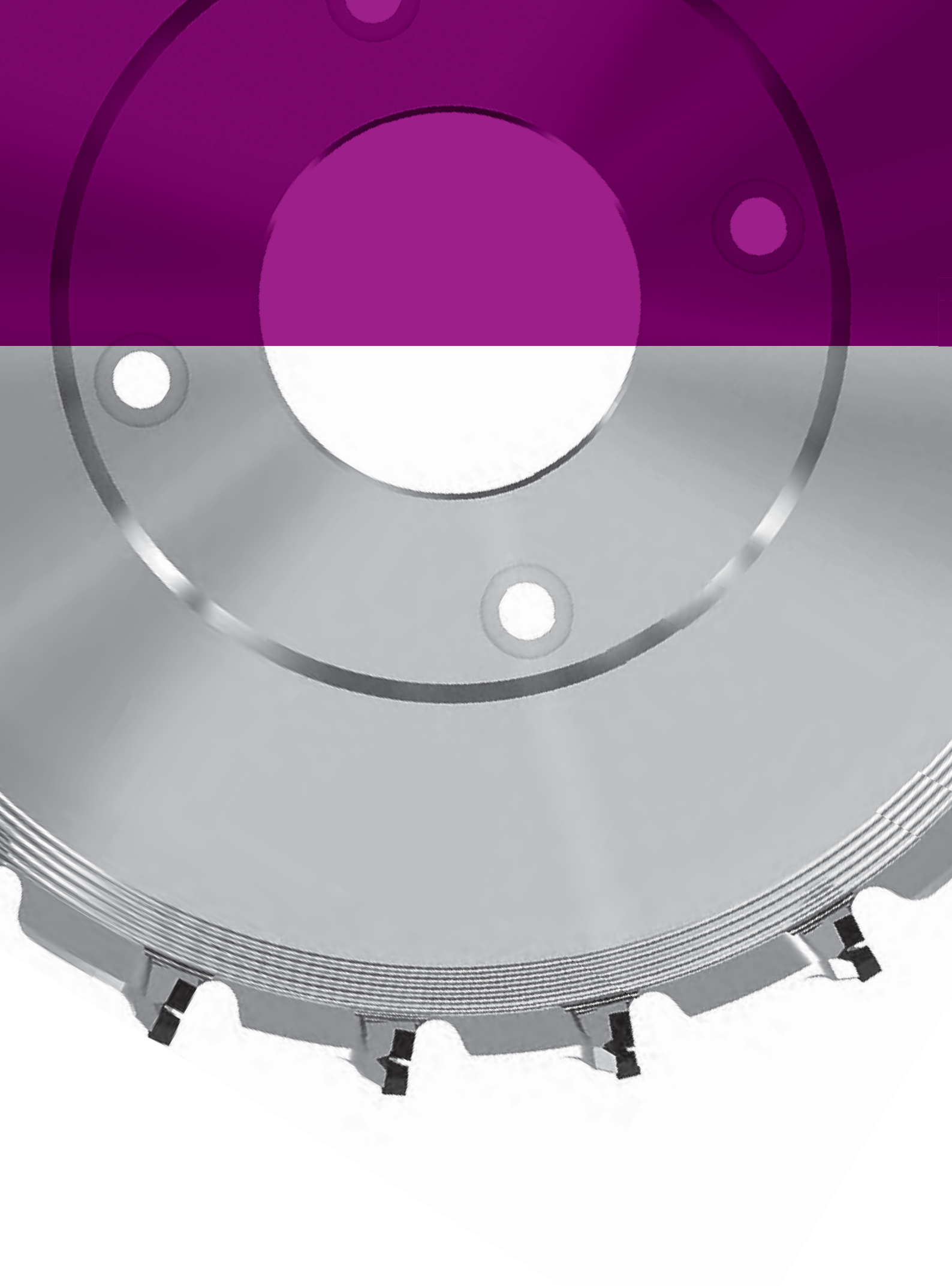
Thin-Kerf Saw Blades on splitting machines

Customer-no.:	_____	Contact partner:	_____
Company:	_____	Function:	_____
Plant:	_____	Phone:	_____
Street:	_____	Fax:	_____
Zip / City:	_____	E-mail:	_____
Country:	_____		



1.1 Wood type:	_____	Humidity [%]:	_____	No. of saw blades per spindle [pcs.]:	_____
0 Slat dimension: thickness	_____	Length [mm]:	_____	Edge saw blade:	Yes <input type="radio"/> No <input type="radio"/>
1 Lamella width [mm]:	_____			Current dimension:	_____
2 Lamella thickness [mm]:	_____			Saw Blades in current application (dimension):	_____
3 Cutting width [mm]:	_____			RPM [min-1]:	_____
4 Saw plate thickness b [mm]:	_____			Feed rate [m/min]:	_____
5 Saw blade diameter [mm]:	_____			Spindle diameter [mm]:	_____
6 Bore diameter [mm]:	_____			Spindle length [mm]:	_____
7 Flange diameter [mm]:	_____			Driving pin:	
8 Bushing: hydro	Yes <input type="radio"/> No <input type="radio"/>			Spindle / Bushing:	Top <input type="radio"/> Bottom <input type="radio"/>
9 Bushing inside diameter [mm]:	_____			Diameter [mm]:	_____
10 Bushing outside diameter [mm]:	_____			Pitch circle diameter [mm]:	_____
11 Pin holes:	_____	DKN:	_____		

508-01.1006





Hoggers

Product	Page
PowerTec Hoggers	2-1
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CompactTec Hoggers	2-6
Segment Hoggers	2-11
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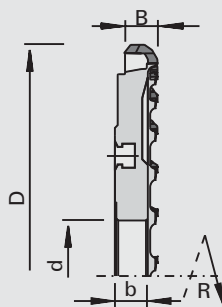
215032

PowerTec airFace Hoggers DP for LEUCO s-System Ø 160 mm and Ø 192 mm (DZ)

Product



Drawing



LEUCO
topline

LEUCO
powertec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | For chip-free and low-noise sizing of raw, melamine-coated, paper-laminated, foil-coated and veneered wood-based materials as well as HPL materials, with a focus on durability and economic efficiency

Design

- | Resharpener area 4 mm
- | n max= 7,200 rpm
- | LEUCO airFace design: reduced vibration and aerodynamic properties
- | Polished quality cutting edge for optimum cutting quality
- | Division of cut into low-noise hogger tooth and finish-cut tooth for optimum quality with rounded edges on one wing

Advantages

- | Very long edge live thanks to optimized tooth shape
- | Noise reduction during idling and machining thanks to airFace design
- | Cutting width consistency over the entire tool life
- | High feed rates achievable
- | Low total cost/running meter ratio
- | Machining of panels from 8 mm thickness possible
- | Good chip removal
- | Compatible with a wide variety of clamping systems

Notes

- | for double hogging process (DZ)
- | application with feed sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	9,5	23	60	16+8	28	s-System Ø 160	186526	186525
250	9,5	23	60	20+10	45	s-System Ø 160	186528	186527
250	9,5	23	60	28+14	60	s-System Ø 160	186530	186529
250	9,5	23	60	36+18	80	s-System Ø 160	186532 s	186531 s
250	14,5	23	60	16+8+4	28	s-System Ø 160	186540 s	186539 s
250	14,5	23	60	20+10+5	45	s-System Ø 160	186534 s	186533 s
250	14,5	23	60	28+14+7	60	s-System Ø 160	186536 s	186535 s
250	14,5	23	60	36+18+9	80	s-System Ø 160	186538 s	186537 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	9,5	23	80	16+8	28	s-System Ø 192	186542	186541
250	9,5	23	80	20+10	45	s-System Ø 192	186544 s	186543 s
250	14,5	23	80	16+8+4	28	s-System Ø 192	186546 s	186545 s
250	14,5	23	80	20+10+5	45	s-System Ø 192	186548 s	186547 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

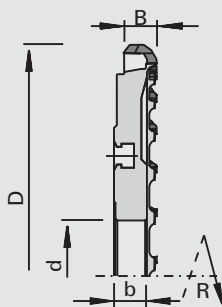
215332

PowerTec airFace S Hoggers DP for LEUCO s-System Ø 160 mm and Ø 192 mm (DZ)

Product



Drawing



LEUCO
topline

LEUCO
powertec
airFace S

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- Ideally suited for chip-free and low-noise sizing of raw, melamine-coated, paper-laminated, foil-coated and veneered wood-based materials as well as HPL materials, with a focus on durability and economic efficiency

Design

- Resharpener area 4 mm
- n max= 7,200 rpm
- LEUCO airFace design: reduced vibration and aerodynamic properties
- Polished quality cutting edge for optimum cutting quality
- Division of cut into low-noise hogger tooth and finish-cut tooth for optimum quality with rounded edges on one wing
- Full number of teeth for peripheral cutting edge and hogger tooth

Advantages

- Extremely long edge live thanks to optimized tooth shape and reinforced DP cutting edges
- Noise reduction during idling and machining thanks to airFace design
- Cutting width consistency over the entire tool life
- High feed rates achievable
- Low total cost/running meter ratio
- Machining of panels from 8 mm thickness possible
- Good chip removal
- Compatible with a wide variety of clamping systems

Notes

- for double hogging process (DZ)
- application with feed
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	9,5	23	60	16+16	28	s-System Ø 160	186550 s	186549 s
250	9,5	23	60	20+20	45	s-System Ø 160	186552	186551
250	9,5	23	60	28+28	60	s-System Ø 160	186554	186553
250	9,5	23	60	36+36	80	s-System Ø 160	186556	186555
250	14,5	23	60	16+16+4	28	s-System Ø 160	186558 s	186557 s
250	14,5	23	60	20+20+5	45	s-System Ø 160	186560 s	186559 s
250	14,5	23	60	28+28+7	60	s-System Ø 160	186562 s	186561 s
250	14,5	23	60	36+36+9	80	s-System Ø 160	186564 s	186563 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	9,5	23	80	16+16	28	s-System Ø 192	186566 s	186565 s
250	9,5	23	80	20+20	45	s-System Ø 192	186568	186567
250	14,5	23	80	20+20+5	45	s-System Ø 192	186570 s	186569 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

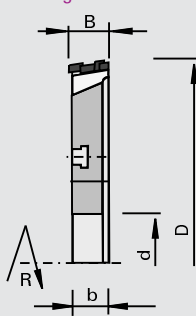
215044

UniTec Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO
unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- resharpenable area 4 mm
- n max = 6,000 min-1
- division of cut in pre-cut and re-cut tooth

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- reduced suction performance
- high quality of cut due to division of cut
- long edge lives thanks to optimized tooth form

Notes

- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,0-5,0	23	60	24+12	30	182115 s	182114 s
250	8-5	23	60	36+18	45	182031	182030
250	8,0-5,0	23	60	48+24	60	182033	182032
250	8,0-5,0	23	60	54+27	70	182035 s	182034 s
250	16-13	23	60	36+18+6	45	182037 s	182036 s
250	16-13	23	60	48+24+6	60	182039	182038
250	16-13	23	60	54+27+9	70	182041 s	182040 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

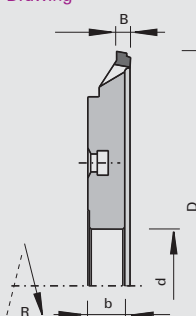
215044

UniTec A Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO
unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- resharpening area 4 mm
- n max = 6,000 min-1
- division of cut in pre-cut and re-cut tooth
- ascending chamfer at the step

Advantages

- improved chip evacuation integrated into the tool (ChipMeister)
- reduced cleaning efforts
- reduced suction performance
- high quality of cut due to division of cut
- long edge lives thanks to optimized tooth form

Notes

- machining of 8 mm boards is also possible
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,2-4,7	23	60	36+18	40	183473 s	183472 s
250	8,2-4,7	23	60	48+24	50	183475 s	183474 s
250	8,2-4,7	23	60	60+30	75	183477 s	183476 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

215044

UniTec Veneer Hoggers CM DP for LEUCO s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO
unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | for chip-free sizing of veneered panels

Design

- | DP-tipped
- | resharping area 4 mm
- | n max = 6,000 min-1
- | HS insert sets Z=2+2 for hogging of excess veneer

Advantages

- | improved chip evacuation integrated into the tool (ChipMeister)
- | reduced cleaning efforts
- | high cutting quality for veneered panels due to division of cut
- | long edge lives thanks to optimized tooth form
- | low power consumption
- | safe hogging of excess veneer
- | no formation of strips
- | no clogging of the exhaustion

Notes

- | machining of 8 mm boards is also possible
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | sense of rotation according to DIN-EN 50144

Ø D	B	B1	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250 [mm]	34-31,5 [mm]	10-7,6 [mm]	23 [mm]	60 [mm]	48+24	60 [m/min]	182647 s	182646 s

Spare parts

	Class-No.	PU	Ident-No.
HS insert	332921	4	50570980 [pc.]

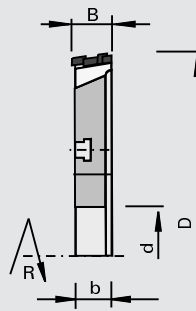
215044

UniTec Hoggers CM DP for LEUCO s-System Ø 192 mm (RZ/DZ)

Product



Drawing



LEUCO
unitec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | resharpening area 4 mm
- | n max = 6,000 min⁻¹
- | division of cut in pre-cut and re-cut tooth

Advantages

- | improved chip evacuation integrated into the tool (ChipMeister)
- | reduced cleaning efforts
- | reduced suction performance
- | high quality of cut due to division of cut
- | long edge lives thanks to optimized tooth form

Notes

- | especially for particle boards with loose core, recycling particle boards, particle boards with sensitive coating
- | machining of 8 mm boards is also possible
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | application with feed
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8,0-5,0	23	80	24+12	30	182117 s	182116 s
250	8,0-5,0	23	80	36+18	45	182119	182118
250	8,0-5,0	23	80	48+24	60	182121 s	182120 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

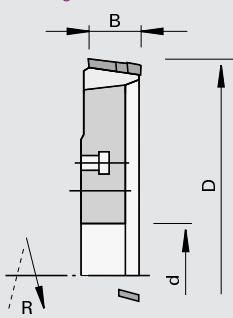
215082

CompactTec N Hoggers CM DP for LEUCO Hydro s-System Ø 160 mm and Bushing (RZ/DZ)

Product



Drawing



LEUCO
compacttec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double-end tenoners
- | edge banding machines
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | negative hook angle
- | tooth configuration chamfer ascending
- | with shear angle
- | resharpenable area 4 mm

Advantages

- | improved chip evacuation thanks to chip evacuation integrated in the tool (Chip-Meister)
- | reduced cleaning effort
- | reduction of suction power
- | long edge lives thanks to negative hook angle
- | minimal machine downtimes thanks to long edge lives
- | excellent cutting quality thanks to high concentric and runout accuracy

Notes

- | for scoring/hogging (RZ) and double hogging (DZ) process
- | application with feed for cutting with and across the grain
- | resharpenable on the flanks
- | the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	20-17	20	60	30+5+5	30	182537 s	182536 s
250	20-17	20	60	36+6+6	35	182539 s	182538 s
250	20-17	20	60	48+6+6	50	182541 s	182540 s
250	20-17	20	60	72+8+8	80	182545 s	182544 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

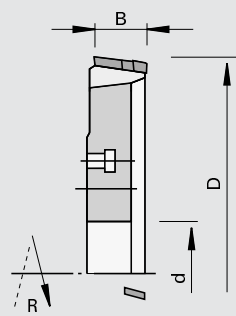
215082

CompactTec N Hoggers CM DP for LEUCO s-System Ø 192 mm (RZ/DZ)

Product



Drawing



LEUCO
compacttec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge trimming machines
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | negative hook angle
- | tooth configuration chamfer ascending
- | with shear angle
- | resharpenable area 4 mm

Advantages

- | improved chip evacuation thanks to chip evacuation integrated in the tool (Chip-Meister)
- | reduced cleaning effort
- | reduction of suction power
- | long edge lives thanks to negative hook angle
- | minimal machine downtimes thanks to long edge lives
- | excellent cutting quality thanks to high concentric and runout accuracy

Notes

- | for scoring/hogging (RZ) and double hogging (DZ) process
- | application with feed for cutting with and across the grain
- | sides of teeth can be resharpened
- | the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	20-17	20	80	30+5+5	30	182547 s	182546 s
250	20-17	20	80	36+6+6	35	182549 s	182548 s
250	20-17	20	80	48+6+6	50	182551 s	182550 s
250	20-17	20	80	72+8+8	80	182555 s	182554 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

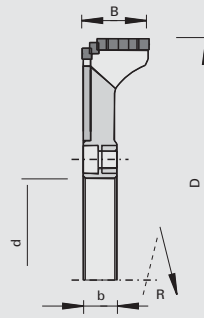
215089

Compact Hogger DP - for dividing laminate boards

Product



Drawing



LEUCO
compacttec

Polycrystalline diamond [DP]

MEC

Machine / Application

- | panel sizing saws
- | laminate flooring

Design

- | open gullet
- | with shear angle
- | resharpening area 4 mm

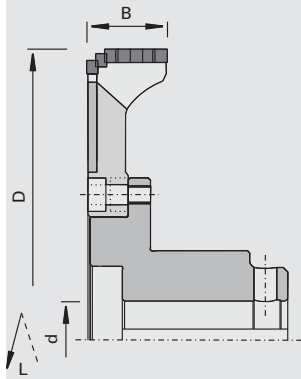
Advantages

- | improved chip evacuation thanks to shear angle
- | optimal positioning of knives from hogger to saw blade
- | reduction of scouring on the tool

Notes

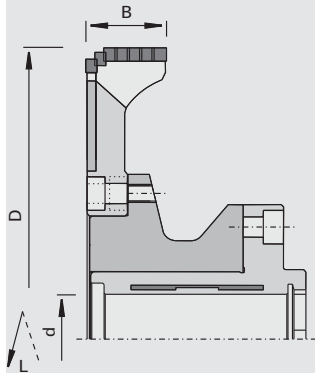
- | application against feed for cutting along and across the grain
- | sense of rotation according to DIN-EN 50144

Hogger on special flange 35 DKN 189750



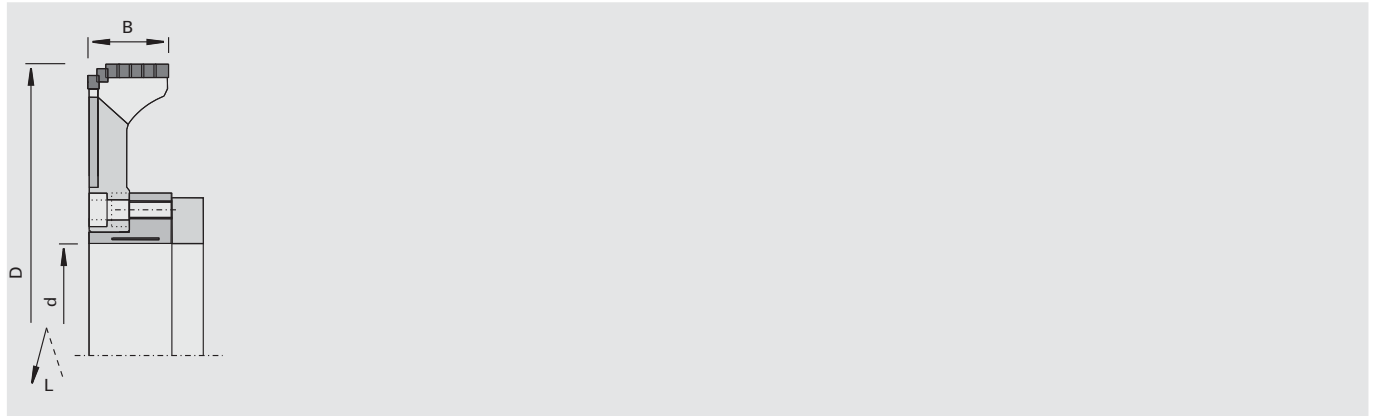
Ø D	B	Ø d	DKN	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	35	10x4	48+24+12+12	2x4/8/130	189737 s	189738 s
260	25	35	10x4	48+24+12+12	2x4/8/130	189739 s	189740 s
260	36	35	10x4	48+24+12+12	2x4/8/130	189741 s	189742 s
260	18	35	10x4	36+18+9+9	2x4/8/130	189743 s	189744 s
260	25	35	10x4	36+18+9+9	2x4/8/130	189745 s	189746 s
260	36	35	10x4	36+18+9+9	2x4/8/130	189747 s	189748 s
[mm]	[mm]	[mm]	[mm]				

Hogger on hydro bushing 172678 with special flange 189749



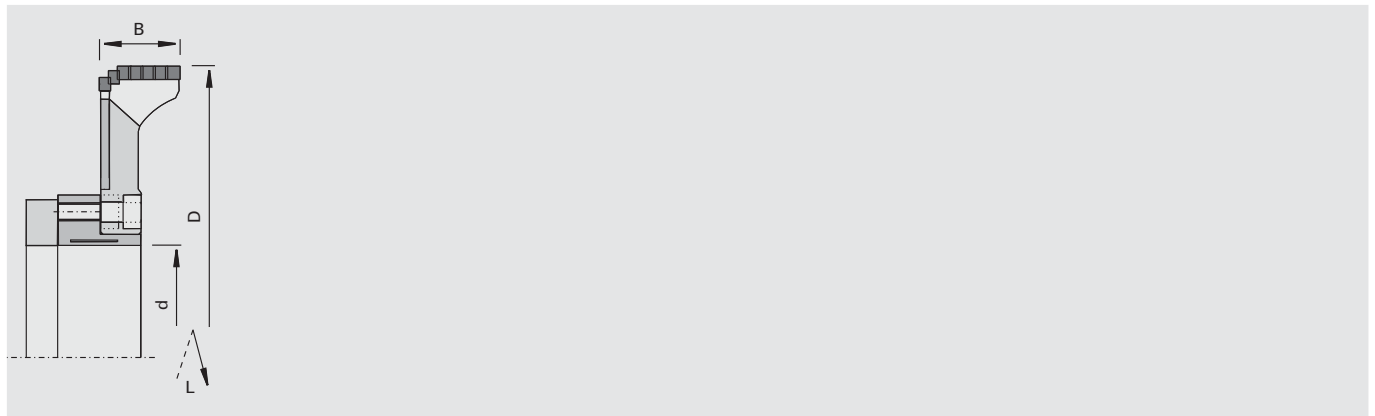
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	40	48+24+12+12	2x4/8/130	189752 s	189753 s
260	25	40	48+24+12+12	2x4/8/130	189754 s	189755 s
260	36	40	48+24+12+12	2x4/8/130	189756 s	189757 s
260	18	40	36+18+9+9	2x4/8/130	189758 s	189759 s
260	25	40	36+18+9+9	2x4/8/130	189760 s	189761 s
260	36	40	36+18+9+9	2x4/8/130	189762 s	189763 s
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183821 - saw blade away from the spindle (version 1)



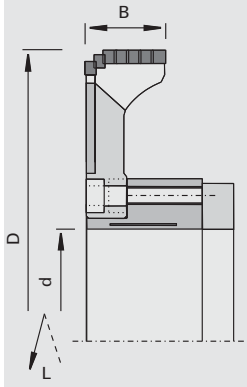
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189809 s	189810 s
260	25	100	48+24+12+12	2x4/8/130	189811 s	189812 s
260	36	100	48+24+12+12	2x4/8/130	189813 s	189814 s
260	18	100	36+18+9+9	2x4/8/130	189815 s	189816 s
260	25	100	36+18+9+9	2x4/8/130	189817 s	189818 s
260	36	100	36+18+9+9	2x4/8/130	189819 s	189820 s
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183821 - saw blade towards the spindle (version 2)



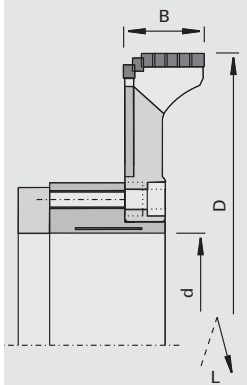
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189821 s	189822 s
260	25	100	48+24+12+12	2x4/8/130	189823 s	189824 s
260	36	100	48+24+12+12	2x4/8/130	189825 s	189826 s
260	18	100	36+18+9+9	2x4/8/130	189827 s	189828 s
260	25	100	36+18+9+9	2x4/8/130	189829 s	189830 s
260	36	100	36+18+9+9	2x4/8/130	189831 s	189832 s
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183829 - saw blade away from the spindle (version 1)



Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189764 s	189765 s
260	25	100	48+24+12+12	2x4/8/130	189766 s	189767 s
260	36	100	48+24+12+12	2x4/8/130	189768 s	189769 s
260	18	100	36+18+9+9	2x4/8/130	189770 s	189771 s
260	25	100	36+18+9+9	2x4/8/130	189772 s	189773 s
260	36	100	36+18+9+9	2x4/8/130	189774 s	189775 s
[mm]	[mm]	[mm]				

Hogger on hydro bushing 183829 - saw blade towards the spindle (version 2)



Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189776 s	189777 s
260	25	100	48+24+12+12	2x4/8/130	189778 s	189779 s
260	36	100	48+24+12+12	2x4/8/130	189780 s	189781 s
260	18	100	36+18+9+9	2x4/8/130	189782 s	189783 s
260	25	100	36+18+9+9	2x4/8/130	189784 s	189785 s
260	36	100	36+18+9+9	2x4/8/130	189786 s	189787 s
[mm]	[mm]	[mm]				

Attachment Sleeves and Flanges	Dimension	Class-No.	PU	Ident-No.
Hydro Clamping Bushing	Ø120x96xØ60/40	933030	1	172678
attachment flange for hydro clamping bushing 172678	Ø147x69,4xØ110/60	997300	1	189749s
Attachment Sleeves	Ø145x89,4xØ110/35 DKN	997300	1	189750s
Hydro Clamping Bushing	Ø145x65,5xØ110/100	933030	1	183829
Hydro Clamping Bushing	Ø150x49,5xØ110/100	933030	1	183821s
	[mm]			[pc.]

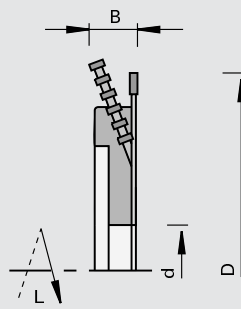
115122

Segment Hoggers HW - Circular Cut "WS"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double-board edgers and edgers
- | double end tenoners
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | tooth configuration of the saw blade: alternate top bevel "WS"

Advantages

- | excellent quality of cut thanks to high concentric and runout accuracy
- | optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- | application with feed for cutting with the grain
- | replacement saw blades: sizing saw blade Class-No. 102320 ATB
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	60	60	6x8	053174 s	053210 s
300	30	60	72	6x8	005437 s	005509 s
300	30	80	72	6x8	005440 s	005512 s
300	40	80	72	6x10	005446 s	005518 s
355	30	60	72	6x8	004283 &	004355 &
355	40	60	72	6x10	004289 &	004361 &
355	30	80	72	6x8	004286 &	004358 &
355	40	80	72	6x10	004292 &	004364 &
350	40	80	54	6x10	004895 &	004823 &
350	30	60	72	6x8	053211 &	053175 &
350	30	80	72	6x8	053214 &	053178 &
350	30	60	84	6x8	005510 &	005438 &
350	40	80	84	6x10	005519 &	005447 &
350	30	60	108	6x8	005654 &	005582 &
[mm]	[mm]	[mm]				

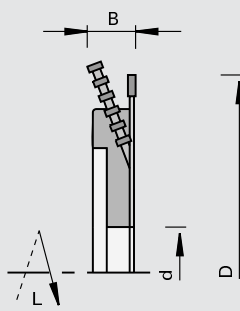
115122

Segment Hoggers HW - Stepped Cut "WS"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double-board edgers and edgers
- | double end tenoners
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | tooth configuration of the saw blade: alternate top bevel "WS"

Advantages

- | excellent quality of cut thanks to high concentric and runout accuracy
- | optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- | application with feed for cutting across the grain
- | replacement saw blades: sizing saw blade Class-No. 102320 ATB
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	80	48	6x8	004834 &	004906 &
300	40	60	60	6x10	053198 &	053234 &
300	30	80	72	6x8	005458 s	005530 s
350	40	60	72	6x10	053199 s	053235 &
350	40	80	84	6x10	005465 &	005537 &
355	30	60	72	6x8	004301 &	004373 &
355	40	60	72	6x10	004307 &	004379 &
355	40	80	72	6x10	004310 &	004382 &
[mm]	[mm]	[mm]				

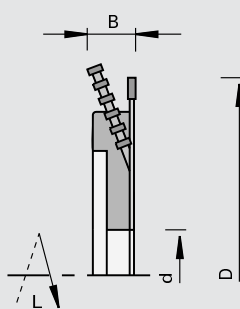
115147

Segment Hoggers HW - Circular Cut "TR-F"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double-board edgers and edgers
- | double end tenoners
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | tooth configuration of the saw blade: triple chip / flat "TR-F"

Advantages

- | excellent quality of cut thanks to high concentric and runout accuracy
- | optimum hogging of the offal thanks to cut division of the cutting edges

Notes

- | application with feed for cutting with the grain
- | replacement saw blades: panel sizing saw blade Class-No. 104370 triple chip / flat
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
305	30	60	60	6x8	172951 &	172955 &
[mm]	[mm]	[mm]				

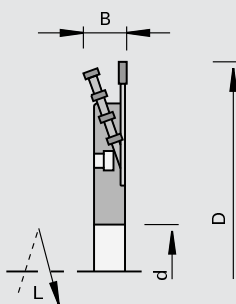
115521

Segment Hoggers HW for LEUCO s-System Ø 192 mm - Circular Cut "F" (RZ/DZ)

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: flat "F"
- RPM: for B = 18 mm n max = 7,200 min-1 / for B = 36 mm n max = 6,000 min-1

Advantages

- excellent cutting quality thanks to high concentric and runout accuracy
- decreased downtimes thanks to extremely long edge lives
- optimum hogging of the offal thanks to cut division of the cutting edges with shear angle

Notes

- application with feed for cutting with the grain
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
250	18	80	48	6x4	160877 &	160879 &
250	18	80	72	6x4	160878 &	160880 &
250	36	80	48	12x4	164400 &	164401 &
250	36	80	72	12x4	164402 &	164403 &

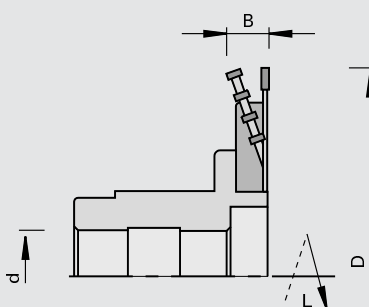
115321

Segment Hoggers HW mounted on Bushing - Circular Cut "F" (RZ/DZ)

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration of the saw blade: flat "F"
- Ø 200 mm: n max = 9,500 min-1
- Ø 250 mm: n max = 7,600 min-1

Advantages

- excellent quality of cut thanks to high concentric and runout accuracy
- optimum hogging of the offal thanks to cut division of the cutting edges

Notes


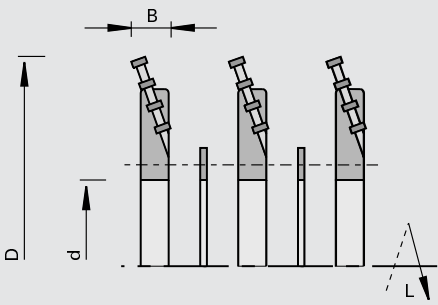
- application with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- sense of rotation see drawing

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
200	18	40	40	4x4 B+G	005864 &	005928 &
200	18	40	40	4x4 M+S	005865 &	005929 &
200	18	35	40	4x4 Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	005876 &	005940 &
200	18	40	60	4x4 M+S	005993 &	006057 &
200	18	30	60	4x4 Lehbrink, Wadkin	005997 &	006061 &
200	18	35	60	4x4 Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	006004 &	006068 &
250	18	40	72	6x4 B+G	057158 &	057159 &

Ø D	B	Ø d	Z	Z segments		Ident-No. [L]	Ident-No. [R]
250	18	35	72	6x4	Celaschi	057160 s	057161 s
250	18	40	72	6x4	Gabbiani (spindle with key)	057164 ♂	057165 ♂
250	18	35	72	6x4	Homag, Homburg, IMA, Koch	057168 ♂	057169 ♂
250	18	40	72	6x4	M+S	057172 ♂	057173 ♂
250	18	35	48	6x4	Celaschi	162159 s	162163 s
250	18	40	48	6x4	M+S	162175 ♂	162179 ♂
250	18	40	48	6x4	Gabbiani (spindle with key)	162223 ♂	162227 ♂
250	18	35	48	6x4	Homag, SCM-IDM, Homburg, IMA	162239 ♂	162243 ♂
[mm]	[mm]	[mm]					

115301

Segment Extensions HW - Circular Cut

<p>Product</p> 	<p>Drawing</p> 	<p>LEUCO DUR</p> <p>Tungsten Carbide [HW]</p> <p>MEC</p>
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<p>Machine / Application</p> <p>for hogging of large offal widths and veneer overhang</p>	<p>Design</p>	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> extendable to 72 mm for subsequent extension of existing folding hoggers Ø 200 mm and Ø 250 mm the extensions consist of a body with installed HW segments, spacer and screws sense of rotation see drawing
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Ø D	B	Ø d	Z		Ident-No. [L]	Ident-No. [R]
200	18-36	80	4x4		006406 ♂	006407 ♂
200	18-54	80	8x4		006408 ♂	006409 ♂
250	18-36	80	6x4		058390 ♂	058391 ♂
250	18-54	80	12x4		058392 ♂	058393 ♂
250	36-54	80	6x4		058396 ♂	058397 ♂
250	36-72	80	12x4		058398 ♂	058399 ♂
250	54-72	80	6x4		058402 ♂	058403 ♂
[mm]	[mm]	[mm]				

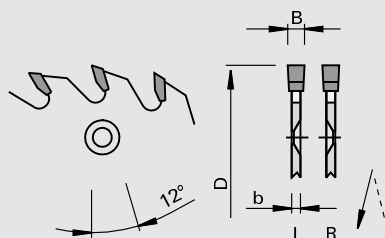
102312

Sizing Saw Blades HW for Segment Hoggers "F"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double end tenoners
- | edge trimming machines
- | for sizing cuts in laminated and raw panels

Design

- | tooth configuration: flat "F"
- | cutting material: HW HL Board 06

Advantages

Notes

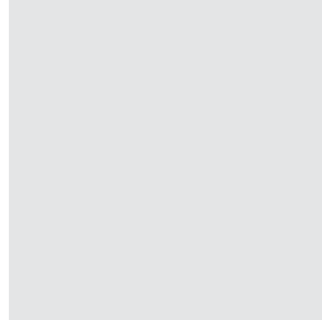
- | bore diameter 100 mm for s-System hogger
- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
200	4,0	2,8	80	40	4/6,5/140	188226	188227
200	4,0	2,8	80	60	4/6,5/140	188228 \$	188229
250	4,0	2,8	80	48	6/6,5/200	188230	188231
250	4,0	2,8	100	48	6/6,5/200	188238	188239
250	4,0	2,8	80	72	6/6,5/200	188236	188237
250	4,0	2,8	100	72	6/6,5/200	188240 \$	188241
[mm]	[mm]	[mm]	[mm]				

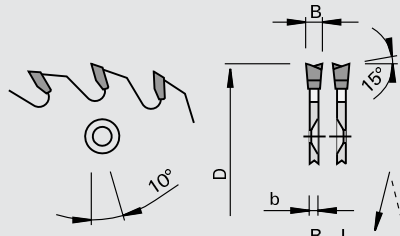
102322

Circular Saw Blades HW for Segment Hoggers "WS"

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double end tenoners
- | edge trimming machines
- | for sizing cuts in raw and laminated panels

Design

- | tooth configuration: ATB "WS"
- | cutting material: HW HL Board 06

Advantages

- | optimum cutting quality and edge life

Notes

- | with pin holes for LEUCO Segment Hoggers
- | sense of rotation acc. to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
355	4,4	3,0	80	72	6/5,5/300 + 4/10/130	189055	189054
[mm]	[mm]	[mm]	[mm]				

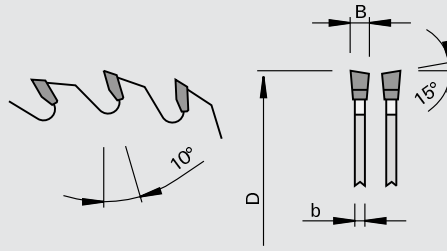
102328

Sizing Saw Blades HW - LowNoise for Segment Hoggers "WS"

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]



Machine / Application

Design

| tooth configuration: ATB "WS"

Advantages

Notes

- | circular saw blades for large hoggers
- | when ordering, please indicate hogger type: circular cut or stepped cut
- | prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- | other dimensions and versions see chapter "Circular Saw Blades"
- | Combi2 = 2/7/42 + 2/9/46 + 2/10/60

Ø D	B	b	Ø d	Z	NL**	Ident-No.
300	3,2	2.2	60	48		188185 €
300	3,2	2.2	30	48	Combi2	189668
300	3,2	2.2	30	60	Combi2	189669
300	3,2	2.2	30	72	Combi2	192766 \$
300	3,2	2.2	30	96	Combi2	192767 \$
350	3,5	2.5	30	72	Combi2	189671
350	3,5	2.5	30	84	Combi2	192768
350	3,5	2.5	30	108	Combi2	192769
[mm]	[mm]	[mm]	[mm]			

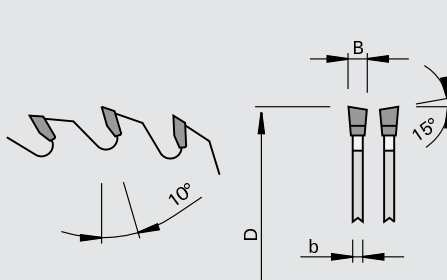
104320

Panel Sizing Saw Blades HW for Segment Hoggers "WS"

Product



Drawing



LEUCO
topline



Tungsten Carbide [HW]

Machine / Application

Design

- | tooth configuration: ATB "WS"
- | cutting material: HW HL Board 04 plus

Advantages

Notes

- | circular saw blades for large hoggers
- | when ordering, please indicate hogger type: circular cut or stepped cut
- | prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- | other dimensions and versions see chapter "Circular Saw Blades"

Ø D	B	b	Ø d	Z	Ident-No.
355	4,4	3.0	30	72	193101
355	4,4	3.0	60	54	193102
[mm]	[mm]	[mm]	[mm]		

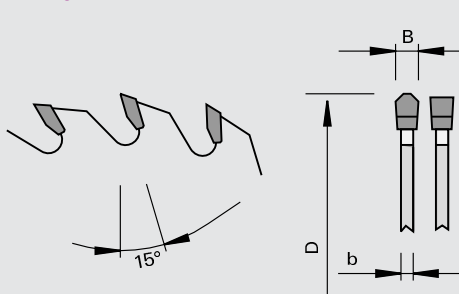
104370

Panel Sizing Saw Blades HW for Segment Hoggers "TR-F"

Product



Drawing



LEUCO
topline



Tungsten Carbide [HW]

Machine / Application

Design

- | tooth configuration: triple chip / flat "TR-F"

Advantages

Notes

- | circular saw blades for large hoggers
- | when ordering, please indicate hogger type: circular cut or stepped cut
- | prices valid for saw blades only; additional pinholes, countersinks and reboring to fit onto hoggers at a surcharge
- | other dimensions and versions see chapter "Circular Saw Blades"

Ø D	B	b	Ø d	Z	Ident-No.
305	4,4	2.8	60	60	192905
[mm]	[mm]	[mm]	[mm]		

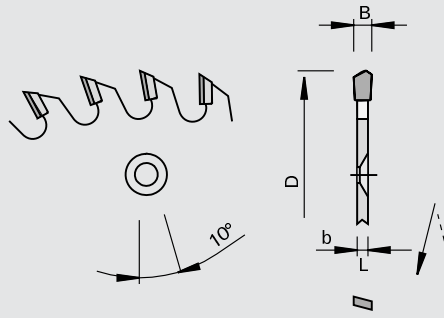
202062

Sizing Saw Blades DP for Segment Hoggers "ES-FA"

Product



Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge trimming machines
- | for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | tooth configuration: top bevel with chamfer and face shear "ES-FA"
- | saw blade with equal tooth pitch
- | n max = 9,000 min⁻¹ with Ø 200 mm
- | n max = 7,200 min⁻¹ with Ø 250 mm
- | resharpenable area 4 mm; sides of teeth can be resharpened

Advantages


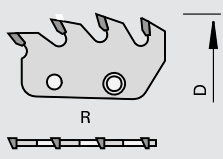
Notes

- | application against feed
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | for combination with LEUCO Segment Hoggers: Ø 80 on Segment Hoggers with standard bushing / Ø 100 on Segment Hoggers for s-System
- | the specified feed rates are based on n = 6,000 min⁻¹
- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
200	4,0	2,8	80	24	15	25	170397 s	170398 s
200	4,0	2,8	80	28	17,5	30	170399 s	170400 s
200	4,0	2,8	80	32	20	32,5	170401 s	170402 s
200	4,0	2,8	80	36	22,5	35	170403 s	170404 s
200	4,0	2,8	80	40	25	40	170405 s	170406 s
200	4,0	2,8	80	44	27,5	45	170407 s	170408 s
200	4,0	2,8	80	48	30	50	170409 s	170410 s
250	4,0	2,8	80	24	15	25	170495 s	170496 s
250	4,0	2,8	80	30	20	32,5	170497 s	170498 s
250	4,0	2,8	80	36	25	40	170499 s	170500 s
250	4,0	2,8	80	42	27,5	45	170501 s	170502 s
250	4,0	2,8	80	48	30	50	170503 s	170504 s
250	4,0	2,8	80	54	35	55	170505 s	170506 s
250	4,0	2,8	80	60	40	60	170507 s	170508 s
250	4,0	2,8	80	66	45	65	170509 s	170510 s
250	4,0	2,8	80	72	50	70	170511 s	170512 s
250	4,0	2,8	100	24	15	25	170621 s	170622 s
250	4,0	2,8	100	30	20	32,5	170623 s	170624 s
250	4,0	2,8	100	36	25	40	170625 s	170626 s
250	4,0	2,8	100	42	27,5	45	170627 s	170628 s
250	4,0	2,8	100	48	30	50	170629 s	170630 s
250	4,0	2,8	100	54	35	55	170631 s	170632 s
250	4,0	2,8	100	60	40	60	170633 s	170634 s
250	4,0	2,8	100	66	45	65	170635 s	170636 s
250	4,0	2,8	100	72	50	70	170637 s	170638 s
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		


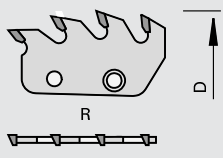
116200

Segments HW for Segment Hoggers - Circular Cut with shear angle

Product		Drawing		 Tungsten Carbide [HW]			
							
Machine / Application		Design		Advantages		Notes	
for complete hogging of the offal in wood-based panels		the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle HW-tipped		no end chipping when cutting along the grain		for offal widths to 18 mm ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process	
Ø D	Z			PU	Ident-No. [L]	Ident-No. [R]	
200/250 [mm]	4	DZ		12	171395	171396	
				[pc.]			

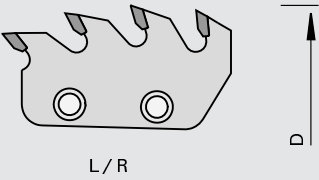

116200

Segments HW for Segment Hoggers - Stepped Cut

Product		Drawing		 Tungsten Carbide [HW]			
							
Machine / Application		Design		Advantages		Notes	
for complete hogging of the offal in wood-based panels		Ident-No.177376 and 177377: the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle HW-tipped		no end chipping when cutting across the grain		for offal widths to 18 mm ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process	
Ø D	Z			PU	Ident-No. [L]	Ident-No. [R]	
200/250	4	stepped cut		12	177374	177375	
200/250	4	stepped cut		12	177376	177377	
[mm]				[pc.]			

116200

Segments HW for Segment Hoggers - Circular Cut

<p>Product</p>	<p>Drawing</p> 	 <p>Tungsten Carbide [HW]</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> HW-tipped segments for both left-hand and right-hand use 	<p>Advantages</p> <ul style="list-style-type: none"> no end chipping when cutting along the grain 	<p>Notes</p> <ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in HW Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process
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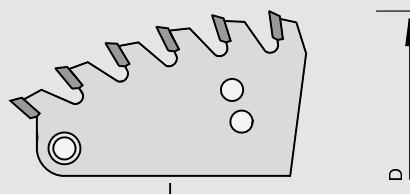
Ø D	Z		PU	Ident-No.
200/250	4	RZ	12	168680
200/250	4	DZ	12	167118
[mm]			[pc.]	

116100

Segments HW for Segment Hoggers - Stepped Cut

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

for complete hogging of the offal in wood-based panels

Design

segments for both left-hand and right-hand use

Advantages

no end chipping when cutting along or across the grain thanks to stepped cut configuration

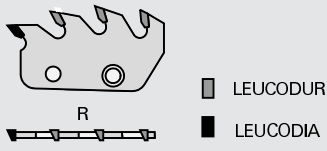

Notes

- ready-to-use in HW Segment Hoggers Ø 250 mm (old design) / Ø 300 mm - Ø 430 mm
- segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm (old design) / 6 HW segments for Ø 300 - 430 mm
- for scoring/hogging (RZ) and double hogging (DZ) process
- segments can be used for circular cut and stepped cut configuration

Ø D	Z	PU	Ident-No. [L]	Ident-No. [R]
250	6	12	006120 s	006129 s
250	8	12	006121 s	006130 s
300	6	12	006123	006132
300	8	12	006124	006133
300	10	12	006125	006134
350/430	6	12	006126	006135
350/430	8	12	006127	006136
350/430	10	12	006128	006137
[mm]			[pc.]	

216200

Segments for Segment Hoggers - Circular Cut Z=1 DP + 3 HW

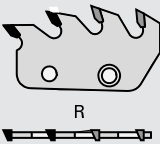

<p>Product</p>	<p>Drawing</p> 	 <p>Polycrystalline diamond [DP]</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> the first tooth is DP-tipped, the following teeth are HW-tipped the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle 	<p>Advantages</p> <ul style="list-style-type: none"> no end chipping when cutting along the grain 	<p>Notes</p> <ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 200 mm for scoring/hogging (RZ) and double hogging (DZ) process
---	---	--	---

Ø D	Z	PU	Ident-No. [L]	Ident-No. [R]
200/250 [mm]	1+3	12	172288 #	172289 s
		[pc.]		

216200

Segments for Segment Hoggers - Circular Cut Z=2 DP + 2 HW

<p>Product</p>	<p>Drawing</p> 	 <p>Polycrystalline diamond [DP]</p>
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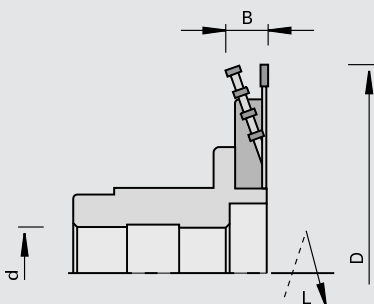

<p>Machine / Application</p> <ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> the first and second tooth are DP-tipped, the following teeth are HW-tipped the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle 	<p>Advantages</p> <ul style="list-style-type: none"> no end chipping when cutting along the grain 	<p>Notes</p> <ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process
--	--	---	--

Ø D	Z	PU	Ident-No. [L]	Ident-No. [R]
200/250 [mm]	2+2	12 [pc.]	172290 s	172291 s

Spare parts		Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	for attaching the segments	M8x12,5	995192	10	180010
Countersunk Screws		M5x12-5.8 DIN 87	995122	10	180007
Spacers		Ø115x1,0xØ80	955520	1	009255
Head Cap Screws	for attaching the extension (18 and 36 mm)	M8x16	995111	10	180004
Head Cap Screws	for attaching the extension (54 mm)	M8x30	995111	10	180005
Head Cap Screws	for attaching the extension (72 mm)	M8x50	995111	10	180006
Cranked Wrench Keys		SW5 DIN ISO 2936	985730	1	009674
Screwdrivers	for hoggers	9,0 [mm]	985730	1 [pc.]	011088

115421

Folding Segment Hoggers HW mounted on Bushing - Circular Cut "F"


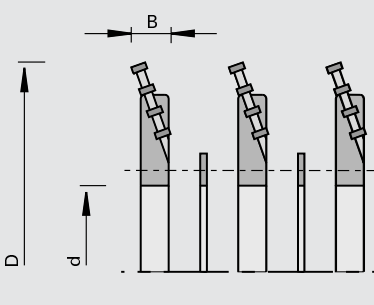

Product 	Drawing 	 Tungsten Carbide [HW] MEC
---	--	---

Machine / Application folding machines for cutting of V grooves and rabbets in laminated and veneered panels	Design tooth configuration of the saw blade: flat "F" RPM n = 3,000 min-1 and n = 6,000 min-1 depending on the machine	Advantages	Notes application against feed circular saw blade and segments have the same diameter the opening angle of > 90 degrees must be determined per application sense of rotation see drawing
---	---	-------------------	---

H	Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
12,5	200	18	35	40	4x4 Koch, Lehbrink	051210 &	051207 &
25	200	36	35	40	8x4 Koch, Lehbrink	051211 &	051208 &
25	250	36	35	48	12x4 Koch, Lehbrink	164021 &	164022 &
16	250	22	35	48	6x5 Koch, Lehbrink	164027 &	164028 &
[mm]	[mm]	[mm]	[mm]				

115401

Folding Segment Extensions HW - Circular Cut

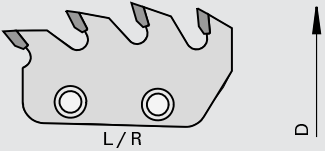

Product 	Drawing 	 Tungsten Carbide [HW] MEC
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Machine / Application for cutting of V grooves in thick panels	Design HW-tipped	Advantages	Notes extendable to 54 mm for subsequent extension of existing folding hoggers Ø 200 mm and Ø 250 mm the diameters of existing folding hoggers and folding extensions must match the extension assemblies consist of a body with installed HW segments, spacer and screws sense of rotation see drawing
--	------------------------------	-------------------	---

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
250	36-54	80	6x4	164011 &	164012 &
[mm]	[mm]	[mm]			

116210

Segments HW - Z=4 for folding segment hoggers

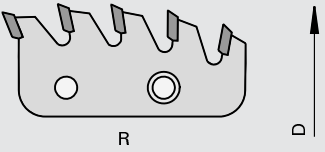

Product	Drawing	
		 Tungsten Carbide [HW] MEC

Machine / Application	Design	Advantages	Notes
for complete hogging of the offal during the V-groove cutting process	HW-tipped		ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions circular saw blade and segments must have the same diameter segments can be used for clockwise and counter-clockwise rotation

Ø D	Z	Ident-No.
200	4	168757
250	4	168760
[mm]		

116210

Segments HW - Z=5 for folding segment hoggers

Product	Drawing	
		 Tungsten Carbide [HW] MEC

Machine / Application	Design	Advantages	Notes
for complete hogging of the offal during the V-groove cutting process	HW-tipped		ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions circular saw blade and segments must have the same diameter

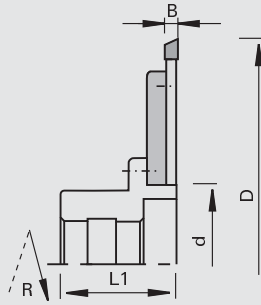
Ø D	Z	Ident-No. [L]	Ident-No. [R]
200	5	168759 s	168758 s
250	5	168761	168762
[mm]			

115775

Saw Hoggers HW for finger jointing lines - Grecon

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l finger jointing lines
l for chip-free cross-cutting of solid woods

Design

Advantages

l clean, chip-free cuts and long edge lives thanks to special cutting geometry
l precise fit for finger joints
l low noise level

Notes

l included in delivery: hogger saw blade, flange, screws and screwdrivers (not mounted); sleeve not included in delivery
l sense of rotation acc. to DIN-EN 50144

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	44	59	80	60	12x3,3	Grecon	182379 &	182378 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No. [L]

Ident-No. [R]

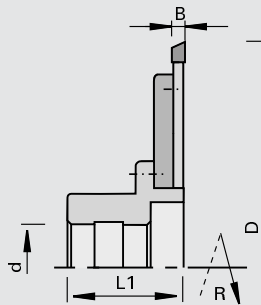
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	1	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Flanges	Ø210x8,4xØ80	997370	1		182377
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294
	[mm]			[pc.]	

115775

Saw Hoggers HW mounted on bushing for finger jointing lines - Grecon

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l finger jointing lines
l for chip-free cross-cutting of solid woods

Design

Advantages

l clean, chip-free cuts and long edge lives thanks to special cutting geometry
l precise fit for finger joints
l low noise level

Notes

l sense of rotation acc. to DIN-EN 50144

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	44	59	40	60	12x3,3	Grecon	182599 &	182600 &
350	10	44	59	40	60+12	12x3,3	Grecon	182611 &	182612 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	1	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	1	189246 s	189247 #
Flanges	Ø210x8,4xØ80	997370	1		182377
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100
Bushings for Grecon-Combipact	Ø250x8x40	997370	1		178783 s
	[mm]		[pc.]		

115775

Saw Hoggers HW mounted on bushing for finger jointing lines - NKT

Product	Drawing	
		<p>Tungsten Carbide [HW]</p> <p>MEC</p>

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> I finger jointing lines I for chip-free cross-cutting of solid woods 		<ul style="list-style-type: none"> I clean, chip-free cuts and long edge lives thanks to special cutting geometry I precise fit for finger joints I low noise level 	<ul style="list-style-type: none"> I sense of rotation acc. to DIN-EN 50144

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8,0	84	102	38	60	10x4	NKT	182601 &	182602 &
300	8,0	84	102	38	60	10x4	NKT	182607 &	182608 &
350	10	84	102	38	60+12	10x4	NKT	182613 &	182614 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	1	189223	189222
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102350	1	189244	189245
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	1	189246 s	189247 #
Countersunk Screws	M5x12 T20	995125	10		166709
Screwdrivers	T20x100	985730	1		166092
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294
	[mm]		[pc.]		

115775

Saw Segment Hogger HW mounted on bushing for finger jointing lines - Grecon

Product		Drawing									
										 Tungsten Carbide [HW] MEC	
Machine / Application		Design		Advantages		Notes					
<ul style="list-style-type: none"> I finger jointing lines I for chip-free cross-cutting of solid woods 				<ul style="list-style-type: none"> I clean, chip-free cuts and long edge lives thanks to special cutting geometry I precise fit for finger joints I low noise level 		<ul style="list-style-type: none"> I sense of rotation see drawing 					
$\varnothing D$	B	b	L1	$\varnothing d$	Z	DKN		Ident-No. [L]	Ident-No. [R]		
250	16,3	44	59	40	48+(6x4)	12x3,3	Grecon	189097 &	189096 &		
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]					
Spare parts		Dimension		Class-No.		PU		Ident-No. [L]		Ident-No. [R]	
Hogger Saw Blade		$\varnothing 250 \times 4,0 / 2,8 \times \varnothing 120$ Z48		102312		1		189092		189093	
HW segments		$\varnothing 250$ Z=4		116200		1		189094		189094	
Bushings for Grecon		$\varnothing 113 \times 59 \times 40$ DKN		997300		1				189100	
Countersunk Screws		M6x10 DIN EN ISO 10642		995121		10				182598	
Countersunk Screws		M5x10-8.8 DIN EN ISO 2009		995122		10				055881	
Head Cap Screws		M8x16 DIN912		995111		10				001891	
Screwdrivers		SW4x100		985730		1				166091	
Screwdrivers		8,0		985730		1				053874	
		[mm]						[pc.]			

105320

Scoring Saw Blades HW "WS" - for finger joint machines

Product		Drawing									
										 Tungsten Carbide [HW]	
Machine / Application		Design		Advantages		Notes					
<ul style="list-style-type: none"> I finger jointing lines Grecon I for scoring of solid woods 		<ul style="list-style-type: none"> I 6 countersunk pin holes on both sides each I for clockwise and counter-clockwise rotation I tooth configuration: alternate top bevel "WS" I cutting material: HW HL Board 06 		<ul style="list-style-type: none"> I along and across the grain, from below 							
$\varnothing D$	B	b	$\varnothing d$	Z	NL	Hook angle	Corner			Ident-No.	
200	7,0	4.0	75	48	2x6/6,5/95	10	10	Grecon		189539	
[mm]	[mm]	[mm]	[mm]			[°]	[°]				

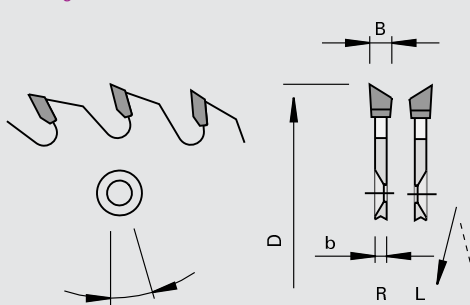
105350

Scoring Saw Blades HW "ES" - for finger joint machines

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | finger jointing lines Grecon-Combipact
- | for scoring of solid woods

Design

- | tooth configuration: top bevel "ES (right + left)"
- | cutting material: HW HL Board 06

Advantages

Notes

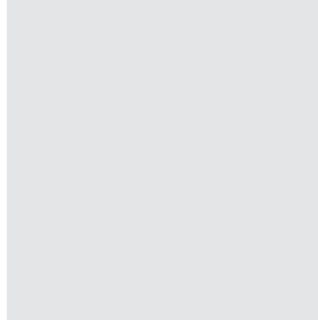
- | along and across the grain, from above and below
- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠		Ident-No. [L]	Ident-No. [R]
200	5,1	3.5	75	48	6/7/95	10	25	Grecon-Combipact	188947	188948
200	4,7	3.4	75	64	6/6,6/95	10	30	Grecon HS 120	189034	189035
200	6,0	4.0	75	48	6/6,5/95	10	5	Grecon	189540	
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

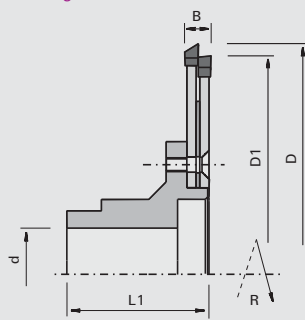
105355

Scoring Saw Blade Set HW "ES" - for finger joint machines

Product



Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | finger jointing lines Grecon Ultra / Profi Joint
- | for scoring of solid woods

Design

- | tooth configuration: top bevel "ES"
- | cutting material: HW HL Board 06

Advantages

Notes

- | along and across the grain, from below
- | sense of rotation according to DIN-EN 50144

Ø D1	Ø D	B	L1	Ø d	Z	DKN		Ident-No. [R]
190	200	11,6	61	40	48+48	12x3,3	Grecon Ultra / Profi Joint	189536 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Scoring Saw Blades	Ø200x6,0/4,0xØ75 Z48	105350	1	189537
Scoring Saw Blades	Ø190x6,0/4,0xØ75 Z48	105350	1	189538
Bushings for Grecon	Ø115x61xØ40DKN	997300	1	189543
Spacers	Ø150x1,5xØ75	955520	1	189542
Countersunk Screws	M6x20 DIN 7991-8.8	995121	10	183114
Screwdrivers	SW4x100	985730	1	166091
	[mm]			[pc.]

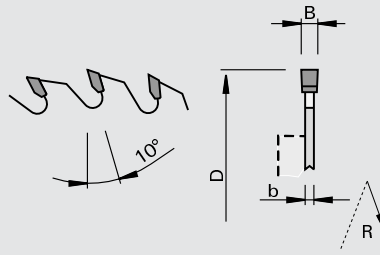
105311

Scoring Saw Blades HW "F" - for hoggers and flange

Product



Drawing



LEUCO
topLine

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed
- for flange Ident-No. L 164770 R 164758 for LEUCO s-System
- for flange Ident-No. 006480 for Homag, Brandt, IMA motor shaft Ø 30 DKW
- flanges see chapter "Clamping Systems"
- included in delivery: saw blade without flange
- sense of rotation acc. to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
180	3,2	2.2	65	36	6/6,5/90	188266	188267
180	3,2	2.2	65	48	6/6,5/90	188268	188269
180	3,2	2.2	65	54	6/6,5/90	188270	188271
[mm]	[mm]	[mm]	[mm]				

Complete sets with flange	Ø D	Z	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	180	36	Homag, Brandt, IMA	105011 1	160656 &	160655 &
	180	48	Homag, Brandt, IMA	105011 1	161274 &	161273 &
	180	54	Homag, Brandt, IMA	105011 1	161272 &	161271 &
	[mm]			[pc.]		

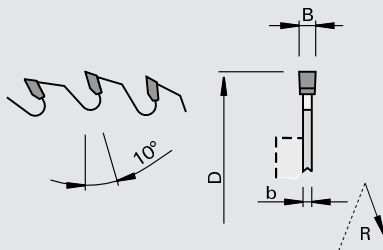
105311

Scoring Saw Blades HW "F" - for hoggers and flange 160849

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed
- for flange Ident-No. 160849 for LEUCO s-System
- flanges see chapter "Clamping Systems"
- included in delivery: saw blade without flange
- sense of rotation acc. to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Ident-No.
180	3,2	2.2	50	36	3/22/80	188263
180	3,2	2.2	50	48	3/22/80	188264
180	3,2	2.2	50	54	3/22/80	188265
200	3,2	2.2	50	42	3/22/80	188272 &
200	3,2	2.2	50	64	3/22/80	188273
[mm]	[mm]	[mm]	[mm]			

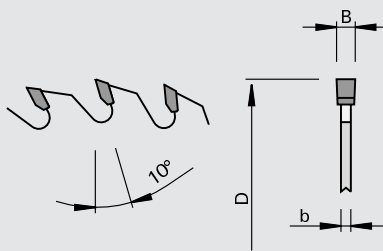
105311

Scoring Saw Blades HW "F" - for hoggers

Product



Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
150	3,2	2.2	30	36		188295
150	3,2	2.2	40	36		188255 &
150	3,2	2.2	40	48		188256
150	3,2	2.2	55	36		188274
180	3,2	2.2	30	36		188257
180	3,2	2.2	30	54		188259
200	3,2	2.2	30	42		188260
200	3,2	2.2	60	64		188276
[mm]	[mm]	[mm]	[mm]			

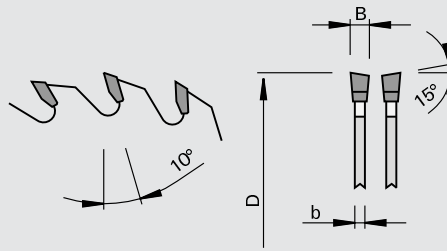
105320

Scoring Saw Blades HW "WS" - for hoggers

Product



Drawing



LEUCO
topLine

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners with scoring / hogging unit
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: ATB "WS"
- cutting material: HW HL Board 06

Advantages

Notes

- application with feed

Ø D	B	b	Ø d	Z	Ident-No.
150	3,2	2.2	30	48	188292
180	3,2	2.2	30	54	188293
200	3,2	2.2	30	64	188294
[mm]	[mm]	[mm]	[mm]		

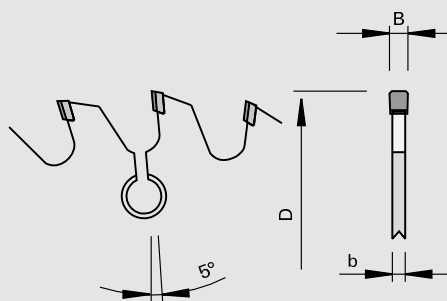
205241

DIAMAX Scoring Saw Blades DP "F-FA" - for hoggers and flange 160849

Product



Drawing



LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer "F-FA"
- n max = 10,000 min-1
- reduced resharpenable area

Advantages

- long edge lives
- low purchase price thanks to large-scale manufacturing

Notes

- application with feed
- the specified feed rates are based on n = 6,000 min-1
- for flange Ident-No. 160849 for LEUCO s-System

Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	50	24	3/22/80	20	173712 s
180	3,2	2.2	50	28	3/22/80	25	173716
180	3,2	2.2	50	32	3/22/80	30	173720
[mm]	[mm]	[mm]	[mm]			[m/min]	

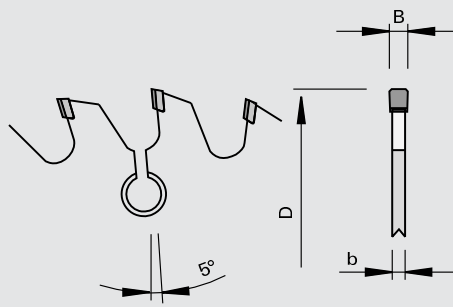
205241

DIAMAX Scoring Saw Blades DP "F-FA" - for hoggers and flange 006480

Product



Drawing



LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- l double end tenoners
- l edge trimming machines
- l for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- l tooth configuration: flat with two-sided chamfer "F-FA"
- l n max = 10,000 min-1
- l reduced resharpenable area

Advantages

- l long edge lives
- l low purchase price thanks to large-scale manufacturing

Notes

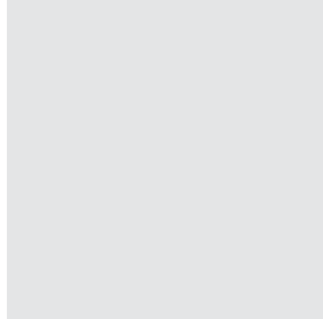
- l application with feed
- l the specified feed rates are based on n = 6,000 min-1
- l for flange Ident-No. 006480 for Homag, Brandt, IMA for LEUCO s-System

Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	24	6/6,5/90	20	173714
180	3,2	2.2	65	32	6/6,5/90	30	173722
[mm]	[mm]	[mm]	[mm]			[m/min]	

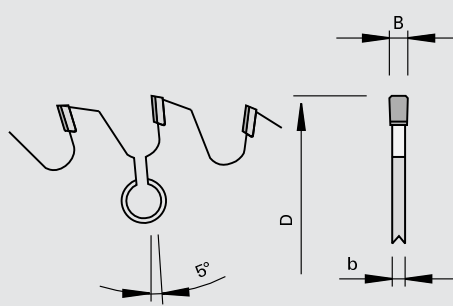
205041

Scoring Saw Blades DP "F-FA" - for hoggers

Product



Drawing



LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- l double end tenoners
- l edge trimming machines
- l for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- l tooth configuration: flat with two-sided chamfer "F-FA"
- l resharpenable area 4 mm

Advantages

- l long edge lives

Notes

- l application with feed
- l the specified feed rates are based on n = 6,000 min-1

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No.
150	3,2	2.2	55	28	25	169322 s
180	3,2	2.2	30	48	50	169338 s
180	3,2	2.2	30	44	45	169335 s
180	3,2	2.2	30	40	40	169332 s
180	3,2	2.2	30	36	35	169329 s
180	3,2	2.2	30	32	30	169327 s
180	3,2	2.2	30	28	25	169326 s
180	3,2	2.2	30	24	20	169325 s
150	3,2	2.2	55	32	30	169323 s
150	3,2	2.2	55	24	20	169321 s
200	3,2	2.2	30	24	20	169341 s
150	3,2	2.2	60	36	35	170173 s
150	3,2	2.2	55	36	35	169324 s
[mm]	[mm]	[mm]	[mm]		[m/min]	

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No.
150	3,2	2.2	60	28	25	170171 s
150	3,2	2.2	60	32	30	170172 s
200	3,2	2.2	30	28	25	169343 s
150	3,2	2.2	60	24	20	170170 s
200	3,2	2.2	30	48	50	169353 s
200	3,2	2.2	30	44	45	169351 s
200	3,2	2.2	30	40	40	169349 s
200	3,2	2.2	30	36	35	169347 s
200	3,2	2.2	30	32	30	169345 s
[mm]	[mm]	[mm]	[mm]		[m/min]	

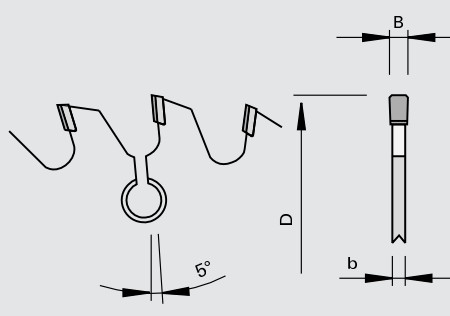
205041

Scoring Saw Blades DP "F-FA" - for hoggers and flange 160849

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- l double end tenoners
- l edge trimming machines
- l for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- l tooth configuration: flat with two-sided chamfer "F-FA"
- l resharpenable area 4 mm

Advantages

- l long edge lives

Notes

- l application with feed
- l the specified feed rates are based on n = 6,000 min⁻¹
- l for flange Ident-No. 160849 for LEUCO s-System

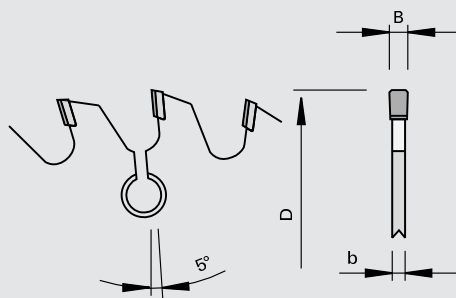
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	50	24	3/22/80	20	168905 s
180	3,2	2.2	50	28	3/22/80	25	168907 s
180	3,2	2.2	50	32	3/22/80	30	168909 s
180	3,2	2.2	50	36	3/22/80	35	169330 s
180	3,2	2.2	50	40	3/22/80	40	169333 s
180	3,2	2.2	50	44	3/22/80	45	169336 s
180	3,2	2.2	50	48	3/22/80	50	169339 s
200	3,2	2.2	50	24	3/22/80	20	169342 s
200	3,2	2.2	50	28	3/22/80	25	169344 s
200	3,2	2.2	50	32	3/22/80	30	169346 s
200	3,2	2.2	50	36	3/22/80	35	169348 s
200	3,2	2.2	50	40	3/22/80	40	169350 s
200	3,2	2.2	50	44	3/22/80	45	169352 s
200	3,2	2.2	50	48	3/22/80	50	169354 s
[mm]	[mm]	[mm]	[mm]			[m/min]	

205041

Scoring Saw Blades DP "F-FA" - for hoggers and flange 006480

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free scoring of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: flat with two-sided chamfer "F-FA"
- resharpenable area 4 mm

Advantages

- long edge lives

Notes

- application with feed
- the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$
- for flange Ident-No. 006480 for Homag, Brandt, IMA for LEUCO s-System

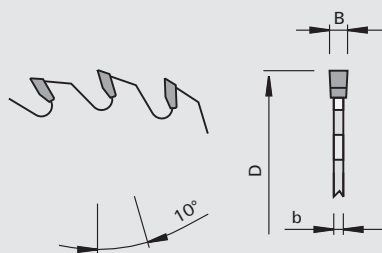
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	24	6/5,5/90	20	168906
180	3,2	2.2	65	28	6/5,5/90	25	168908 s
180	3,2	2.2	65	32	6/6,5/90	30	169328 s
180	3,2	2.2	65	36	6/5,5/90	35	169331 s
180	3,2	2.2	65	40	6/6,5/90	40	169334 s
180	3,2	2.2	65	44	6/5,5/90	45	169337 s
180	3,2	2.2	65	48	6/6,5/90	50	169340 s
[mm]	[mm]	[mm]	[mm]			[m/min]	

102312

Sizing Saw Blades HW "F" - for hoggers

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- for sizing cuts in raw and laminated panels

Design

- tooth configuration: flat "F"
- cutting material: HW HL Board 06


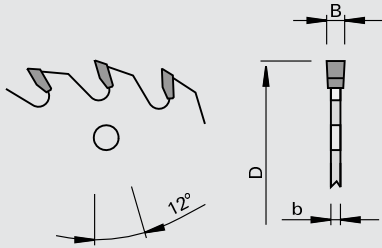


Advantages

Notes

Ø D	B	b	Ø d	Z	Tooth geometry	Ident-No.
250	4,0	2.8	80	54	flat without cut out	188248
250	4,0	2.8	80	78	flat without cut out	188249
255	4,0	2.8	60	60	flat without cut out	188251
255	4,0	2.8	80	60	flat without cut out	188253 &
[mm]	[mm]	[mm]	[mm]			


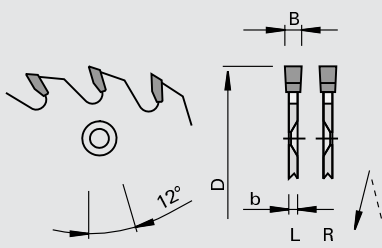


102312

Sizing Saw Blades HW "F" - for high-tech hoggers

Product 		Drawing 				  Tungsten Carbide [HW] MEC	
Machine / Application double end tenoners for sizing cuts in raw and laminated panels		Design tooth configuration: flat "F" cutting material: HW HL Board 06		Advantages		Notes	
Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250 [mm]	4,0 [mm]	2.8 [mm]	100 [mm]	72	6/6,5/172	flat with 6 cut out	188245 s

102312

Sizing Saw Blades HW for TwinTec Hoggers "F"

Product 		Drawing 				  Tungsten Carbide [HW] MEC	
Machine / Application double end tenoners edge trimming machines for sizing cuts in laminated and raw panels		Design tooth configuration: flat "F" cutting material: HW HL Board 06		Advantages		Notes sense of rotation see drawing	
Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
220 [mm]	4,0 [mm]	2.8 [mm]	80 [mm]	48	6/6/154	169820	169819
				60	6/6/154	169818	169817

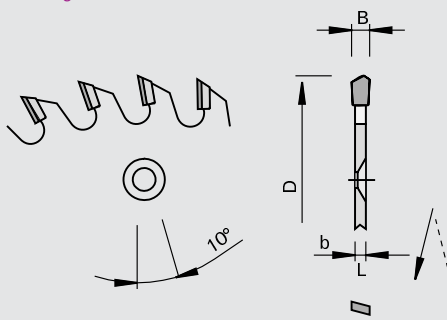
202062

Circular Saw Blades DP for TwinTec Hoggers "ES-FA"

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge trimming machines
- for chip-free sizing of raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- tooth configuration: top bevel with chamfer and face shear "ES-FA"
- n max = 7,200 min-1
- resharpenable area 4 mm; sides of teeth can be resharpened
- saw blade with equal tooth pitch

Advantages

- decreased downtimes thanks to long edge lives

Notes

- application with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- for combination with LEUCO TwinTec hoggers
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
220	4,0	2,8	80	24	15	25	171353 s	171354 s
220	4,0	2,8	80	30	20	32,5	171355 s	171356 s
220	4,0	2,8	80	36	25	40	171357	171358
220	4,0	2,8	80	42	27,5	45	171359 s	171360 s
220	4,0	2,8	80	48	30	50	171361 s	171362 s
220	4,0	2,8	80	54	35	55	171363 s	171364 s
220	4,0	2,8	80	60	40	60	171365	171366 s
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		

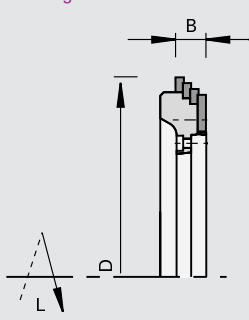
115205

Hogger Rings HW for TwinTec Hoggers

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- for chip-free sizing during the cross-cutting process

Design

- hogger teeth positioned in a stepped cut configuration
- segments Z=1 solid tungsten carbide with shear angle

Advantages

Notes

- sense of rotation see drawing

Ø D	B	Z	Ident-No. [L]	Ident-No. [R]
239	18,4	4x6	172304 s	172303 s
[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screwdrivers

T20x100

985730

1

166092

Head Cap Screws

M5x12 T20

995115

10




171237

[mm]

[pc.]



150501

Segments VHW for TwinTec hogger

<p>Product</p> 		<p>Drawing</p> 		 <p>Solid Tungsten Carbide</p>	
<p>Machine / Application</p> <p> for use in TwinTec Hogger Ring</p>		<p>Design</p> <p> Z = 1 VHW with shear angle</p>		<p>Advantages</p>	
				<p>Notes</p> <p> one set consists of 6 segments completely tipped for circular cut: 12 segments / stepped cut: 24 segments</p>	
				Ident-No. [L]	Ident-No. [R]
				171232	171233
Spare parts		Dimension		Class-No.	PU
Countersunk Screws		M5x13,5 T20		995125	10
Screwdrivers		T20x100		985730	1
		[mm]			[pc.]

232921

Segments for TwinTec Hogger DP-tipped

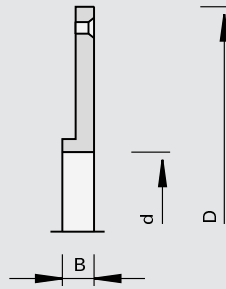
<p>Product</p>		<p>Drawing</p> 		 <p>Polycrystalline diamond [DP]</p>	
<p>Machine / Application</p> <p> for use in TwinTec Hogger Ring</p>		<p>Design</p> <p> Z = 1 DP-tipped with shear angle</p>		<p>Advantages</p>	
				<p>Notes</p> <p> one set consists of 6 segments completely tipped for circular cut: 12 segments / stepped cut: 24 segments</p>	
				Ident-No. [L]	Ident-No. [R]
				171234	171235
Spare parts		Dimension		Class-No.	PU
Countersunk Screws		M5x13,5 T20		995125	10
Screwdrivers		T20x100		985730	1
		[mm]			[pc.]

997300

Hogger Flanges for TwinTec Hoggers

Product

Drawing



Machine / Application

Design

Advantages

Notes

for attaching the hogger saw blades

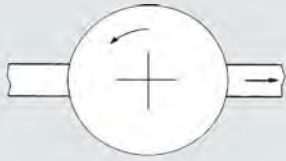
during the double hogging process the saw is attached to the flange by screws
included in delivery: flange, countersunk screws M5x16 mm

Ø D	B	Ø d	Ident-No.
170	12	60	171367 s
[mm]	[mm]	[mm]	

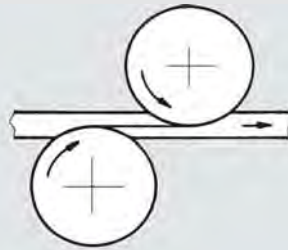
Spare parts		Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	for attaching the saw blade without flange	M5x10 T20	995125	10	171236
Countersunk Screws	for attaching the flange	M5x16 T20	995125	10	164839
Screwdrivers		T20x100	985730	1	166092
		[mm]		[pc.]	

Application example

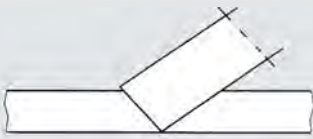
Hogging



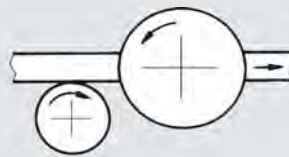
Double hogging



Folding Hogging



Scoring / Hogging



Order / Inquiry for Special Tools: Hoggers

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	<input type="radio"/>
Company:	_____	Inquiry:	<input type="radio"/>
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Maker: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Flange diameter [mm]: _____

Motor output (hogger motor) [kW]: _____

Cutting diameter D [mm]: _____

Hogging width [mm]: _____

No. of teeth [pcs.]: _____

Circular Saw Blade
No. x no. of segment teeth

Sense of rotation: Right Left

Mode of application:

Hogger: Against feed:

With feed:

Mode of application: Hogging

Scoring / Hogging

Double hogging

Interface

Bushing: _____

Double keyway	Width	Height
Keyway	Width	Height

Workpiece

Description: _____

Material thickness [mm]: _____

Hogging width [mm]: _____

Cutting quality: Rough hogging

Finish hogging

Folding

Circular cut

Stepped cut

Direction of cut: With grain

(Solid wood) Across grain

Coating: Yes No

Hydro Bushing: _____

Hydro s-System: _____

s-System: _____

Other: _____

Cutting material

Circular Saw Blade	Carbide	<input type="radio"/>
	Diamond	<input type="radio"/>
Segments:	Carbide	<input type="radio"/>
	Diamond	<input type="radio"/>

o Check if applicable

Description: _____

Further Information: _____

Tool drawing: _____

Tool

Compact Hoggers

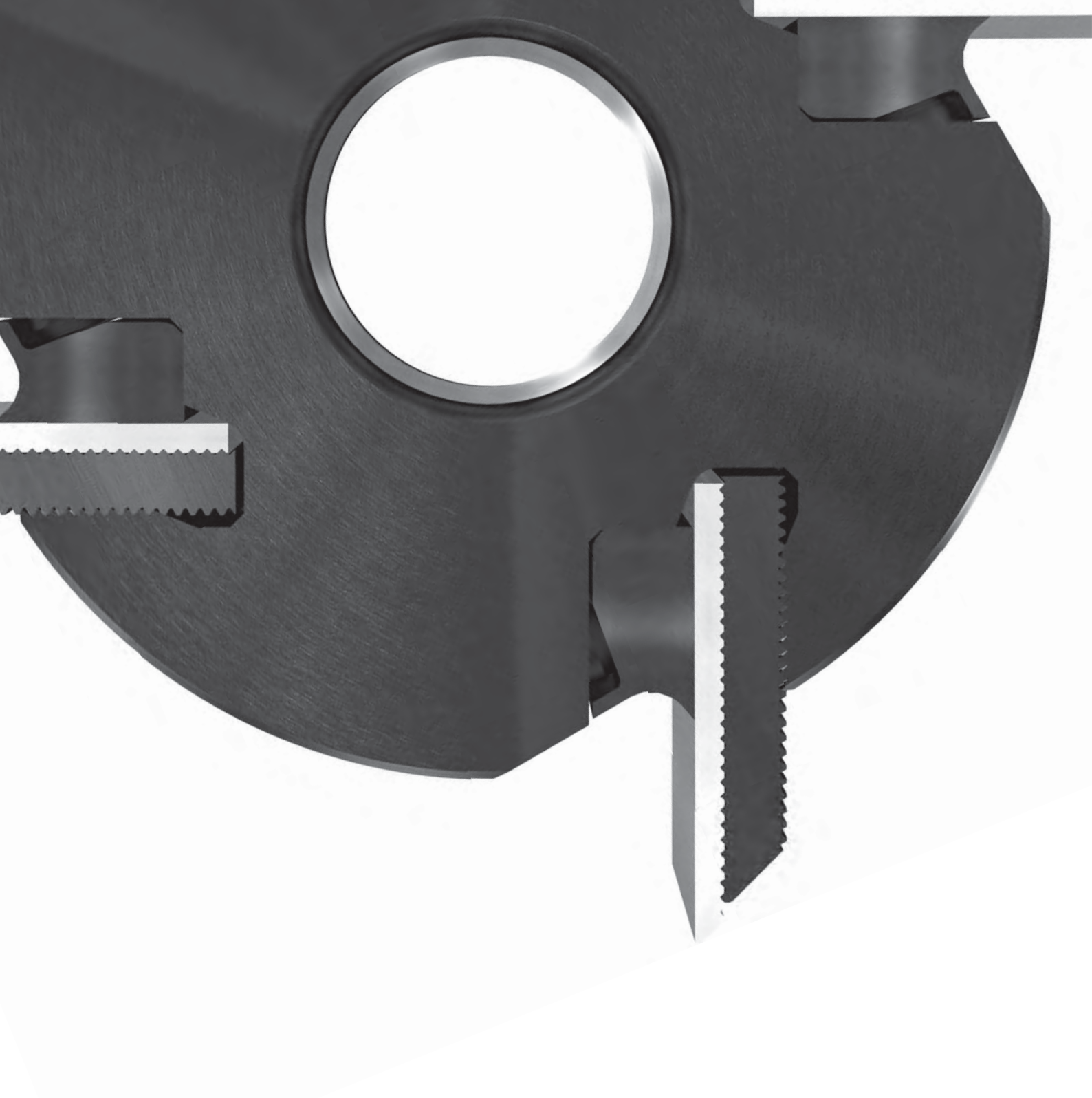
Segment Hoggers

TwinTec Hoggers

Radius hogger

Other:

517-01.0708



Cutters with Bore

Product	Page
Edge trimming	3-1
Postforming	3-64
Grooving	3-68
Jointing/Rabbeting/Chamfering/Rounding	3-84
Profiling	3-107
Groove bed	3-127
Planing	3-129
Jointing	3-143
Technical Information	3-155

122110

Edge Jointing Cutters HW two-part version - IMA (BIMA)

Product		Drawing						
<p>Machine / Application</p> <ul style="list-style-type: none"> edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135 for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<p>Design</p> <ul style="list-style-type: none"> cutting edges parallel to cutter axis two part version countersunk on both sides n max = 18,000 min-1 			<p>Advantages</p>		<p>Notes</p> <ul style="list-style-type: none"> sense of rotation see drawing 	
$\emptyset D$	B	b	$\emptyset d$	Z		Ident-No. [L]	Ident-No. [R]	
70 [mm]	6,0 [mm]	6.0 [mm]	30 [mm]	6	IMA (BIMA)	716658 s	716657 s	

122110

Edge Jointing Cutters HW

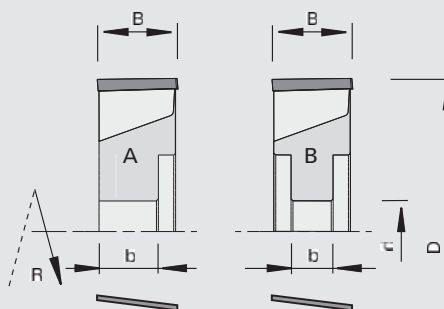
Product		Drawing						
<p>Machine / Application</p> <ul style="list-style-type: none"> edge banding machines for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<p>Design</p> <ul style="list-style-type: none"> with shear angle n max = 18,000 min-1 			<p>Advantages</p>		<p>Notes</p> <ul style="list-style-type: none"> sense of rotation according to DIN-EN 50144 	
$\emptyset D$	B	b	$\emptyset d$	Z	DKN	Shear \sphericalangle	Ident-No. [L]	Ident-No. [R]
70 [mm]	25 [mm]	10.5 [mm]	16 [mm]	4	5x2,3 [mm]	10 [°]	180796 s	180795 s
100 [mm]	25 [mm]	15 [mm]	30 [mm]	4		15 [°]	160647 s	160109 s

122112

Edge Jointing Cutters HW - SCM-Stefani

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
SCM-Stefani with ED-System
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle
 $n_{max} = 18,000 \text{ min}^{-1}$

Advantages

Notes

sense of rotation according to
DIN-EN 50144

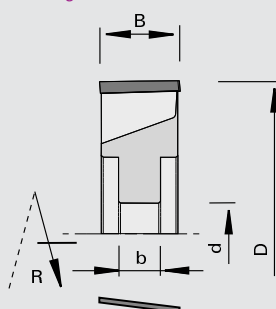
$\varnothing D$	B	b	$\varnothing d$	Z	DKN	Shear \angle	Type		Ident-No. [L]	Ident-No. [R]
70	20	14.5	16	4	5x2,3	12	A	SCM-Stefani-RSK	182985 s	182986 s
75	20	10.5	16	4	5x2,3	12	A	SCM-Stefani-RSP	182989 s	182990 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				
$\varnothing D$	B	b	$\varnothing d$	Z	DKN	Shear \angle	Type		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	B	SCM-Stefani-RSP	182991 s	182992 s
80	20	11	16	4	5x2,3	12	B	SCM-Stefani-R	182617 s	182618 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

222210

DIAMAX Edge Jointing Cutters DP - SCM-Stefani

Product

Drawing

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
SCM-Stefani with ED-System
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle
reduced resharpenable area
 $n_{max} = 23,800 \text{ min}^{-1}$

Advantages

Notes

sense of rotation according to
DIN-EN 50144

$\varnothing D$	B	b	$\varnothing d$	Z	DKN	Shear \angle	Type		Ident-No. [L]	Ident-No. [R]
80	20	11	16	4	5x2,3	12	SCM-Stefani		182976 s	182975 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

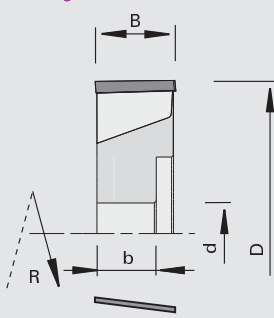
222510

DIAMAX Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines SCM Stefani with ED-System
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

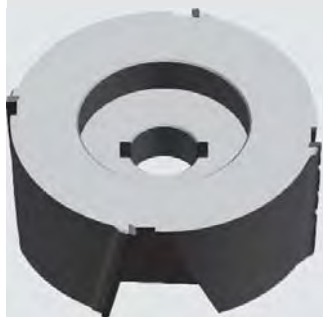
sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear<		Ident-No. [L]	Ident-No. [R]
70	10	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182979 s	182980 s
70	20	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182977 s	182978 s
75	20	10.5	16	4	5x2,3	12	SCM-Stefani-RSP	182981 s	182982 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

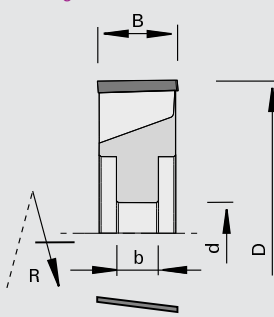
222510

DIAMAX Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines SCM Stefani with ED-System
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

sense of rotation according to DIN-EN 50144

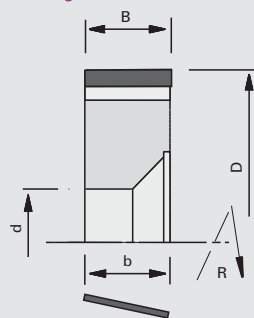
Ø D	B	b	Ø d	Z	DKN	Shear<		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	SCM-Stefani-RSP	182983 s	182984 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

122110

Edge Jointing Cutters CM HW - HOLZ-HER

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
HOLZ-HER
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

sense of rotation according to
DIN-EN 50144

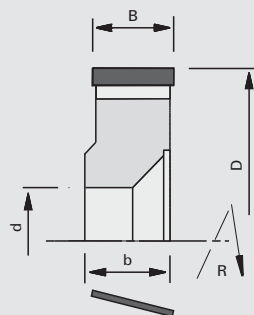
Ø D	B	b	Ø d	Z	DKN	Shear∠	nmax		Ident-No. [L]	Ident-No. [R]
50	18	17	20	2	5x2,2	10	24000	HOLZ-HER-1828	183113 s	183112 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

122110

Edge Jointing Cutters CM HW- HOLZ-HER 1828 - AirStream-System

Product

Drawing

AIR
STREAMLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1828
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle
AirStream-System
ChipMeister

Advantages

improved chip removal thanks
to ChipMeister version and
AirStream-System
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
low noise level

Notes

sense of rotation according to
DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear∠	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,3	10	18000	HOLZ-HER-1828	184747	184746
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

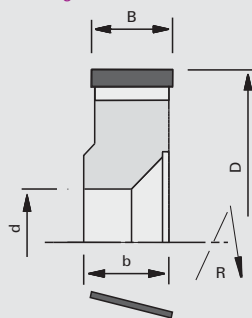
222810

Edge Jointing Cutters CM DP - HOLZ-HER 1828 - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
HOLZ-HER aggregate 1828
l for for jointing and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l with shear angle
l polished face and high-finish
clearance angle
l AirStream-System
l ChipMeister
l n max = 18,000 min-1

Advantages

l improved chip removal thanks
to ChipMeister version and
AirStream-System
l less chips remain inside of the
machine
l no malfunctions due to chips
l reduction of suction power
l low noise level

Notes

l sense of rotation according to
DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear∠	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,2	12	18000	HOLZ-HER 1828	184749 s	184748 s
70	19	20	20	4	5x2,2	12	18000	HOLZ-HER 1828	184751 s	184750 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

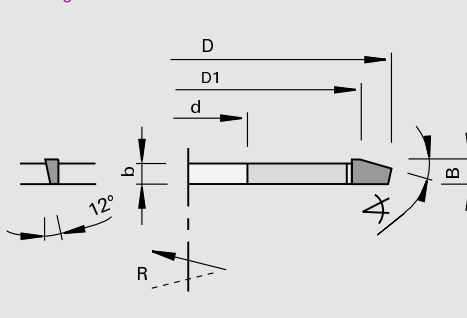
122115

Edge Jointing Cutters HW - Brandt

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l edge banding machines
l for flush-cutting and chamfering
of solid wood, veneer and
plastic edge bands

Design

l with shear angle
l n = 8,100 - 13,800 min-1

Advantages

Notes

l sense of rotation according to
DIN-EN 50144

Chamfer∠	Ø D1	Ø D	B	b	Ø d	Z	Shear∠		Ident-No. [L]	Ident-No. [R]
15	60	66	4,0	3,0	16	6	12	Brandt	819482 s	819481 s
16		96	5,8	5,0	40	12	12	Brandt	164658 s	164657 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]			

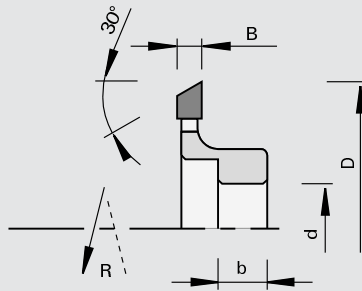
122100

Edge Jointing Cutters HW - IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

| edge banding machines
 | for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

| cutting edges parallel to cutter axis
 | n max = 18,000 min-1

Advantages

Notes

| sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
73	6,0	12	20	12	6x3,5	IMA	171240	171239
[mm]	[mm]	[mm]	[mm]		[mm]			

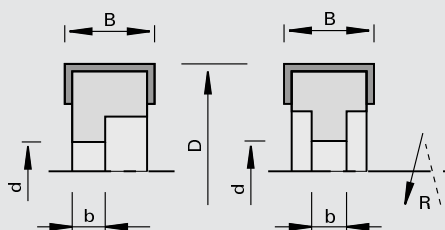
120100

Edge Jointing Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min⁻¹

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
50	12	10	16	4	5x2,3	Sudhoff, EBM, Ney	167258
50	12	10	16	2	5x2,3	Homag, Homburg	164066 s
50	15	10	16	4	5x2,3	EBM	179139
50	15	10	16	2	5x2,3	IMA, Raimann	164067
61	12	10	16	3	5x2,3	Homag	167899 s
61	20	11	16	3	5x2,3	Homag	167900 s
70	12	10	16	6	5x2,3	Brandt, Homag	164073
70	12	10	16	4	5x2,3	Brandt, Homag	164068 s
70	20	11	16	2	5x2,3	Reich	182077 s
70	20	11	16	4	5x2,3	Homag, HOLZ-HER 1823, Biesse Akron 400 RS 502	164071
70	20	20	16	4	5x2,3	Ott	164069
70	20	12.5	20	6	2/6x3,5	IMA, SCM-IDM	164134 s 164080 s
70	20	12.5	20	4	6x3,5	Brandt, Homag	164133 s 164079 s
70	20	11	20	4	6x3,5	HOLZ-HER	164070 s
80	40	25	30	4	8x3,3	HOLZ-HER	164072
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080
	15	12	1.5	150515	10	003081
	20	12	1.5	150515	10	003082
	40	12	1.5	150515	10	164078
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	164066, 164067, 164068, 164073, 167258, 167899, 179139	925300	2	164526
Pressure Bars	B=18	164069, 164070, 164071, 164079, 164080, 164133, 164134, 167900, 182077	925300	2	164076
Pressure Bars	B=39	164072	925300	2	164077
Set Screws	M6x10 DIN EN ISO 4028	164066, 164067, 164068, 164073, 167258, 167899, 179139	995161	10	180002
Set Screws	M6x12 DIN EN ISO 4028	164069, 164070, 164071, 164072, 164079, 164080, 164133, 164134, 167900, 182077	995161	10	180214
Screwdrivers	SW3x100	For all	985730	1	166090
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672
	[mm]				[pc.]

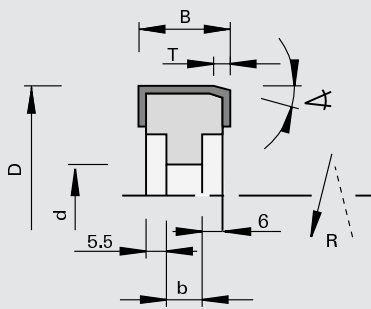
120100

Edge Jointing Cutterheads HW - HOLZ-HER

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
HOLZ-HER
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

cutting edges parallel to cutter
axis
cutting material: HW HL Board
06
n max = 18,000 min-1

Advantages

Notes

sense of rotation according to
DIN-EN 50144

Chamfer \sphericalangle	$\varnothing D$	B	b	$\varnothing d$	T	Z		Ident-No. [L]	Ident-No. [R]
15 [°]	70 [mm]	29,5 [mm]	17 [mm]	20 [mm]	5,0 [mm]	4	HOLZ-HER	164462 s	164463 s

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for counter-clockwise rotation	29,5	12	1.5	150515	10	160618
for clockwise rotation	29,5	12	1.5	150515	10	160118
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=30	925300	2	164185
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Screwdrivers	SW3x100 [mm]	985730	1	166090
			[pc.]	

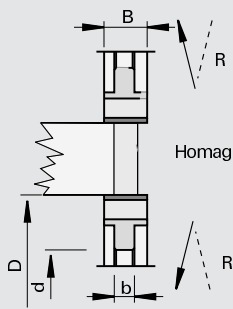
120101

Edge Jointing Cutterheads HW - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN		Ident-No.
70	14,3	10	16	4	5x2,3	Homag	170247 s
70	20	10	16	4	5x2,3	Homag	168510 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3	14,3	2,5	150517	10	170248
	20	14,3	2,5	150517	10	168509
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20	995125	10	166709
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

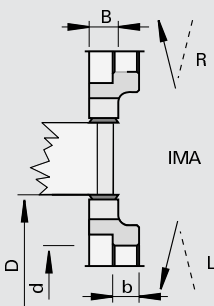
120101

Edge Jointing Cutterheads HW - IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70 [mm]	14,3 [mm]	13 [mm]	20 [mm]	4	6x3,5 [mm]	IMA	172717 s 172718 s

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3 [mm]	14,3 [mm]	2,5 [mm]	150517	10	170248

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20	995125	10	166709
Screwdrivers	T20x100 [mm]	985730	1 [pc.]	166092

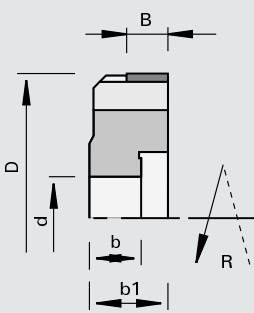
222210

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, SCM-IDM, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l polished face and high-finish clearance angle
l reduced resharpenable area
l straight cutter axis
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	b1	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70 [mm]	10 [mm]	12,5 [mm]	19 [mm]	20 [mm]	4	6x2,8 [mm]	Brandt, Homag, IMA	175787 s 175788 s
70 [mm]	10 [mm]	12,5 [mm]	19 [mm]	20 [mm]	6	5x2,3 [mm]	SCM-IDM	175789 s 175788 s

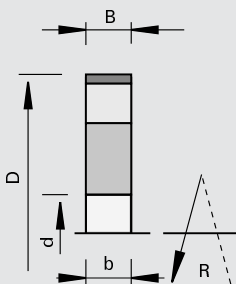
222510

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, Biesse

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Biesse Akron 400 RS 502
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- reduced resharpener area 2.0 mm
- straight cutter axis
- n max = 24,000 min⁻¹

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

Ø D	B	b	Ø d	Z	DKN	Ident-No.
70	10	10	16	4	5x2,3	175779
70	10	10	16	6	5x2,3	175780
[mm]	[mm]	[mm]	[mm]		[mm]	

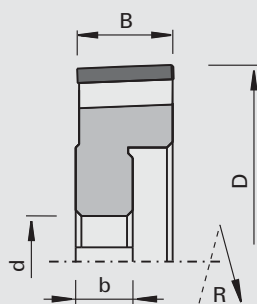
222510

DIAMAX Edge Jointing Cutters CM DP - Ott

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Ott
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min⁻¹

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70	16,5	10	16	4	5x2,3	185677 #	185678 #
[mm]	[mm]	[mm]	[mm]		[mm]		

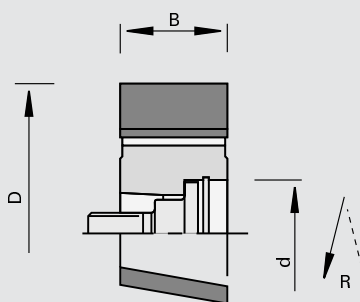
122110

Edge Jointing Cutters HW HSK 25R - Homag, IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag, IMA
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70 [mm]	35 [mm]	HSK 25R [mm]	4	178035 s	178034 s

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	10	177782 [pc.]

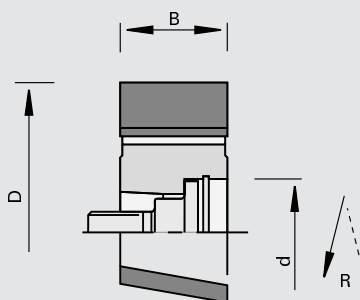
122110

Edge Jointing Cutters CM HW HSK 25R - Homag

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing
l optimized chip removal thanks to internal chip evacuation
l less chips remain inside of the machine
l no malfunctions due to chips
l reduction of suction power
l noise reduced

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70 [mm]	25 [mm]	HSK 25R [mm]	4	180765	180766

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

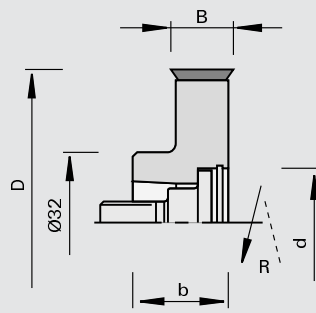
120101

Edge Jointing Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag, IMA
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis, with 4 cutting edges
l cutting material: HW HL Solid 20
l n max = 18,000 min-1

Advantages

l excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	14,3	23	HSK 25R	4	177592	177591
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14,3	14,3	2,5	150517	10	170248
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20	995125	10	166709
Screwdrivers	T20x100	985730	1	166092
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

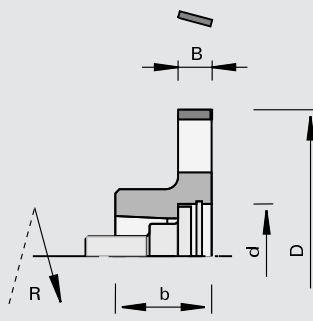
222510

DIAMAX-Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag, IMA
for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

polished face and high-finish clearance angle
with shear angle
n max = 24,000 min⁻¹

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing
low purchase price thanks to large-scale manufacturing

Notes

not resharpenable because constant (zero) diameter must be maintained
sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	8,0	23	HSK 25R	4	177651	177652
70	15	23	HSK 25R	4	177653	177654
70	8,0	23	HSK 25R	6	180492	180493
70	15	23	HSK 25R	6	180494 s	180495 s
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

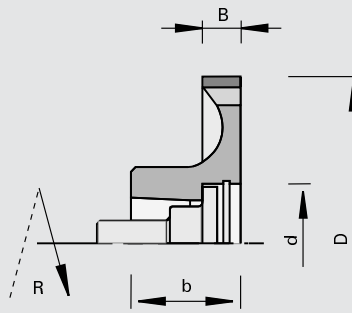
222812

Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO
topline

LEUCO
i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
Homag, aggregate FF and
finish milling, IMA
- | for flush-cutting and chamfer-
ing of solid wood, veneer and
plastic edge bands

Design

- | polished face and high-finish
clearance angle
- | with shear angle

Advantages

- | highest concentricity
- | optimized chip removal thanks
to internal chip evacuation
- | less chips remain inside of the
machine
- | no malfunctions due to chips
- | reduction of suction power
- | noise reduced
- | low purchase price thanks to
large-scale manufacturing

Notes

- | Z = 4 for feed rate 20 - 30 m/
min
- | Z = 6 for feed rate 30 - 45 m/
min
- | Z = 8 for feed rate 45 - 60 m/
min
- | machines must be equipped
with i-System
- | constant basic dimensions
- | sense of rotation according to
DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	15	23	HSK 25R	4	180934 s	180935 s
70	15	23	HSK 25R	6	180936 s	180937 s
70	8,0	23	HSK 25R	4	181176	181177
70	8,0	23	HSK 25R	6	181178	181179
70	8,0	23	HSK 25R	8	181180 s	181181 s
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

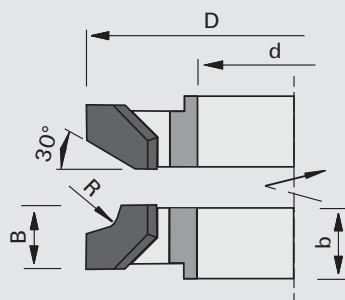
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

122110

Edge Rounding / Chamfering Cutters HW one-part version - IMA (BIMA)

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135

for flush-cutting and rounding or chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle

one part version

n max = 18,000 min-1

Advantages

Notes

sense of rotation according to DIN-EN 50144

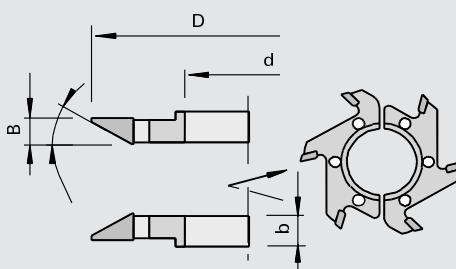
R	Chamfer◁	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
1,0		65	10	10.7	30	6	IMA (BIMA)	192419	192418
1,3		65	10	10.7	30	6	IMA (BIMA)	192573 s	192574 s
1,5		65	10	10.7	30	6	IMA (BIMA)	184351	184352
2,0		65	10	10.7	30	6	IMA (BIMA)	184353	184354
2,5		65	10	10.7	30	6	IMA (BIMA)	192575 s	192576 s
3,0		65	10	10.7	30	6	IMA (BIMA)	184355	184356
	2	65	10	10.7	30	6	IMA (BIMA)	192577 s	192578 s
	15	65	10	10.7	30	6	IMA (BIMA)	192579 s	192580 s
	30	65	10	10.7	30	6	IMA (BIMA)	184357	184358
	45	65	10	10.7	30	6	IMA (BIMA)	192581 s	192582 s
[mm]	[°]	[mm]	[mm]	[mm]	[mm]				

122110

Edge Chamfering Cutters HW two-part version - IMA (BIMA)

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135

for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle

two part version

n max = 18,000 min-1

Advantages

Notes

sense of rotation see drawing

Chamfer◁	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
30	70	9,0	9,0	30	6	IMA (BIMA)	180164	180163
[°]	[mm]	[mm]	[mm]	[mm]				

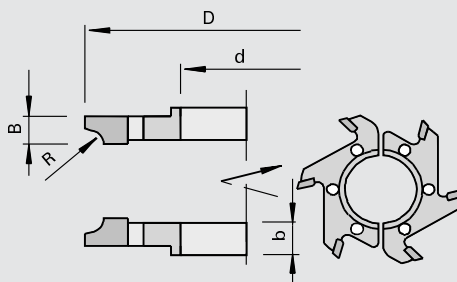
122110

Edge Rounding Cutters HW two-part version - IMA (BIMA)

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135
l for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

l two part version
l with shear angle
l n max = 18,000 min-1

Advantages

Notes

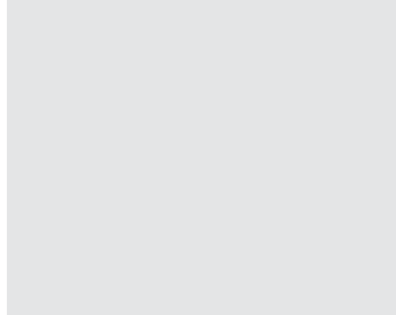
l sense of rotation see drawing

R	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
2,0	70	6,0	6,0	30	6	IMA (BIMA)	180155 s	180156 s
2,0	70	9,0	9,0	30	6	IMA (BIMA)	180157	180158
3,0	70	9,0	9,0	30	6	IMA (BIMA)	180167	180168
[mm]	[mm]	[mm]	[mm]	[mm]				

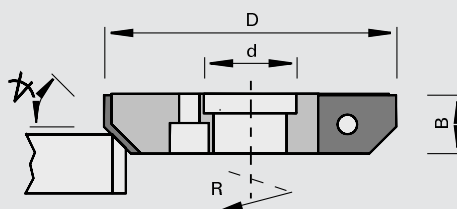
120102

Edge Chamfering Cutterheads HW for machining centers - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l machining center Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l delivery with 3 additional profile knives
l sense of rotation according to DIN-EN 50144

Chamfer∠	Ø D	B	Ø d	Z		Ident-No. [L]	Ident-No. [R]
5	60	12	19	3		179207 s	179206 s
15	60	12	19	3		178634 s	178633 s
30	60	13,5	19	3		178632	178631
45	60	12	19	3		178630 s	178629 s
[°]	[mm]	[mm]	[mm]				

Knives	Chamfer∠	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	5	12	16	2.0	151586	10	179174	179173
	15	11,7	16	2.0	151586	10	177042	177045
	30	13,5	16	2.0	151586	10	177043	177046
	45	12,2	16	2.0	151586	10	177822	177823
	[°]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	11x10x7	925300	2	178759
Magnetic Stops	0,0	997800	1	016613
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Screwdrivers	SW3x100	985730	1	166090
	[mm]		[pc.]	

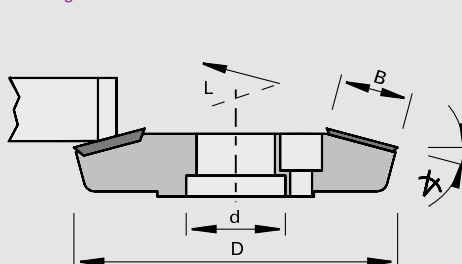
120101

Edge Chamfering Cutterheads HW for machining centers (particularly for thin edge bands) - Homag

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l machining center Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW
l n max = 18,000 min-1

Advantages

Notes

l especially for thin edge bands
l sense of rotation according to DIN-EN 50144

Chamfer	Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
5	78	11,5	19	3	186577 s	186576 s
15	62	14	19	3	178640	178639
[°]	[mm]	[mm]	[mm]			

Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	178639, 178640	150558	10	003079
Triangular Spur	22	19.05	2.0	186576, 186577	150557	10	180779
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6,8 T15	186576, 186577	995125	10	180839
Countersunk Screws	M5x6 T20	178639, 178640	995125	10	176199
Screwdrivers	T20x100	178639, 178640	985730	1	166092
	[mm]			[pc.]	

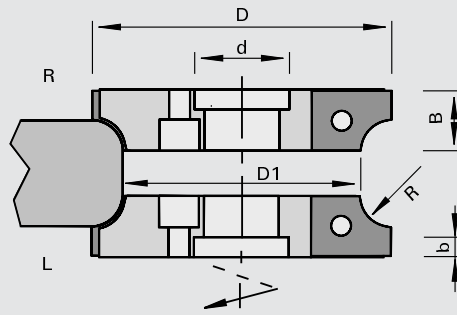
120102

Edge Rounding Cutterheads HW for machining centers - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l machining center Homag
l for rounding of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 06
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R 1.5 - 3 mm; R 4 - 5 mm
l included in delivery: 3 additional spare knives
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	59	50	15	4.0	19	3	185197 &	185198 &
1,5	59	50	15	4.0	19	3	185199 &	185200 &
2,0	59	50	15	4.0	19	3	180749 &	180748 &
2,5	59	50	15	4.0	19	3	185201 s	185202 s
3,0	59	50	15	4.0	19	3	180751 &	180750 &
4,0	63	50	15	4.0	19	3	178795 s	178794 s
5,0	63	50	15	4.0	19	3	178797 s	178796 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	1,0	13	15	2.0	151545	10	180722	180721
	1,5	13	15	2.0	151545	10	181954	181953
	2,0	13	15	2.0	151545	10	181956	181955
	2,5	13	15	2.0	151545	10	180728 s	180727 s
	4,0	14	17	2.0	151546	10	177036 s	177040 s
	5,0	15	17	2.0	151545	10	177037	177041
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	11x10x7	925300	2	178759
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Screwdrivers	SW3x100	985730	1	166090
Magnetic Stops	1,0	997800	1	166094
Magnetic Stops	0,0	997800	1	016613
	[mm]			[pc.]

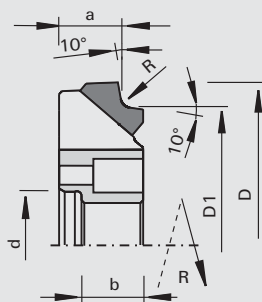
222582

DIAMAX high power Edge Rounding Cutters DP for machining center - Homag

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l machining center Homag
l for rounding of solid wood,
vener and plastic edge bands

Design

l polished face
l high-finish clearance angle
l with shear angle
l very high balance quality
l Z6 design
l n max = 24,000 min-1

Advantages

l excellent cutting quality thanks
to excellent balance quality and
high number of teeth
l possibility to do without scraper
knife processing

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
1,0	59	50	11	11	19	6	3/4,2/25	185977 s	185978 s
1,5	59	50	11	11	19	6	3/4,2/25	185979 s	185980 s
2,0	59	50	11	11	19	6	3/4,2/25	185981 s	185982 s
3,0	59	50	11	11	19	6	3/4,2/25	185983 s	185984 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

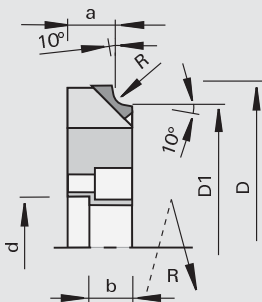
222582

DIAMAX Edge Rounding Cutters DP - Homag

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l machining center Homag
l for rounding of solid wood,
vener and plastic edge bands

Design

l polished face
l high-finish clearance angle
l with shear angle
l n max = 24,000 min-1

Advantages

l optimum cutting quality

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
1,0	57	50	11	9.5	19	3	3/4,2/25	179414 s	179415 s
2,0	57	50	11	9.5	19	3	3/4,2/25	179416	179417
3,0	57	50	11	9.5	19	3	3/4,2/25	179418 s	179419 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

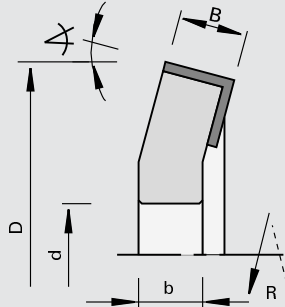
120120

Edge Chamfering Cutterheads HW - Homag

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min⁻¹

Advantages

Notes

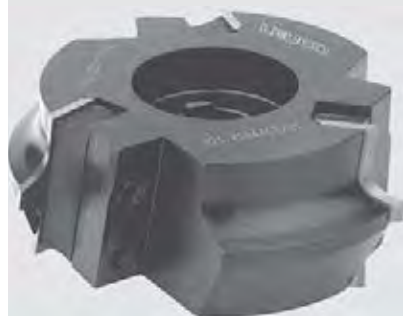
l sense of rotation according to DIN-EN 50144

Chamfer	∅ D	B	b	∅ d	Z	DKN		Ident-No. [L]	Ident-No. [R]
15 [°]	65 [mm]	12 [mm]	11 [mm]	16 [mm]	3	5x2,3 [mm]	Homag	167735 s	167734 s
Turnover Knives	B		H		S		Class-No.	PU	Ident-No.
	12 [mm]		12 [mm]		1.5 [mm]		150515	10 [pc.]	003080
Spare parts	Dimension						Class-No.	PU	Ident-No.
Pressure Bars	B=10						925300	2	164526
Set Screws	M6x12 DIN EN ISO 4028						995161	10	180214
Screwdrivers	SW3x100 [mm]						985730	1 [pc.]	166090

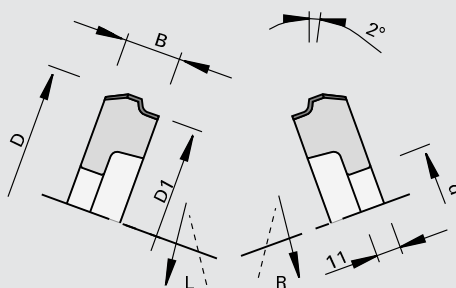
120102

Edge Rounding Cutterheads HW - Homag Softforming

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
Homag during the softforming
process
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
cutting material: HW HL Board
05
n max = 18,000 min-1

Advantages

Notes

same cutterhead body for R
2 - 3 mm; R 5 - 8 mm
sense of rotation see drawing

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	75	66	20,5	11	16	3	5x2,3	163079 s	163080 s
3,0	75	66	20,5	11	16	3	5x2,3	163081 ♂	163082 ♂
5,0	80	66	30	11	16	3	5x2,3	163085 ♂	163086 ♂
6,0	80	66	30	11	16	3	5x2,3	163087 ♂	163088 ♂
8,0	80	66	30	11	16	3	5x2,3	163091 s	163092 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
	2,0	20,5	15	2,0	151545	10	163062 s
	3,0	20,8	15	2,0	151545	10	163063
	5,0	30	17	2,0	151545	10	163065
	6,0	30,5	17	2,0	151545	10	163066
	8,0	30,5	17	2,0	151545	10	163068 s
	[mm]	[mm]	[mm]	[mm]		[pc.]	

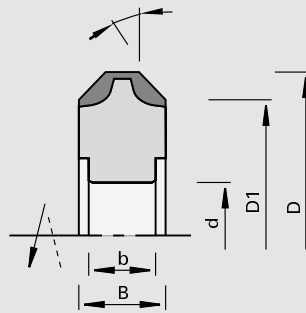
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=18	163079, 163080, 163081, 163082	925300	2	163077 s
Pressure Bars	B=27,6	163085, 163086, 163087, 163088, 163089, 163090, 163091, 163092	925300	2	163078 s
Set Screws	M6x12 DIN EN ISO 4028	For all	995161	10	180214
Screwdrivers	SW3x100	For all	985730	1	166090
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672
Magnetic Stops	0,0	For all	997800	1	016613
	[mm]				[pc.]

120102

Edge Chamfering Cutterheads HW

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
l for chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l for clockwise and counter-clockwise rotation
l sense of rotation according to DIN-EN 50144

Chamfer∠	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No.
45	57	50	12	12	16	2	5x2,3 HOLZ-HER	171189 &
45	62	50	16	10	16	2	5x2,3 HOLZ-HER	173379 &
45	73	61	16	11	16	3	5x2,3 Homag	173380 &
45	82	70	16	11	16	4	5x2,3 Brandt	172728 &
45	73	61	16	11	20	3	6x3,5 HOLZ-HER	173381 &
45	82	70	16	11	20	4	6x3,5 IMA, Wilmsmeyer	172729 &
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Knives	Chamfer∠	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 57	45	12	12	1.5	151545	10	171190
for Ø D = 62/73/82	45	16	17.5	2.0	151545	10	169292
	[°]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=15,6	173379, 173380, 173381	925300	2	169246
Pressure Bars	B=15,6	172728, 172729	925300	2	163488
Set Screws	M6x12 DIN EN ISO 4028	For all	995161	10	180214
Cranked Wrench Keys	SW2,5 DIN ISO 2936	For all	985730	1	009671
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672
Magnetic Stops	0,0 [mm]	For all	997800	1	016613
					[pc.]

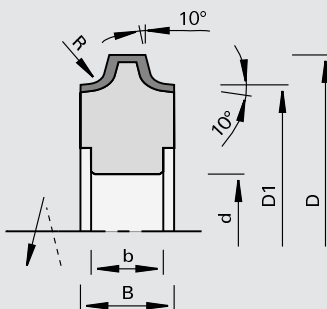
120102

Edge Rounding Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

Notes

l for clockwise and counter-clockwise rotation
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN		Ident-No.
2,0	57	50	12	12	16	2	5x2,3	HOLZ-HER	170338 s
3,0	57	50	12	12	16	2	5x2,3	HOLZ-HER	170339 s
2,0	58	50	12	10	16	4	5x2,3	Brandt	177030
3,0	58	50	12	10	16	4	5x2,3	Brandt	177031 &
2,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	179997 s
3,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	169241 s
5,0	62	50	16	10	16	2	5x2,3	HOLZ-HER	169243 s
2,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171128
3,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171129 &
4,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171130 &
5,0	73	61	16	11	16	3	5x2,3	Homag, Ott	171131 &
6,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170254 &
8,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170256 &
9,0	81	61	24	11	16	3	5x2,3	Homag, Ott	170257 &
2,0	78	70	16	11	16	4	5x2,3	Brandt	182086 &
2,0	82	70	16	11	16	4	5x2,3	Brandt	170192 &
3,0	82	70	16	11	16	4	5x2,3	Brandt	170193 &
4,0	82	70	16	11	16	4	5x2,3	Brandt	170194 &
5,0	82	70	16	11	16	4	5x2,3	Brandt	170195 &
2,0	73	61	16	11	20	3	6x3,5	HOLZ-HER	171132 &
3,0	73	61	16	11	20	3	6x3,5	HOLZ-HER	171133 &
4,0	73	61	16	11	20	3	6x3,5	HOLZ-HER	171134 &
5,0	73	61	16	11	20	3	6x3,5	HOLZ-HER	171135 &
2,0	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166882 &
3,0	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166881 &
4,0	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166880 &
5,0	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166879 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives

	R	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 57	2,0	12	12	1,5	151545	10	170340
for Ø D = 57	3,0	12	12	1,5	151545	10	170341
for Ø D = 58	2,0	12	13	2,0	151545	10	177033
for Ø D = 58	3,0	12	13	2,0	151545	10	177032
for Ø D = 78	2,0	16	15,5	2,0	151545	10	182087
for Ø D = 81	6,0	24	22	2,0	151545	10	170258
for Ø D = 81	8,0	24	22	2,0	151545	10	170260
for Ø D = 81	9,0	24	22	2,0	151545	10	170261 #
for Ø D = 62/73/82	1,0	16	17,5	2,0	151545	10	186745
for Ø D = 62/73/82	1,5	16	17,5	2,0	151545	10	176583
for Ø D = 62/73/82	2,0	16	17,5	2,0	151545	10	163489
for Ø D = 62/73/82	3,0	16	17,5	2,0	151545	10	163490
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Knives	R	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 62/73/82	4,0	16	17.5	2.0	151545	10	163491
for Ø D = 62/73/82	5,0	16	17.5	2.0	151545	10	163492
	[mm]	[mm]	[mm]	[mm]		[pc.]	
Spare parts	Dimension	For Ident-No.			Class-No.	PU	Ident-No.
Pressure Bars	B=10,5	177030, 177031			925300	2	175640
Pressure Bars	B=15,6	169241, 169243, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997			925300	2	169246
Pressure Bars	B=15,6	166879, 166880, 166881, 166882, 170192, 170193, 170194, 170195, 182086			925300	2	163488
Pressure Bars	24x14,5x7	170254, 170256, 170257			925300	2	170262
Set Screws	M5x12 DIN EN ISO 4028	177030, 177031			995161	10	050565
Set Screws	M6x12 DIN EN ISO 4028	166879, 166880, 166881, 166882, 169241, 169243, 170192, 170193, 170194, 170195, 170338, 170339, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997, 182086			995161	10	180214
Set Screws	M8x12 DIN EN ISO 4028	170254, 170256, 170257			995161	10	180001
Magnetic Stops	0,0	For all			997800	1	016613
Cranked Wrench Keys	SW2,5 DIN ISO 2936	For all			985730	1	009671
Cranked Wrench Keys	SW3 DIN ISO 2936	For all			985730	1	009672
	[mm]					[pc.]	

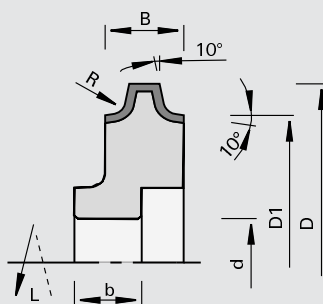
120102

Edge Rounding Cutterheads HW - IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

l same cutter head body for
radius 1 - 5 mm and chamfer

Notes

l sense of rotation see drawing

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	82	70	16	13	20	4	6x3,5	168373 s	168374 s
3,0	82	70	16	13	20	4	6x3,5	168353 s	168354 s
4,0	82	70	16	13	20	4	6x3,5	168375 s	168376 s
5,0	82	70	16	13	20	4	6x3,5	168377 s	168378 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	Chamfer \sphericalangle	R	B	H	S	Class-No.	PU	Ident-No.
Chamfering Knives	45		16	17.5	2.0	151545	10	169292
Radius Knives		1,0	16	17.5	2.0	151545	10	186745
Radius Knives		2,0	16	17.5	2.0	151545	10	163489
Radius Knives		3,0	16	17.5	2.0	151545	10	163490
Radius Knives		4,0	16	17.5	2.0	151545	10	163491
Radius Knives		5,0	16	17.5	2.0	151545	10	163492
	[°]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=15,6	925300	2	163488
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672
	[mm]		[pc.]	

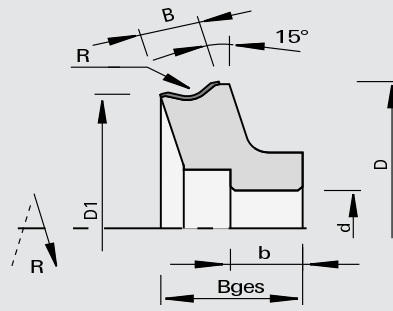
120102

Edge Rounding Cutters HW (cranked) - IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R
2 - 4 mm
l sense of rotation see drawing

R	Ø D	Ø D1	B	b	b1	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
4,0	77.6	70	13	13	27.9	20	4	6x3,5	172712 s	172711 s
3,0	77.6	70	13	13	27.9	20	4	6x3,5	172710 s	172709 s
2,0	77.6	70	13	13	27.9	20	4	6x3,5	172708 s	172707 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
	2,0	13	16	2.0	151555	10	172713
	3,0	13	16	2.0	151555	10	172714
	4,0	13	16	2.0	151555	10	172715 s
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=12	925300	2	162095
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672
	[mm]		[pc.]	

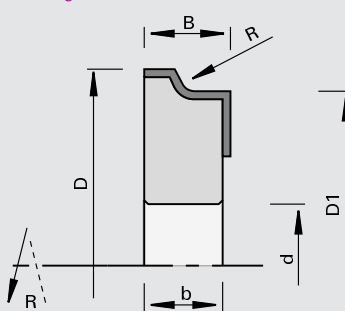
120102

Edge Rounding Cutterheads HW - Brandt

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines Brandt
l for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l with shear angle
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

l optimum cutting quality on solid
wood edges thanks to cutting
edges with shear angle

Notes

l same cutterhead body for R
2 - 3 mm
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	78	70	18,5	10	16	4	5x2,3	180441 s	180440 s
3,0	78	70	18,5	10	16	4	5x2,3	173389 s	173388 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

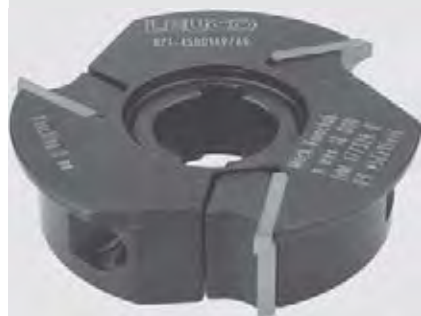
Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	19,6	15.2	2.0	15 1546	10	173817	173816
	3,0	19,6	15.2	2.0	15 1545	10	173393	173392
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=17	For all	925300 2	167971
Set Screws	M6x10 DIN EN ISO 4028	For all	995161 10	180002
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730 1	009672
Magnetic Stops	0,0	For all	997800 1	016613
	[mm]			[pc.]

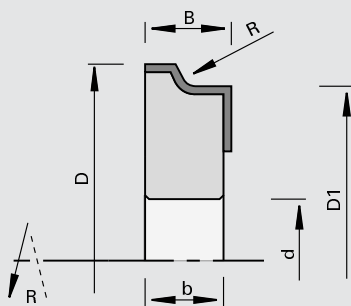
120102

Edge Rounding Cutterheads HW - Brandt, EBM, HOLZ-HER 1942M

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines
Brandt, EBM, HOLZ-HER
1942M
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

cutting edges parallel to cutter
axis
cutting material: HW HL Board
05
n max = 18,000 min-1

Advantages

Notes

same cutterhead body for R
2 - 3 mm
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	56	50	15	11	16	3	5x2,3	179995	179996
2,5	56	50	15	11	16	3	5x2,3	177325 &	177326 &
3,0	56	50	15	11	16	3	5x2,3	177327 #	177328 #
2,0	56	50	12	11	16	4	5x2,3	172138	172137
3,0	56	50	12	11	16	4	5x2,3	172140 s	172139 s
2,0	56	50	16	11	16	4	5x2,3	178215 s	178214 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	12	14.5	2.0	151545	10	172142	172141
	3,0	12	14.5	2.0	151545	10	172144	172143
	2,0	15	14.5	2.0	151545	10	177317	177318
	2,5	15	14.5	2.0	151545	10	177319	177320
	3,0	15	14.5	2.0	151545	10	177321	177322
	2,0	16,1	14	2.0	151546	10	178219	178218
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	172137, 172138, 172139, 172140	925300	2	171221
Pressure Bars	B=13	177325, 177326, 177327, 177328, 179995, 179996	925300	2	177332
Pressure Bars	B=15	178214, 178215	925300	2	178213 o
Set Screws	M5x10 DIN EN ISO 4026	172137, 172138, 172139, 172140	995161	10	180028
Set Screws	M6x12 DIN EN ISO 4028	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	995161	10	180214
Magnetic Stops	0,0	For all	997800	1	016613
Cranked Wrench Keys	SW2,5 DIN ISO 2936	172137, 172138, 172139, 172140	985730	1	009671
Cranked Wrench Keys	SW3 DIN ISO 2936	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	985730	1	009672
	[mm]				[pc.]

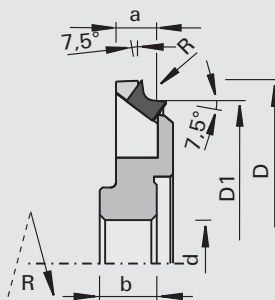
222582

DIAMAX Edge Rounding Cutters CM DP - Ott

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines Ott
l for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l polished face
l high-finish clearance angle
l with shear angle
l n max = 24,000 min-1

Advantages

l optimized chip removal thanks
to ChipMeister version
l less chips remain inside of the
machine
l no malfunctions due to chips
l reduced suction performance
l low noise level

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	69	61	10	10.5	16	4	5x2,3	185681 s	185682 s
2,0	69	61	10	10.5	16	4	5x2,3	185679	185680
3,0	69	61	10	10.5	16	4	5x2,3	185683 s	185684 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

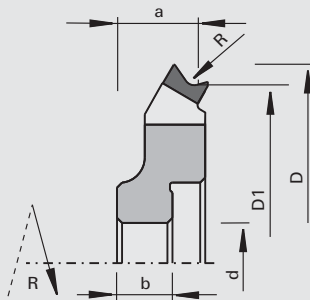
222582

DIAMAX Edge Rounding Cutters DP - Ott HFR 06.2

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines Ott
HFR 06.2
l for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l polished face
l high-finish clearance angle
l without shear angle
l n max = 23,800 min-1

Advantages

l optimum cutting quality

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	80	72	15.3	11	16	4	5x2,3	185685 s	185686 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

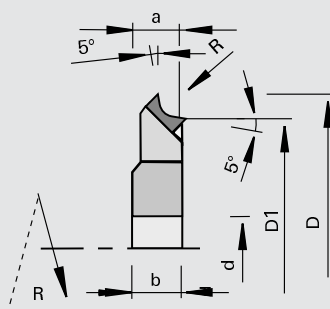
222282

DIAMAX Edge Rounding Cutters DP - HOLZ-HER

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
HOLZ-HER
l for rounding of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min-1

Advantages

Notes

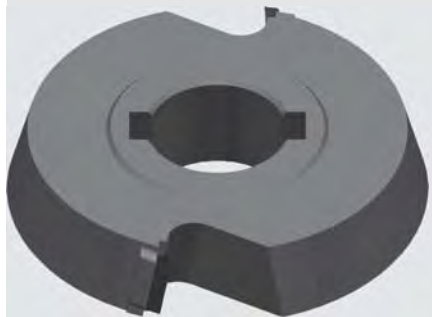
l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	57	50	8.5	12.5	16	2	5x2,3	182141	182142
2,5	57	50	8.5	12.5	16	2	5x2,3	182143 s	182144 s
3,0	57	50	8.5	12.5	16	2	5x2,3	182145 s	182146 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

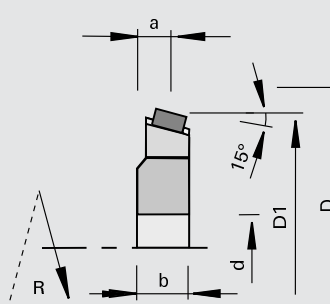
222512

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
HOLZ-HER
l for chamfering of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min-1

Advantages

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

Chamfer<	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
15	52	50	8.5	12.5	16	2	5x2,3	182147 s	182148 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

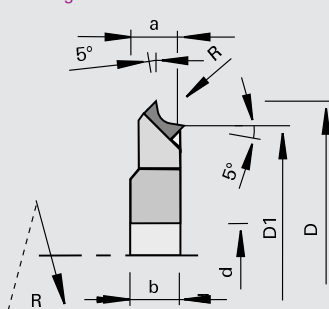
222582

DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1832

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1832
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
n max = 24,000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

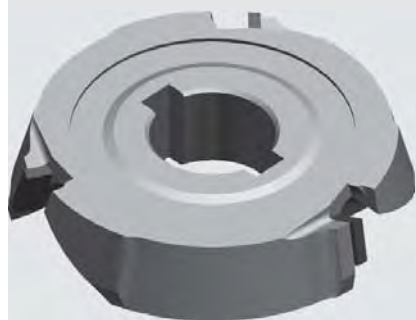
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
1,0	58.7	50	8.5	12	16	3	5x2,3	186581 s
1,3	58.7	50	8.5	12	16	3	5x2,3	186580
2,0	58.7	50	8.5	12	16	3	5x2,3	182684
2,5	58.7	50	8.5	12	16	3	5x2,3	182685 s
3,0	58.7	50	8.5	12	16	3	5x2,3	182686
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

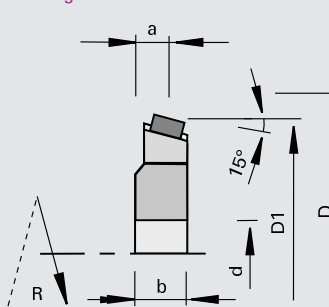
222512

DIAMAX Edge Chamfering Cutters CM DP - HOLZ-HER 1832

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1832
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area 3.5 mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
15	53	50	10	12	16	3	5x2,3	182687 s
45	56	50	10	12	16	3	5x2,3	182688 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

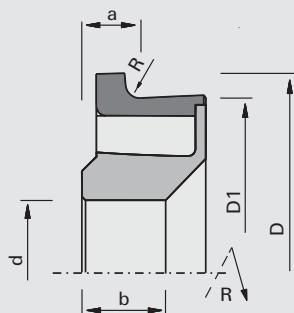
222312

DIAMAX Edge Rounding Cutters DP - HOLZ-HER 1827 - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
- | HOLZ-HER aggregate 1827
- | for rounding of solid wood, veneer and plastic edge bands

Design

- | AirStream-System
- | with shear angle
- | polished face and high-finish clearance angle
- | n max = 24,000 min-1

Advantages

- | considerably increased chip caption degree thanks to AirStream-System
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | very low noise level

Notes

- | constant basic dimensions a and D1
- | sense of rotation according to DIN-EN 50144
- | not for resharping

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	56	50	8.0	11.5	20	2	5x2,3	185440 s	185441 s
1,3	56	50	8.0	11.5	20	2	5x2,3	185434	185435
2,0	56	50	8.0	11.5	20	2	5x2,3	185436	185437
3,0	57	50	8.0	11.5	20	2	5x2,3	185438	185439
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

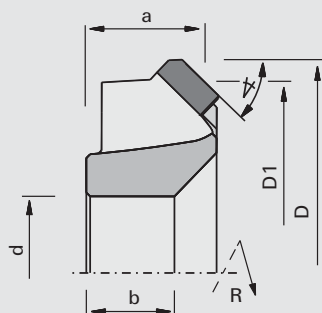
222312

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER 1827 - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
- | HOLZ-HER aggregate 1827
- | for chamfering of solid wood, veneer and plastic edge bands

Design

- | AirStream-System
- | with shear angle
- | polished face and high-finish clearance angle
- | n max = 24,000 min-1

Advantages

- | considerably increased chip caption degree thanks to AirStream-System
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | very low noise level

Notes

- | constant basic dimensions a and D1
- | sense of rotation according to DIN-EN 50144
- | not for resharping

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	57	50	16	11.5	20	2	5x2,3	185442 s	185443 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

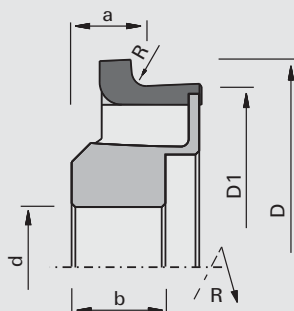
222312

DIAMAX Edge Rounding Cutters DP - HOLZ-HER FR201 - AirStream-System

Product



Drawing

AIR
STREAMLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate FR201
(1825M)
for rounding of solid wood,
veneer and plastic edge bands

Design

AirStream-System
with shear angle
polished face and high-finish
clearance angle
n max = 24,000 min-1

Advantages

considerably increased chip
caption degree thanks to
AirStream-System
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
very low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144
not for resharpening

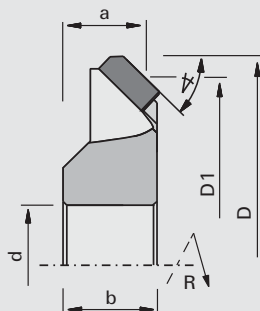
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	57	50	10	12.5	16	2	5x2,3	185430 s	185431 s
1,3	57	50	10	12.5	16	2	5x2,3	185424	185425
2,0	57	50	10	12.5	16	2	5x2,3	185426	185427
3,0	57	50	10	12.5	16	2	5x2,3	185428	185429
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222312

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER FR201 - AirStream-System

Product

Drawing

AIR
STREAMLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate FR201
(1825M)
for chamfering of solid wood,
veneer and plastic edge bands

Design

AirStream-System
with shear angle
polished face and high-finish
clearance angle
n max = 24,000 min-1

Advantages

considerably increased chip
caption degree thanks to
AirStream-System
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
very low noise level

Notes

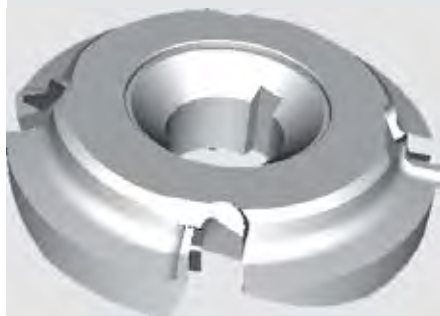
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144
not for resharpening

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	57	50	10	12.5	16	2	5x2,3	186115 s	186116 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

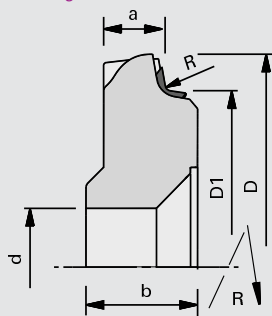
222582

DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1833

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate 1833
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

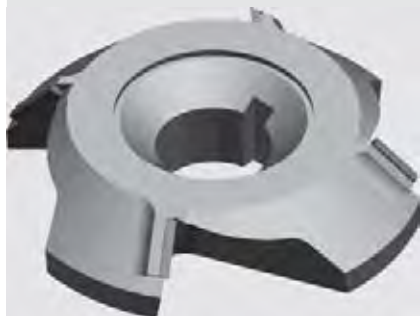
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	72.5	61	13.5	19	20	4	5x2,2	182501 s	182500 s
2,0	72.5	61	13.5	19	20	4	5x2,2	182503	182502
2,5	72.5	61	13.5	19	20	4	5x2,2	182505 s	182504 s
3,0	72.5	61	13.5	19	20	4	5x2,2	182507	182506
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

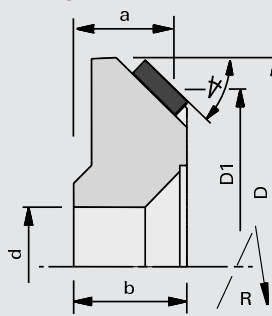
222582

DIAMAX Edge Chamfering Cutters CM DP - HOLZ-HER 1833

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate 1833
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	72.5	61	17	19	20	4	5x2,2	182509	182508
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

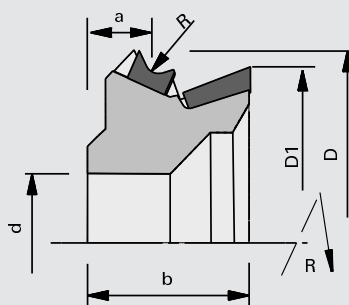
222282

Edge Rounding Trimming Cutters CM DP - HOLZ-HER 1826

Product



Drawing

LEUCO
toplineLEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1826
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area 3.5 mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	57.3	50	10.76	23	20	2	5x2,2	182481 s	182480 s
5,0	57.3	50	11.8	23	20	2	5x2,2	182489 s	182488 s
1,0	57.3	50	10.76	23	20	3	5x2,2	182491 s	182490 s
5,0	57.3	50	11.8	23	20	3	5x2,2	182499 s	182498 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

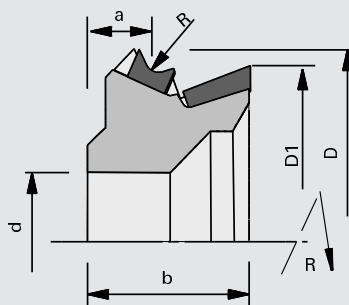
222312

Edge Rounding Trimming Cutters CM DP - HOLZ-HER 1826 - AirStream-System

Product



Drawing

AIR
STREAMLEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1826
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
AirStream-System
ChipMeister
n max = 24.000 min-1

Advantages

improved chip removal thanks
to ChipMeister version and
AirStream-System
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]	
2,0	55	50	11.02	23.6	20	2+2	5x2,2	HOLZ-HER 1826	184735	184734
2,5	55.8	50	11.15	23.8	20	2+2	5x2,2	HOLZ-HER 1826	184737 #	184736 #
3,0	56	50	11.28	23.9	20	2+2	5x2,2	HOLZ-HER 1826	184739	184738
2,0	55	50	11.02	23.6	20	3+3	5x2,2	HOLZ-HER 1826	184741	184740
2,5	55.8	50	11.15	23.8	20	3+3	5x2,2	HOLZ-HER 1826	184743 s	184742 s
3,0	56	50	11.28	23.9	20	3+3	5x2,2	HOLZ-HER 1826	184745 s	184744 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

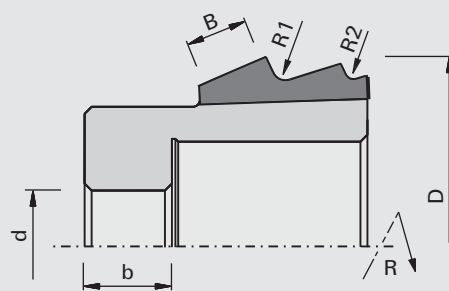
222212

DIAMAX Multi-profile edge trimming cutter DP - HOLZ-HER FR502 Multi - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate FR502
- for flush-cutting, rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min⁻¹

Advantages

- Significantly increased chip caption degree thanks to AirStream-System
- No contamination of the machine with chips
- No malfunctions due to chips
- Reduction of the extraction output
- Very low noise level

Notes

- not for resharping
- constant basic dimensions
- sense of rotation according to DIN-EN 50144

B	R1	R2	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
10	2.0	1.3	55.8	12.5	16	2	5x2,3	186787	186786
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

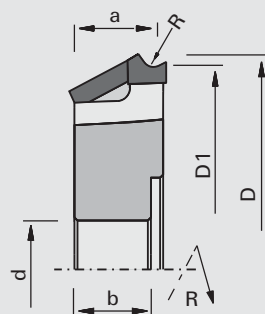
222312

DIAMAX Edge Rounding Flush-Cutting Cutters - HOLZ-HER FR701 - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate FR701
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- AirStream-System
- n max = 24,000 min⁻¹

Advantages

- considerably increased chip caption degree thanks to AirStream-System
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- very low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144
- not for resharping

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	72.7	68	14	12.5	16	2+2	5x2,3	185874 s	185451 s
1,3	72.4	68	14	12.5	16	2+2	5x2,3	185875	185445
2,0	71.8	68	14	12.5	16	2+2	5x2,3	185876	185447
3,0	70.9	68	14	12.5	16	2+2	5x2,3	185877	185449
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

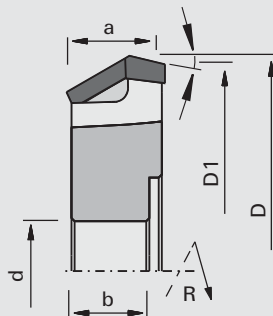
222312

Edge Chamfering Trimming Cutter CM DP - HOLZ-HER 1826 - AirStream-System

Product



Drawing

AIR
STREAMLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate FR701
for chamfering and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
AirStream-System
n max = 24,000 min-1

Advantages

considerably increased chip caption degree thanks to AirStream-System
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
very low noise level

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144
not for resharping

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45°	70.5 [mm]	68 [mm]	14 [mm]	12.5 [mm]	16 [mm]	2+2	5x2,3 [mm]	185878 s	185453 s

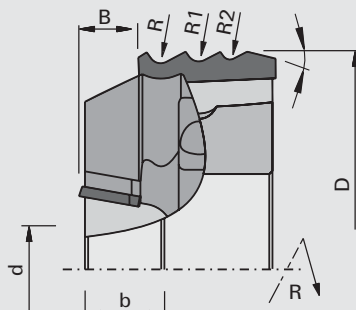
222212

DIAMAX Multi-profile edge trimming cutter DP - HOLZ-HER FR701 Multi - AirStream-System

Product



Drawing

AIR
STREAMLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines HOLZ-HER aggregate FR701 Multi
for flush-cutting, rounding and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
AirStream-System
n max = 24,000 min-1

Advantages

increased chip caption degree thanks to AirStream-System
less chips remain inside of the machine
less malfunctions due to chips
reduction of suction power
noise-reduced - combination of 4 different profiles and flush trimming cutting edge
different profiles without tool change

Notes

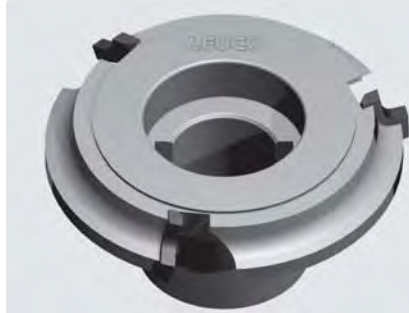
not for resharping
constant basic dimensions
sense of rotation according to DIN-EN 50144

B	R	R1	R2	Chamfer	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
8,0 [mm]	2,0 [mm]	1,3 [mm]	2,0 [mm]	2,0 [mm]	70,9 [mm]	12,5 [mm]	16 [mm]	2+2	5x2,3 [mm]	186884	186885
8,0 [mm]	2,0 [mm]	2,0 [mm]	1,3 [mm]	45 [mm]	70,9 [mm]	12,5 [mm]	16 [mm]	2+2	5x2,3 [mm]	185467	185466
8,0 [mm]	3,0 [mm]	2,0 [mm]	1,3 [mm]	45 [mm]	70,9 [mm]	12,5 [mm]	16 [mm]	2+2	5x2,3 [mm]	185465	185464

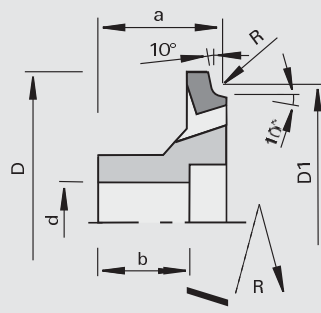
122110

Edge Rounding Cutters HW - SCM-Stefani Round/K

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines Stefani with ED system and aggregate Round/K
for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 30,000 min-1

Advantages

optimized chip removal
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	55,7	49,9	25,4	20	16	3	5x2,3	182446 s	182447 s
1,5	55,7	50,9	25,4	20	16	3	5x2,3	182448 s	182449 s
2,0	55,7	51,9	25,4	20	16	3	5x2,3	182450	182451
3,0	55,7	53,9	25,4	20	16	3	5x2,3	182454	182455
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

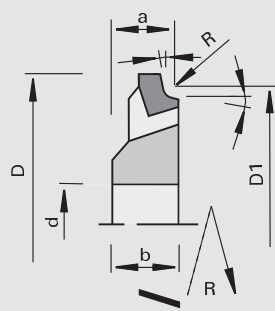
122212

Edge Rounding Cutters HW - SCM-Stefani K130

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines SCM-Stefani with aggregate K130
for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 30,000 min-1

Advantages

optimized chip removal
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	55,3	52	12	13,5	16	3	5x2,3	192213	192214
3,0	55,3	54	13	13,5	16	3	5x2,3	192216	192215
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

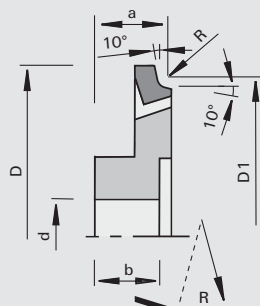
122122

Edge Rounding Cutters HW - SCM-IDM

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate C1 / C2
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 18,000 min-1

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	62,031	14.5	14	16	4	5x2,3	182911 s	182910 s
1,5	70	63,046	14.5	14	16	4	5x2,3	182909 s	182908 s
2,0	70	64,062	14.5	14	16	4	5x2,3	182907	182906
3,0	70	66,092	14.5	14	16	4	5x2,3	182903 s	182902 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

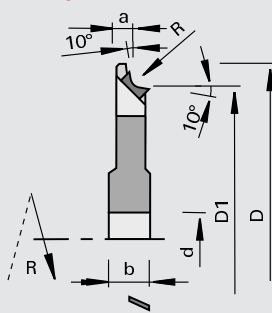
222582

DIAMAX Edge Rounding Cutters DP - SCM-Stefani

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM Stefani with ED-System
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

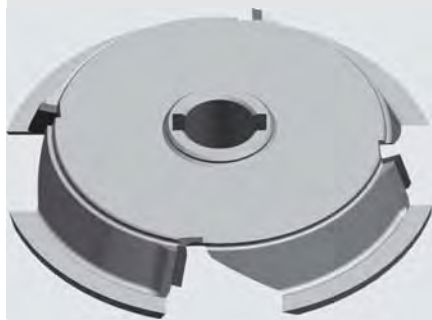
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	73	61,7	8.1	12	12	4	4x1,8	182288 s	182289 s
2,0	73	61,7	7.1	12	12	4	4x1,8	182292 s	182293 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

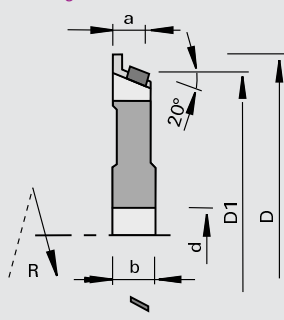
222512

DIAMAX Edge Chamfering Cutters DP - SCM-Stefani

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-Stefani with ED-System
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer [°]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
20	73	61,7	8.7	12	12	4	4x1,8	182302 s	182303 s

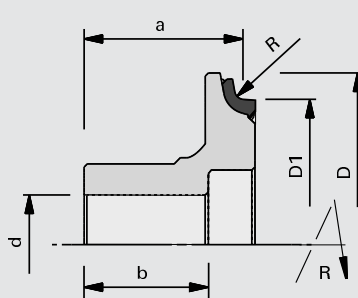
222310

Edge Rounding Cutters DP - SCM-IDM Round/K

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate Round/K
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
1,0	55.3	49,93	25.4	20	16	3	5x2,3	182416 s	182415 s
1,5	55.3	50,93	25.4	20	16	3	5x2,3	182418 s	182417 s
2,0	55.3	51,93	25.4	20	16	3	5x2,3	182414 s	182413 s
2,5	55.7	52,93	25.4	20	16	3	5x2,3	182424 s	182423 s
3,0	55.7	53,93	25.4	20	16	3	5x2,3	182412 s	182411 s

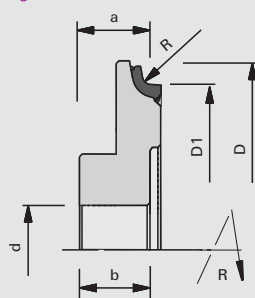
222310

Edge Rounding Cutters DP - SCM-IDM C1/C2

Product



Drawing

LEUCO
toplineLEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
SCM-IDM with ED system and
aggregate C1 / C2

for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle

$n_{max} = 18,000 \text{ min}^{-1}$

polished face and high-finish
clearance angle

Advantages

optimized chip removal

less chips remain inside of the
machine

no malfunctions due to chips

reduced suction performance

low noise level

Notes

constant basic dimensions a
and D1

sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	60	14.5	14	16	4	5x2,2	182901 s	182900 s
1,5	70	60	14.5	14	16	4	5x2,2	182899 s	182898 s
2,0	70	60	14.5	14	16	4	5x2,2	182897 s	182896 s
2,5	70	60	14.5	14	16	4	5x2,2	182895 s	182894 s
3,0	70	60	14.5	14	16	4	5x2,2	182893 s	182892 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

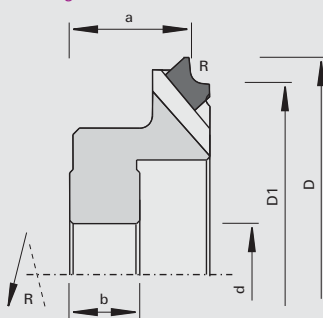
222280

DIAMAX Edge Rounding Cutters DP - Biesse Ergho, Akron

Product



Drawing

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machine Biesse
Ergho/Akron 200/800 - CR
200/CR 202

for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle

reduced resharpening area

$n_{max} = 24,000 \text{ min}^{-1}$

Advantages

Notes

constant basic dimensions a
and D1

sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	68	59,86	21	22.3	16	6	5x2,3	183699 s	183700 s
2,0	68	59,86	21	22.3	16	6	5x2,3	183701 s	183702 s
3,0	68	59,86	21	22.3	16	6	5x2,3	183703 s	183704 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

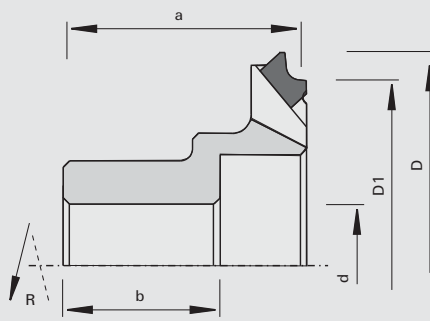
222580

DIAMAX Edge Rounding Cutters DP - Biesse

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines Biesse
l for rounding of solid wood, veneer and plastic edge bands

Design

l with shear angle
l polished face and high-finish clearance angle
l reduced resharpening area
l n max = 24,000 min-1

Advantages

l optimum cutting quality

Notes

l constant basic dimensions a and D1
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	67	60	38.5	39.5	20	6	6x2,8	183709 s	183710 s
2,0	67	60	38.5	39.5	20	6	6x2,8	183711 s	183712 s
3,0	67	60	38.5	39.5	20	6	6x2,8	183713 s	183714 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

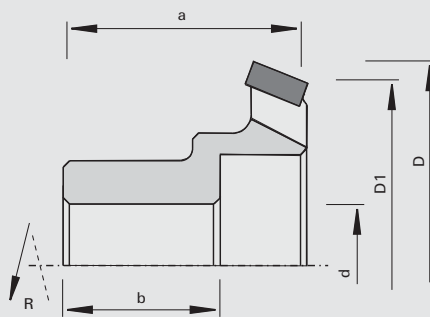
222510

DIAMAX Edge Chamfering Cutters DP - Biesse

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines Biesse
l for chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l polished face and high-finish clearance angle
l reduced resharpening area
l n max = 24,000 min-1

Advantages

l optimum cutting quality

Notes

l constant basic dimensions a and D1
l sense of rotation according to DIN-EN 50144

Chamfer\sphericalangle	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
25	67	60	38.5	39.5	20	6	6x2,8	183715 s	183716 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

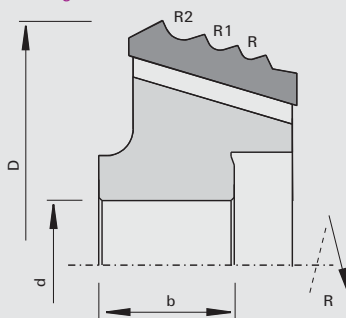
222360

Edge Rounding / Chamfering Cutters DP Multi - Biesse

Product



Drawing

LEUCO
toplineLEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Biesse RF 40
for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
resharpening area 1,0 mm
n max = 24,000 min-1

Advantages

optimum cutting quality

Notes

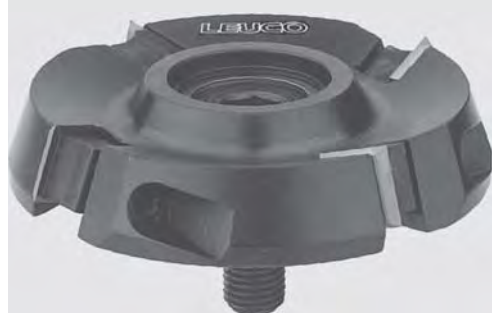
sense of rotation according to DIN-EN 50144

R	R1	R2	Chamfer	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	2.0	3.0	25	75.4	30	20	4	6x2,8	183707 s	183708 s
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]		[mm]		

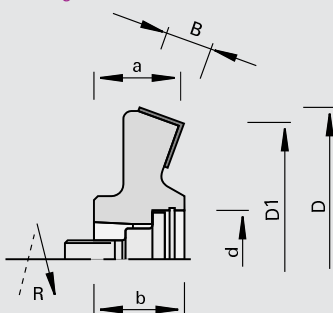
120120

Edge Chamfering Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

edge banding machines Homag, IMA
for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
cutting material: HW HL Board 05
n max = 18,000 min-1

Advantages

excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

Chamfer	Ø D	Ø D1	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	77	70	21.5	12	23	HSK 25R	4	177594	177593
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives

B	H	S	Class-No.	PU	Ident-No.
12	12	1.5	150515	10	003080
[mm]	[mm]	[mm]		[pc.]	

Spare parts

Dimension

	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
Pressure Bars	B=10	925300	2	164526
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Screwdrivers	SW3x100	985730	1	166090
	[mm]			[pc.]

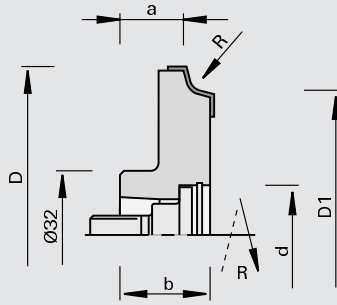
120102

Edge Rounding Cutterheads HW HSK 25R - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Homag
- for rounding of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05

Advantages

- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- same cutterhead body for R 1.5 - 3 mm
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
1,5	79	70	16.5	23	HSK 25R	4	18000	177734 &	177733 &
2,0	79	70	16.5	23	HSK 25R	4	18000	177736 &	177735 &
2,5	79	70	16.5	23	HSK 25R	4	18000	177738 &	177737 &
3,0	79	70	16.5	23	HSK 25R	4	18000	177740 &	177739 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	1,5	12	17	2.0	151546	10	177606	177605
	2,0	12	17	2.0	151546	10	177608	177607
	2,5	12	17	2.0	151546	10	177610 s	177609 s
	3,0	12	17	2.0	151546	10	177612	177611
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	12x11x7	925300	2	177724
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
Set Screws	M6x16 SW3	995161	10	001617
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	1	009672
	[mm]		[pc.]	

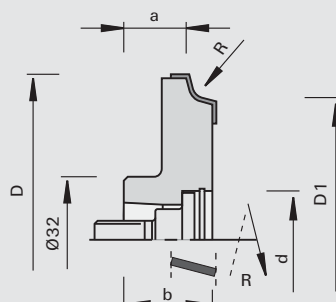
120112

Edge Rounding Cutterheads HW HSK 25R - IMA

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l cutting material: HW HL Board
06

Advantages

l excellent cutting quality thanks
to high radial running accuracy
and precise tool balancing

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
2,0	80	70	16.5	23	HSK 25R	4	18000	180170 &	180169 &
3,0	80	70	16.5	23	HSK 25R	4	18000	180172 &	180171 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

Knives	R	B	H	S	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	2,0	12	18	2.0	151586	10	180174	180173
	3,0	12	18	2.0	151586	10	180176	180175
	[mm]	[mm]	[mm]	[mm]		[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	12x11x7		2	180255
Pressure Bars	12x11x7		2	180256
Screws	M10x1,25x32 SW8		1	177780
Shim Rings	18x25x1,0 DIN 988		10	177781
Locking Rings	25x1,2 DIN 472		10	177782
Set Screws	M6x16 SW3		10	001617
Cranked Wrench Keys	SW3 DIN ISO 2936		1	009672
	[mm]		[pc.]	

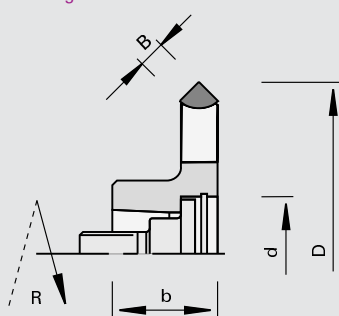
222510

Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag, IMA
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- resharpenable
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- sense of rotation according to DIN-EN 50144

Chamfer \sphericalangle	$\varnothing D$	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
45 [°]	75 [mm]	8,0 [mm]	23 [mm]	HSK 25R [mm]	4	177705 s	177706 s

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

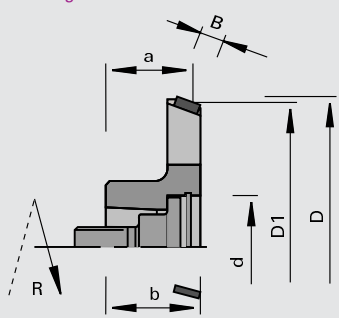
222510

DIAMAX Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FF, IMA,
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle with shear angle
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer \sphericalangle	$\varnothing D1$	$\varnothing D$	a	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
20 [°]	70 [mm]	73 [mm]	21.5 [mm]	6,0 [mm]	23 [mm]	HSK 25R [mm]	4	177649 s	177650 s

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

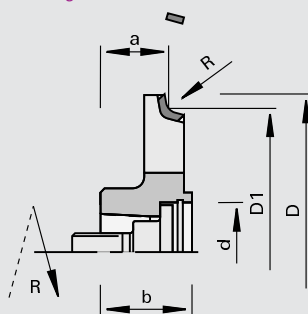
222582

DIAMAX Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag aggregate FF, IMA,
for rounding of solid wood,
veneer and plastic edge bands

Design

polished face
high-finish clearance angle
with shear angle
 $n_{max} = 24,000 \text{ min}^{-1}$

Advantages

optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

constant basic dimensions a
and D1
Z = 4 for feed rate 20 - 30 m/
min
Z = 6 for feed rate 30 - 45 m/
min
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	4	177655 s	177656 s
1,5	76.1	70	16.5	23	HSK 25R	4	177657 s	177658 s
2,0	77.5	70	16.5	23	HSK 25R	4	177659	177660
2,5	78.1	70	16.5	23	HSK 25R	4	177661 s	177662 s
3,0	78.8	70	16.5	23	HSK 25R	4	177663 s	177664 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	6	178545 s	178546 s
1,5	76.1	70	16.5	23	HSK 25R	6	178547 s	178548 s
2,0	77.5	70	16.5	23	HSK 25R	6	178549 s	178550 s
2,5	78.1	70	16.5	23	HSK 25R	6	178551 s	178552 s
3,0	78.8	70	16.5	23	HSK 25R	6	178553 s	178554 s
4,0	81.2	70	16.5	23	HSK 25R	6	178557 s	178558 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

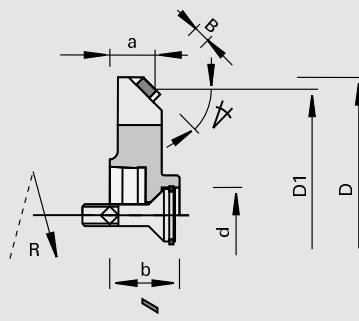
222512

DIAMAX Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag / aggregate FK 01, FK 02, FK 03
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle with shear angle
- n max = 18,000 min⁻¹

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer \sphericalangle	$\varnothing D$	$\varnothing D1$	a	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
5	62.7	62	11.5	6.0	17.5	HSK 32	4	177405 s	177404 s
30	65.9	62	11.5	6.0	17.5	HSK 32	4	177407 s	177406 s
45	71.5	62	11.5	6.0	17.5	HSK 32	4	177409 s	177408 s
20	64.9	62	11.5	6.0	17.5	HSK 32	4	176494 s	176493 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Locking Rings	14x1 DIN 472	995460	10	057258
Shim Rings	8x14x1 DIN 988	995440	10	173406
Countersunk Screws	M6x30 DIN 7991	995121	10	173407
	[mm]			[pc.]

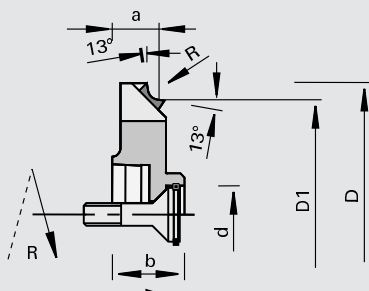
222582

DIAMAX Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag / aggregate FK 01, FK 02, FK 03
- for rounding of solid wood,
veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
with shear angle
- n max = 18,000 min⁻¹
- HSK 32 shortened

Advantages

- optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

- constant basic dimensions a
and D1
- Z = 4 for feed rate 20 - 30 m/
min
- Z = 6 for feed rate 30 - 45 m/
min
- sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,8	68.1	62	11.5	17.5	HSK 32	4	179376 s	179377 s
1,0	68.1	62	11.5	17.5	HSK 32	4	179378 s	179379 s
1,5	68.1	62	11.5	17.5	HSK 32	4	179380 s	179381 s
2,0	71.2	62	11.5	17.5	HSK 32	4	179382	179383
2,5	71.2	62	11.5	17.5	HSK 32	4	179384 s	179385 s
3,0	71.2	62	11.5	17.5	HSK 32	4	179386 s	179387 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	68.1	62	11.5	17.5	HSK 32	6	178466 s	178467 s
1,5	68.1	62	11.5	17.5	HSK 32	6	178468 s	178469 s
2,0	71.2	62	11.5	17.5	HSK 32	6	178470 s	178471 s
3,0	71.2	62	11.5	17.5	HSK 32	6	178474 s	178475 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258
Shim Rings	8x14x1 DIN 988	995440	10	173406
Countersunk Screws	M6x30 DIN 7991	995121	10	173407
	[mm]		[pc.]	

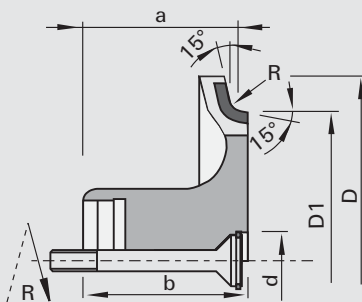
222812

Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing



LEUCO
i-system

LEUCO
i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
- | Homag aggregate FK
- | for rounding of solid wood, veneer and plastic edge bands

Design

- | polished face
- | precise clearance angle
- | with shear angle
- | runout angle 15°

Advantages

- | optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- | optimized chip removal thanks to internal chip evacuation
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | noise reduced

Notes

- | constant basic dimensions a and D1
- | machines must be equipped with i-System
- | sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	4	180301	180300
1,5	74	62	31.5	33	HSK 32	4	180278	180279
2,0	74	62	31.5	33	HSK 32	4	180280	180281
2,5	74	62	31.5	33	HSK 32	4	180303 s	180302 s
3,0	74	62	31.5	33	HSK 32	4	180282	180283
4,0	74	62	31.5	33	HSK 32	4	180307 s	180306 s
5,0	74	62	31.5	33	HSK 32	4	180311 s	180310 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	6	180313 s	180312 s
1,5	74	62	31.5	33	HSK 32	6	180315	180314
2,0	74	62	31.5	33	HSK 32	6	180284	180285
2,5	74	62	31.5	33	HSK 32	6	180317 s	180316 s
3,0	74	62	31.5	33	HSK 32	6	180286 s	180287 s
4,0	74	62	31.5	33	HSK 32	6	180304 s	180305 s
5,0	74	62	31.5	33	HSK 32	6	180308 s	180309 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Locking Rings	14x1 DIN 472	995460	10	057258
Shim Rings	8x14x1 DIN 988	995440	10	173406
Countersunk Screws	M6x30 DIN 7991	995121	10	173407
	[mm]			[pc.]

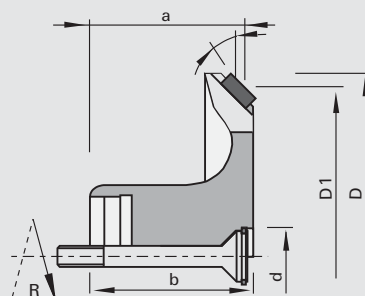
222812

Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing

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Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag / FK-aggregates
- for chamfering of solid wood,
veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing
- optimized chip removal thanks
to internal chip evacuation
- less chips remain inside of the
machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a
and D1
- attention: machines must be
re-equipped accordingly
- sense of rotation according to
DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	65.1	62,3	31.5	34	HSK 32	4	180288	180289
45	70	62,3	31.5	34	HSK 32	4	180319	180318
20	65.1	62,3	31.5	34	HSK 32	6	180290	180291
45	70	62,3	31.5	34	HSK 32	6	180321 s	180320 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Locking Rings	14x1 DIN 472	995460	10	057258
Shim Rings	8x14x1 DIN 988	995440	10	173406
Countersunk Screws	M6x30 DIN 7991	995121	10	173407
	[mm]		[pc.]	

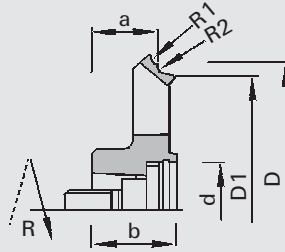
222582

DIAMAX Edge Rounding-Chamfering Cutters DP HSK 25R - Homag

Product



Drawing



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DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Homag aggregate FF
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min⁻¹

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R1	R2	Cham-fer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
3.0	2.0	20	85	69	22.75	28	HSK 25R	4	179076 s	179077 s
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

223512

DIAMAX Edge Rounding-Chamfering Cutters CM DP HSK 25R - flexTrim - Homag

Product



Drawing

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DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

Homag edge banding machines for shaping units FK11, FK20, FK21, FF32, FF12, PF21 with flex Trim aggregate for rounding and / or chamfering of solid wood, veneer and plastic edge bands

Design

2 piece tool
polished face
precise clearance angle
with shear angle
runout angle 15°
n max = 18,000 min-1

Advantages

optimized chip removal thanks to ChipMeister version
short workpiece gap at high feed rates
excellent cutting quality thanks to high radial running accuracy and precise tool balancing
combination of 2 different profiles

Notes

further combinations on request
constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

R1	R2	Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1.5	1.0		78	70	19.5		HSK 25R	4	185077	185076
2.0	1.0		78	70	19.5		HSK 25R	4	185189	185188
2.0	1.2		78	70	19.5		HSK 25R	4	185975 s	185976 s
2.0	1.5		78	70	19.5		HSK 25R	4	183121	183122
3.0	1.0		78	70	19.5		HSK 25R	4	186583	186582
3.0	2.0		78	70	19.5		HSK 25R	4	183115	183116
2.0		20	78	70	19.5		HSK 25R	4	185191 s	185190 s
2.0		45	78	70	19.5		HSK 25R	4	185193 s	185192 s
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
Head Cap Screws	M5x12 DIN EN ISO 4762	995111	10	185320
O-Rings	41x1,78 NBR 11-70	997800	1	69004135
	[mm]			[pc.]

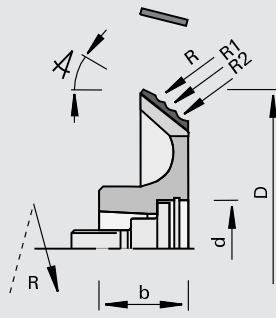
222882

Edge Rounding / Chamfering Cutters DP Multi HSK 25R - Homag MF20 / MF21

Product



Drawing



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i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate MF20 / MF21
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle with shear angle
- runout angle 15°
- resharpenable area 1.0 mm

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-System
- sense of rotation according to DIN-EN 50144

R	R1	R2	Chamfer \angle	$\emptyset D$	b	$\emptyset d$	Z	Ident-No. [L]	Ident-No. [R]
3,0	2,0		20	81.1	28	HSK 25R	4	180757	180758
3,0	2,0		20	81.1	28	HSK 25R	6	180759 s	180760 s
1,5	2,0		20	81.6	28	HSK 25R	4	185075	185074
1,5	2,0	3,0	20	81.1	28	HSK 25R	4	180708 s	180709 s
1,5	2,0	3,0	20	81.1	28	HSK 25R	6	180763 s	180764 s
1,0	1,5	2,0	20	81	27	HSK 25R	4	186677	186676
1,0	1,3	2,0	20	81	27	HSK 25R	4	186679 s	186678 s
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

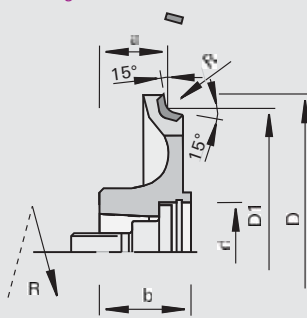
222812

Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing

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toplineLEUCO
i-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
Homag FF, IMA
- | for chamfering of solid wood,
veneer and plastic edge bands

Design

- | polished face
- | precise clearance angle
- | with shear angle
- | runout angle 15°

Advantages

- | optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing
- | optimized chip removal thanks
to internal chip evacuation
- | less chips remain inside of the
machine
- | no malfunctions due to chips
- | reduction of suction power
- | noise reduced

Notes

- | constant basic dimensions a
and D1
- | Z = 4 for feed rate 20 - 30 m/
min
- | Z = 6 for feed rate 30 - 45 m/
min
- | machines must be equipped
with i-System
- | sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	4	184923	184924
1,3	76	70	17.8	23	HSK 25R	4	184927 s	184928 s
1,5	76	70	18	23	HSK 25R	4	184921	184922
2,0	76	70	18.5	23	HSK 25R	4	184919	184920
2,5	78	70	19	23	HSK 25R	4	184925 s	184926 s
3,0	78	70	19.5	23	HSK 25R	4	184917	184918
4,0	84	70	20.5	23	HSK 25R	4	180554 s	180555 s
5,0	84	70	21.5	23	HSK 25R	4	180558 s	180559 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	6	184939 s	184940 s
1,3	76	70	17.8	23	HSK 25R	6	184937 s	184938 s
1,5	76	70	18	23	HSK 25R	6	184935	184936
2,0	76	70	18.5	23	HSK 25R	6	184933	184934
2,5	78	70	19	23	HSK 25R	6	184931 s	184932 s
3,0	78	70	19.5	23	HSK 25R	6	184929	184930
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

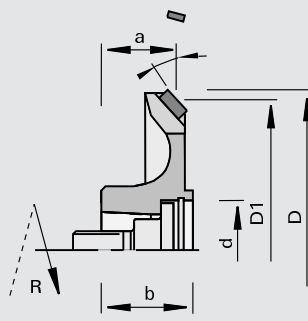
222812

Edge Chamfering Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



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Polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Homag aggregate FF, IMA
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-System
- sense of rotation according to DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	73	70	16.5	22.2	HSK 25R	4	180578	180579
45	73	70	17.5	22.2	HSK 25R	4	180580 s	180581 s
20	73	70	16.5	22.2	HSK 25R	6	180582 s	180583 s
45	73	70	17.5	22.2	HSK 25R	6	180584	180585
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

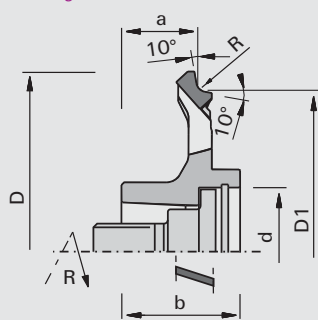
222512

DIAMAX Edge Rounding Cutters DP HSK 25R - Brandt

Product



Drawing

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DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines Brandt
l for rounding of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l polished face and high-finish
clearance angle
l n max = 18,000 min-1
l runout angle 10°

Advantages

l optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

l constant basic dimensions a
and D1
l Z = 4 for feed rate 20 - 30 m/
min
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	70	62	16.5	23	HSK 25R	4	185279	185278
1,2	70	62	16.5	23	HSK 25R	4	185281 s	185280 s
1,3	70	62	16.5	23	HSK 25R	4	185283 s	185282 s
1,5	70	62	16.5	23	HSK 25R	4	185285 s	185284 s
2,0	70	62	16.5	23	HSK 25R	4	185236	185237
3,0	70	62	16.5	23	HSK 25R	4	185287	185286
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

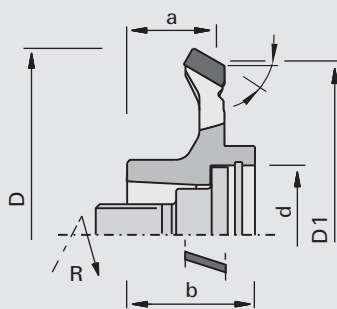
222512

DIAMAX Edge Chamfering Cutters DP HSK 25R - Brandt

Product



Drawing



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DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt for chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
n max = 18,000 min⁻¹

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

constant basic dimensions a and D1
Z = 4 for feed rate 20 - 30 m/min
sense of rotation according to DIN-EN 50144

Chamfer [°]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	Ident-No. [L]	Ident-No. [R]
15	67	62	16.5	23	HSK 25R	4	185289 s	185288 s
30	67	62	16.5	23	HSK 25R	4	185297 s	185298 s
45	70	62	16.5	23	HSK 25R	4	185291 s	185290 s

Spare parts

Dimension

Class-No.

PU

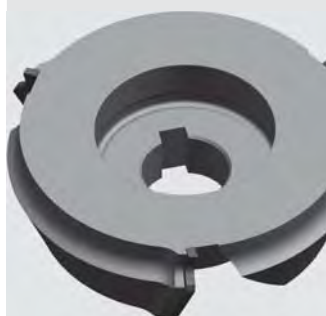
Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

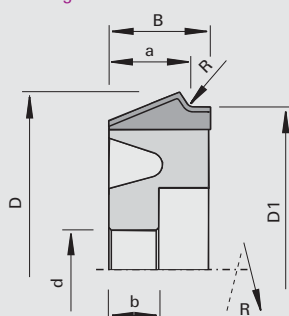
222812

Edge Rounding Trimming Cutters CM DP - Brandt

Product



Drawing



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DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
resharpenable area approx. 2 mm
n max = 24.000 min⁻¹

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

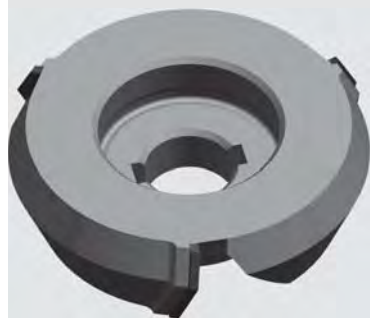
Z = 3 for feed rate 8 - 20 m/min
Z = 4 for feed rate 20 - 30 m/min
sense of rotation according to DIN-EN 50144

R [mm]	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Ø D1 [mm]	a [mm]	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	70,57	20,3	10	16	65,08	17,8	3	5x2,3	183169 s	183168 s
2,0	70,57	20,3	10	16	65,08	17,8	4	5x2,3	185234	185235
3,0	70,57	20,3	10	16	65,02	17,59	4	5x2,3	185305 s	185304 s

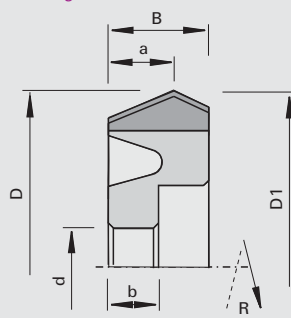
222812

Edge Chamfering Trimming Cutters CM DP - Brandt

Product



Drawing

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DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area approx. 2
mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

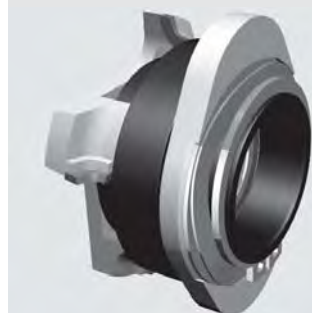
sense of rotation according to
DIN-EN 50144

Chamfer	∅ D	B	b	∅ d	∅ D1	a	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	70.6	20	10	16	69,98	13.07	3	5x2,3	183171 s	183170 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

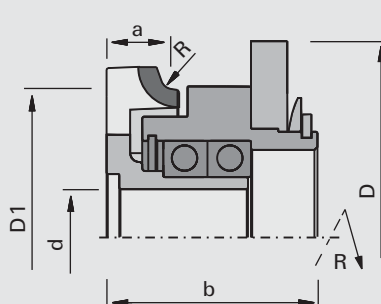
222812

DIAMAX Edge Rounding Cutters DP with copy wheel and torque support - Brandt

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt
for rounding of solid wood,
veneer and plastic edge bands

Design

cutters with integrated copy
function and torque support
torque support made of plastic
to protect the workpiece
bearing by means of roller
bearing
n max = 18,000 min-1

Advantages

high precision and good cutting
results thanks to integrated copy
wheel

Notes

constant basic dimensions a
and D1
for this application only one
sense of rotation is required
sense of rotation according to
DIN-EN 50144

R	∅ D	∅ D1	a	b	∅ d	Z	Ident-No. [R]
1,0	65	49,9	11	34,9	16	4	186746
1,3	65	49,9	11	34,9	16	4	186878
1,5	65	49,9	11	34,9	16	4	185357
2,0	65	49,9	11	34,9	16	4	185358
3,0	65	49,9	11	34,9	16	4	185359
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Torque Support

65x48x6
[mm]

997500

1

185361

[pc.]

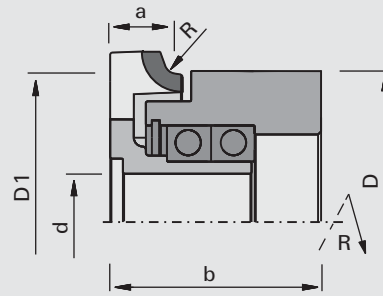
222812

DIAMAX Edge Rounding Cutters DP with copy wheel without torque support - Brandt

Product



Drawing



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topline

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DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt for rounding of solid wood, veneer and plastic edge bands

Design

cutter with integrated follower function
bearing by means of roller bearing
n max = 18,000 min⁻¹

Advantages

high precision and good cutting results thanks to integrated copy wheel

Notes

constant basic dimensions a and D1
for this application only one sense of rotation is required
sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [R]
2,0	58	49,9	11	32,5	16	4	185360
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

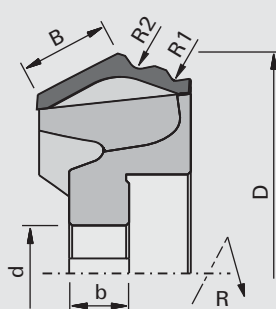
222082

DIAMAX Edge Multiprofile Cutter CM DP - Homag (Brandt)

Product



Drawing

LEUCO
toplineLEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | Homag (Brandt) edge banding machine with dual-profile technology
- | For rounding of soft-wood, hard-wood, veneer and plastic edge bands

Design

- | with shear angle
- | polished face
- | High-finish clearance angle
- | n max=24,000 min-1

Advantages

- | Very long edge life compared to the HW cutterhead version
- | Optimized chip removal thanks to ChipMeister version
- | No contamination of the machine with chips
- | No malfunctions due to chips
- | Reduction of the extraction output
- | Low noise level

Notes

- | Sense of rotation according to DIN-EN 50144

B	R1	R2	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
14	1.0	2.0	74.24	10	16	4	5x2,3	186471	186472
14	1.3	1.3	74.67	10	16	4	5x2,3	186757 s	186758 s
14	1.3	2.0	74.24	10	16	4	5x2,3	186477 s	186478 s
14	1.3	3.0	74.24	10	16	4	5x2,3	186473 s	186474 s
14	1.5	2.0	74.24	10	16	4	5x2,3	186475 s	186476 s
14	2.0	2.0	74.67	10	16	4	5x2,3	186755 s	186756 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		
B	Chamfer	R1	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
14	45	1.0	74.67	10	16	4	5x2,3	186749 s	186750 s
14	45	1.3	74.67	10	16	4	5x2,3	186751 s	186752 s
14	45	1.5	74.67	10	16	4	5x2,3	186753 s	186754 s
14	45	2.0	74.67	10	16	4	5x2,3	186747 s	186748 s
[mm]	[°]	[mm]	[mm]	[mm]	[mm]		[mm]		

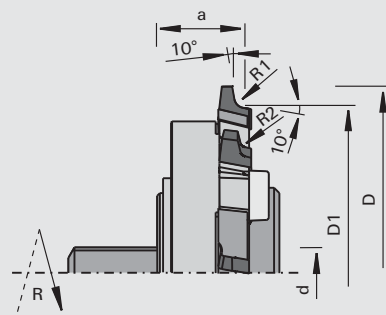
223512

DIAMAX Edge Rounding Cutters CM DP HSK 25R - flexClick - Homag

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- | Homag edge banding machines for shaping units MF50, MF60
- | for rounding and / or chamfering of MDF boards and plastic edge bands

Design

- | 2-profile tool inclusive adjustment mechanics
- | polished face
- | high-finish clearance angle with shear angle
- | runout angle 10°
- | n max=13,000 rpm

Advantages

- | combination of 2 different profiles
- | simple profile change possible without disassembling the tool
- | excellent cutting quality thanks to high radial running accuracy and precise tool balancing
- | optimized chip removal thanks to ChipMeister version

Notes

- | further combinations on request
- | constant basic dimensions a and D1
- | sense of rotation according to DIN-EN 50144

R1	R2	Ø D	Ø D1	a	Ø d	Z	Ident-No. [L]	Ident-No. [R]
2.0	1.0	70	62	16.5	HSK 25R	4	186203	186204
2.0	1.3	70	62	16.5	HSK 25R	4	186201	186202
2.0	1.5	70	62	16.5	HSK 25R	4	186199	186200
3.0	1.3	70	62	16.5	HSK 25R	4	186197	186198
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

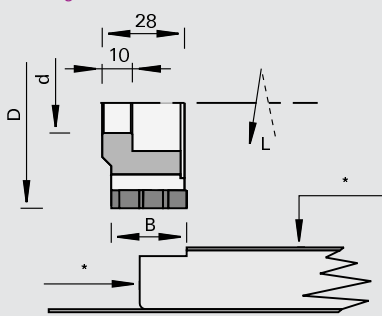
222020

Panel Raising Cutters DP Postforming - Homag

Product



Drawing



Polycrystalline diamond [DP]
MEC

Machine / Application

postforming machines Homag for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design

resharpenable area 3.5 mm
inside edge Z = 9
shear angle and extreme division of cutting pressure
n max = 24,000 min-1

Advantages

no need for extra scoring station

Notes

with inlay profiles
application with feed
* tracing with copy wheel
sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70	25	10	20	9+3+3	6x2,8	179021 s	179022 s
[mm]	[mm]	[mm]	[mm]		[mm]		

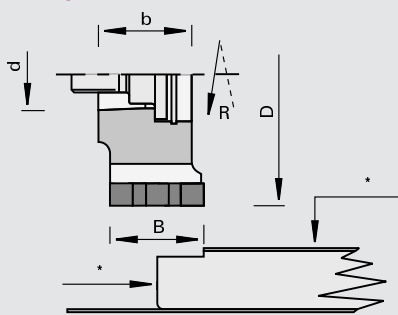
222020

Panel Raising Cutters DP HSK 25R Postforming for inlay profiles - Homag

Product



Drawing



Polycrystalline diamond [DP]
MEC

Machine / Application

postforming machines Homag for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design

resharpenable area 3.5 mm
inside edge Z = 9 resp. Z = 12
shear angle and extreme division of cutting pressure
n max = 24,000 min-1

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing
no need for extra scoring station

Notes

with inlay profiles
application with feed
* tracing with copy wheel
sense of rotation see drawing

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No. [L]	Ident-No. [R]
70	25	28	HSK 25R	9+3+3	25	179020 s	179019 s
70	25	28	HSK 25R	12+6+6	35	180464 s	180463 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

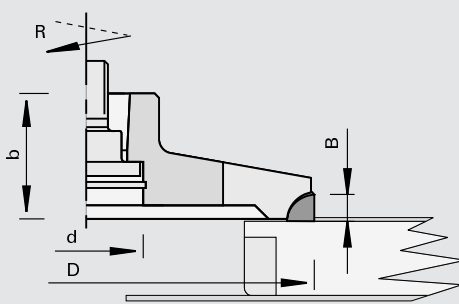
222020

Panel Raising Cutters DP HSK 25R Postforming for U and L profiles - Homag

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag
l for panel raising during the direct postforming process

Design

l with shear angle
l resharpenable area 3.5 mm
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l for panel raising of the U profile and flush-cutting of the L profile
l application against feed
l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [R]
100	5,0	28	HSK 25R	4	177702 s
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

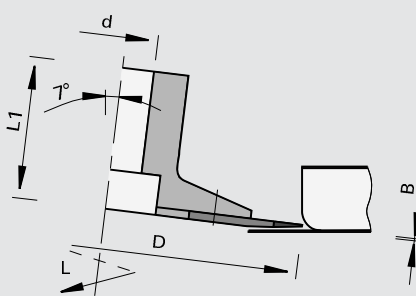
209080

Scribing Cutterheads DP Postforming - Homag, IMA

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag, IMA
l for scribing of the radii during the postforming process

Design

l exchangeable cutting edges
l straight cutter axis
l tooth configuration: symmetrical design for all radii
l n max = 9,000 min-1

Advantages

Notes

l for use without inlay strip
l application against feed
l LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
l B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
l sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	20	45	4	6x3	180073 s	180074 s
125	0,8	20	45	4	6x3	180955 s	180956 s
125	1,2	20	45	4	6x3	180830 s	180831 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	4	180063	180064
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	4	180959 s	180960 s
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	4	180834 s	180835 s
Countersunk Screws	995125	10		178722
Screwdrivers	985730	1		171188
			[pc.]	

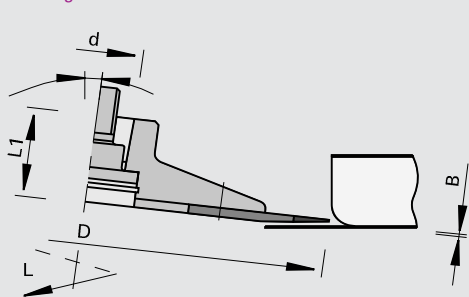
209080

Scribing Cutterheads DP HSK 25R Postforming - Homag

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

postforming machines Homag
for scribing of the radii during the postforming process

Design

cutting edges parallel to cutter axis
tooth configuration: symmetrical design for all radii
n max = 9,000 min-1

Advantages

optimum cutting quality thanks to high concentric and runout accuracy and precise tool balancing

Notes

for use without inlay strip
application against feed
LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	HSK 25R	26	4		180075 s	180076 s
125	0,8	HSK 25R	26	4		180957 s	180958 s
125	1,2	HSK 25R	26	4		180832 s	180833 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	4	180063	180064
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	4	180959 s	180960 s
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	4	180834 s	180835 s
Screws	995190	1		177780
Shim Rings	995440	10		177781
Locking Rings	995460	10		177782
Countersunk Screws	995125	10		178722
Screwdrivers	985730	1		171188
			[pc.]	

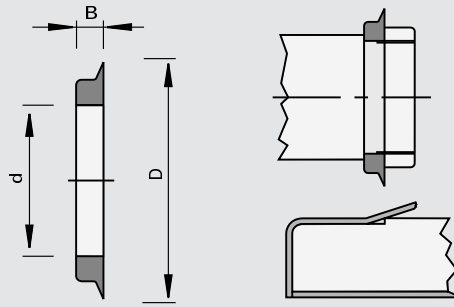
164507

Circular Knives solide carbide for edge trimming Softforming - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

I machines Homag
I for cutting of softforming inlay profiles

Design

I LEUCODUR solid carbide circular knife

Advantages

Notes

$\varnothing D$	B	$\varnothing d$	Ident-No.
40	3,0	25	172757
[mm]	[mm]	[mm]	

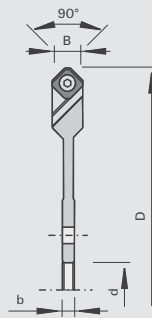
120405

V-groove profile cutterheads HW for aluminum composite materials - HOLZ-HER

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

vertical panel sizing saws
for the production of facade elements, frames, corner elements from aluminum composite material, gutbond etc.

Design

anodized aluminum body
cutting material: HL Solid 40

Advantages

consistent cutting circles thanks to turnover knives
simple handling thanks to quick knife change

Notes

attachment screw for turnover knives executed with two Torx; T15 from front and T10 from back

Ø D	B	b	Ø d	Z	Ident-No.
244 [mm]	16,5 [mm]	6.5 [mm]	30 [mm]	8	182616

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	14 [mm]	14 [mm]	2.0 [mm]	151514	10 [pc.]	182079

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T10 / T15	995125	10	879309
Screwdrivers with handle	T10x80	985730	1	879329
Screwdrivers	T15x80 [mm]	985730	1 [pc.]	171188

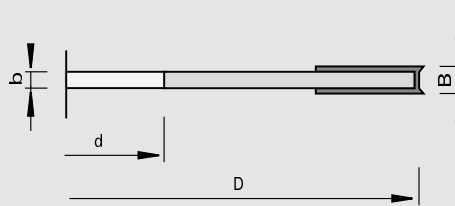
120455

Grooving Cutterheads HW

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

l application against feed with and across the grain

Ø D	B	b	Ø d	Ø dmax	Z	nmin-nmax	Ident-No.
125	4,0	3,0	30	40	4+4	6500-11000	167253
125	5,0	4,0	30	40	4+4	6500-11000	165922 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives

B

H

S

Class-No.

PU

Ident-No.

Spurs

14

14

1.2

150558

10

163701

Turnover Knives

18

18

1.95

150508

10

163699

Turnover Knives

for B = 5

18

18

2.5

150508

10

165906

[mm]

[mm]

[mm]

[pc.]

Spare parts

Dimension

For Ident-No.

Class-No.

PU

Ident-No.

Countersunk Screws

M4x0,5x3,2 T9

167253

995125

10

163925

Countersunk Screws

M4x0,5x4,2 T9

165922

995125

10

165908

Special Nuts

for spurs

M4x0,5x1,6

For all

995290

10

163704

Special Nuts

for profile knives

M4x0,5x2,2

167253

995290

10

163703

Special Nuts

for profile knives

M4x0,5x2,75

165922

995290

10

165907

Screwdrivers

T9

For all

985730

1

164344

[mm]

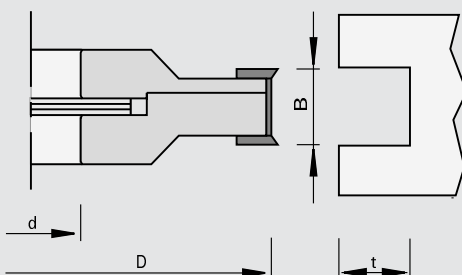
121455

Grooving Cutterheads HW - adjustable 4-15 mm

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | table shapers
- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- | application against feed with and across the grain
- | cutting width 4 - 7.5 mm two-piece
- | cutting width 4 - 15 mm three-piece
- | cutting width adjustable with shims in 0.1 mm increments
- | single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
130	4,0-7,5	30	25	4+4		6000-10000	166509
180	4,0-7,5	30	35	8+4		4500-7400	168081
180	4,0-7,5	35	35	8+4	10x4	4500-7400	168083 s
180	4,0-7,5	40	35	8+4	12x5	4500-7400	168085 s
180	4,0-7,5	50	30	8+4		4500-7400	168087 s
180	4,0-15	30	35	8+2+4		4500-7400	168080 s
180	4,0-15	35	35	8+2+4	10x4	4500-7400	168082 s
180	4,0-15	40	35	8+2+4	12x5	4500-7400	168084 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	7,5	12	1.5	168080, 168082, 168084	150515	10	052543
Spurs	14	14	1.2	For all	150558	10	163701
Turnover Knives	18	18	1.95	For all	150508	10	163699
	[mm]	[mm]	[mm]			[pc.]	

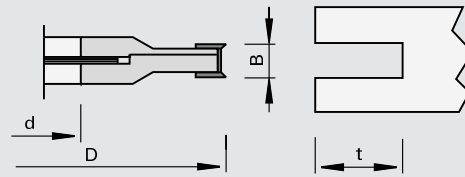
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.	
Pressure Bars	B=7,2	168080, 168082, 168084	925300	2	168074	
Set Screws	M5x12 DIN EN ISO 4028	168080, 168082, 168084	995161	10	050565	
Countersunk Screws	M4x0,5x3,2 T9	For all	995125	10	163925	
Spacer Sets	50x3,5x30	166509	955521	1	166367	
Spacer Sets	65x3,5x30	168080, 168081	955521	1	168075	
Spacer Sets	70x3,5x35	168082, 168083	955521	1	168076	
Spacer Sets	70x3,5x40	168084, 168085	955521	1	168077	
Spacer Sets	90x3,5x50	168087	955521	1	168078	
Special Nuts	for spurs	M4x0,5x1,6	For all	995290	10	163704
Special Nuts	for profile knives	M4x0,5x2,2	For all	995290	10	163703
Screwdrivers	SW2,5x100	168080, 168082, 168084	985730	1	168010	
Screwdrivers	T9	For all	985730	1	164344	
	[mm]					

121455

Grooving Cutterheads HW - adjustable 8-24 mm

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

Design

Advantages

Notes

| table shapers
 | molders
 | double end tenoners
 | for chip-free grooving in solid woods and in wood-based panels

| application against feed with and across the grain
 | cutting width 8 - 15 mm and 12,6 - 24 mm two-piece
 | cutting width adjustable with shims in 0.1 mm increments
 | single cutterheads and spacers secured against rotation with pins


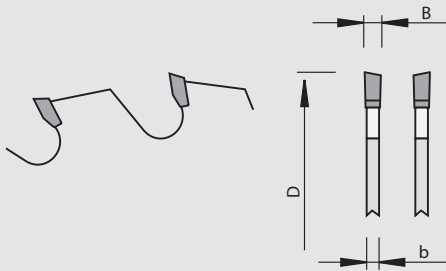
Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
180	8,0-15	30	35	4+4		4500-7400	178725
180	8,0-15	35	35	4+4	10x4	4500-7400	178726 &
180	8,0-15	40	35	4+4	12x5	4500-7400	178727 s
180	12,6-24	30	40	4+4		4500-7400	178729
180	12,6-24	35	40	4+4	10x4	4500-7400	178730 &
180	12,6-24	40	40	4+4	12x5	4500-7400	178731 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	For all	150558	10	003079
Turnover Knives	7,5	12	1.5	178725, 178726, 178727	150515	10	052543
Turnover Knives	12	12	1.5	178729, 178730, 178731	150515	10	003080
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	178729, 178730, 178731	925300	2	164526
Pressure Bars	B=7,2	178725, 178726, 178727	925300	2	168074
Countersunk Screws	M5x6 T20	For all	995125	10	176199
Set Screws	M5x12 DIN EN ISO 4028	178725, 178726, 178727	995161	10	050565
Set Screws	M6x12 DIN EN ISO 4028	178729, 178730, 178731	995161	10	180214
Spacer Sets	65x11,5x30	178729	955521	1	167278
Spacer Sets	70x11,5x35	178730	955521	1	167279
Spacer Sets	70x11,5x40	178731	955521	1	167280
Spacer Sets	65x7x30	178725	955521	1	167282
Spacer Sets	70x7x35	178726	955521	1	167283
Spacer Sets	70x7x40	178727	955521	1	167284
Screwdrivers	SW3x100	178729, 178730, 178731	985730	1	166090
Screwdrivers	SW2,5x100	178725, 178726, 178727	985730	1	168010
Screwdrivers	T20x100	For all	985730	1	166092
Adjusting Gauges	0,3	For all	985200	1	055883
	[mm]			[pc.]	


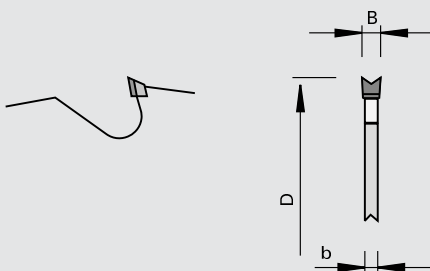
109085

Grooving Cutters HW - for Lamello®

Product		Drawing					
							
				LEUCO DUR			
				Tungsten Carbide [HW]			
				MAN			
Machine / Application		Design		Advantages		Notes	
<ul style="list-style-type: none"> machines Lamello®, ELU for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels 						<ul style="list-style-type: none"> application against feed with and across the grain 	
Ø D	B	b	Ø d	Z	NL	nmin-nmax	Ident-No.
100	4,0	3,45	22	6 WS	4/4,5/36	7600-13000	Lamello®
102	3,85	3,0	22	12 WS		7500-13 100	ELU DS 140
[mm]	[mm]	[mm]	[mm]			[min-1]	

209285

Grooving Cutters DP - for Lamello®

Product		Drawing					
							
				LEUCO DIAMAX			
				Polycrystalline diamond [DP]			
				MAN			
Machine / Application		Design		Advantages		Notes	
<ul style="list-style-type: none"> machines Lamello® for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels 		<ul style="list-style-type: none"> reduced resharpenable area tooth configuration: concave 				<ul style="list-style-type: none"> application against feed with and across the grain 	
Ø D	B	b	Ø d	Z		nmin-nmax	Ident-No.
100	3,95	4,0	22	4		7000-13300	178496
[mm]	[mm]	[mm]	[mm]			[min-1]	

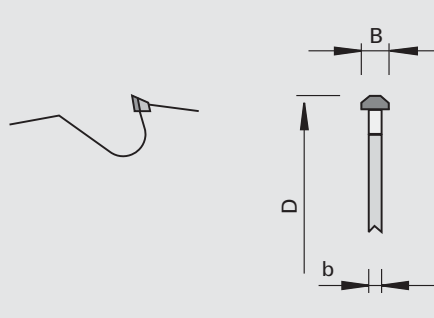
209288

Grooving Cutters DP for Lamello Clamex P® - MEC

Product



Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

l CNC machining centers
l for chip-free grooving for Lamello Clamex P® joints in solid woods and wood-based panels

Design

l not resharpenable
l tooth configuration: specific

Advantages

Notes

l application against feed with and across the grain
l can be used on CNC machines as a grooving cutter
l Mosquito Through-Hole Bits VHW for Lamello Clamex P® see chapter Drill Bits

Ø D	B	b	Ø d	Z	NL	nmax	Ident-No.
100.4	7,0	4,0	30	3	4/6,6/48	15200	189711
100.4	7,0	4,0	35	3	4/5,5/50	15200	Biesse 186094
100.4	7,0	4,0	40	3	4/5,5/52	15200	Homag FLEX 5 / FLEX 5+ 186093
[mm]	[mm]	[mm]	[mm]			[min-1]	

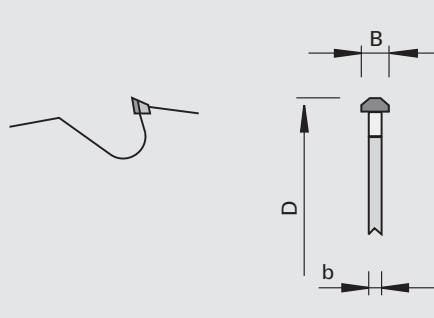
209288

Grooving Cutters DP for Lamello Clamex P® - MAN

Product



Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

MAN

Machine / Application

l Lamello Zeta P2
l for chip-free grooving for Lamello Clamex P® joints in solid woods and wood-based panels

Design

l not resharpenable
l tooth configuration: specific

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
100.4	7,0	4,0	22	3	4/4,3/36	Lamello Zeta P2 186501
[mm]	[mm]	[mm]	[mm]			

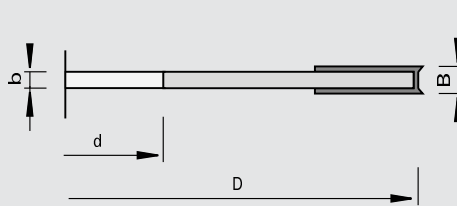
120455

Grooving Cutterheads HW - for Lamello®

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l machines Lamello®
l for chip-free grooving of
Lamello® wood joints in solid
woods and in wood-based
panels

Design

Advantages

Notes

l application against feed with
and across the grain

Ø D	B	b	Ø d	Z	NL	nmin-nmax	Ident-No.		
100	4,0	4,0	22	4+4	4/4,5/36	7700-13300	164838		
[mm]	[mm]	[mm]	[mm]			[min-1]			
Turnover Knives				B	H	S	Class-No.	PU	Ident-No.
Spurs				14	14	1.2	150558	10	163701
Turnover Knives				18	18	1.95	150508	10	163699
				[mm]	[mm]	[mm]		[pc.]	
Spare parts						Dimension	Class-No.	PU	Ident-No.
Countersunk Screws						M4x0,5x3,2 T9	995125	10	163925
Special Nuts			for profile knives			M4x0,5x2,2	995290	10	163703
Special Nuts			for spurs			M4x0,5x1,6	995290	10	163704
Screwdrivers						T9	985730	1	164344
						[mm]		[pc.]	

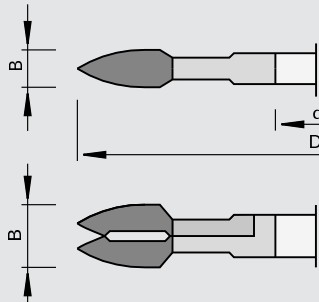
122415

Cutters HW for removing resin pockets

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l Mini-Spot machines
l for cutting out defects in solid
woods

Design

l with alternating shear angle

Advantages

Notes

l for patch sizes 1-4

Ø D	B	Ø d	Z	NL	nmax	Ident-No.
100	8,0	22	4	4/4,3/36	12000	180469
100	15	22	4		12000	70176420
[mm]	[mm]	[mm]			[min-1]	

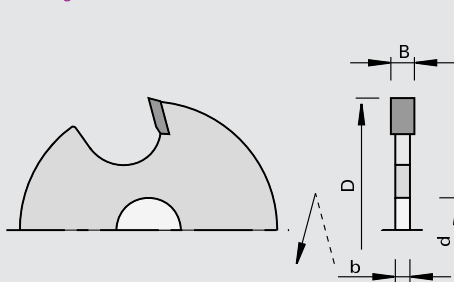
109015

Grooving Cutters HW - portable routers

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l portable routers
l for grooving in solid woods and wood-based panels

Design

l two brazed flat-tooth cutting edges

Advantages

Notes

l clamping elements: cutter arbor

Ø D	B	b	Ø d	Z	nmax	Ident-No.
40	1,8	1.0	8,0	2	24000	001367
40	2,0	1.2	8,0	2	24000	001370
40	2,5	1.5	8,0	2	24000	001374
40	3,0	2.0	8,0	2	24000	001377
40	3,5	2.5	8,0	2	24000	001380
40	4,0	3.0	8,0	2	24000	001383
[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Mounting arbors

8x8

997200

1

160363

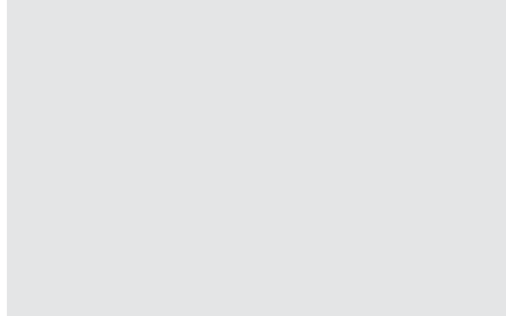
[mm]

[pc.]

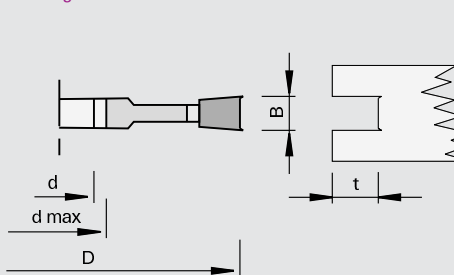
122455

Grooving Cutters HW with spur

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l stationary milling centers
l table shapers against feed
l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

l application with and across the grain
l cutting width = hub width

Ø D	B	Ø d	Ø dmax	Tmax	Z	nmin-nmax	Ident-No.
140	4,0	30	50	33	4+4	5400-9000	198032 s
140	10	30	50	33	4+4	5400-9000	198036 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

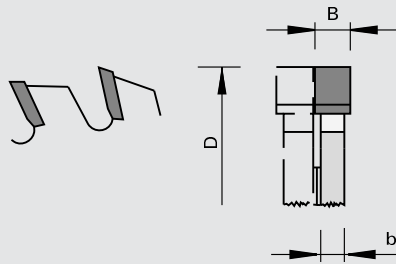
109015

Grooving Cutters HW - MAN

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

l application against feed with the grain (solid wood)
l application with feed only with MEC (wood-based panels)
l for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
l groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	1,5	0.8	30	12	6100-10500	188359
125	1,8	1.0	30	12	6100-10500	188360
125	2,0	1.2	30	12	6100-10500	188361
125	2,2	1.2	30	12	6100-10500	188362
125	2,5	1.4	30	12	6100-10500	188363
125	3,0	2.0	30	12	6100-10500	188364
125	3,5	2.5	30	12	6100-10500	188365
125	4,0	2.5	30	12	6100-10500	188366
125	4,5	3.0	30	12	6100-10500	188367
125	5,0	4.0	30	12	6100-10500	188368
125	6,0	4.0	30	12	6100-10500	188369
125	7,0	5.0	30	12	6100-10500	188370
125	8,0	5.0	30	12	6100-10500	188371
125	10	6.0	30	12	6100-10500	188372
150	1,5	0.8	30	12	5200-8800	188373
150	2,0	1.2	30	12	5200-8800	188375
150	2,2	1.2	30	12	5200-8800	188376
150	2,5	1.5	30	12	5200-8800	188377
150	3,0	2.0	30	12	5200-8800	188378
150	3,5	2.5	30	12	5200-8800	188379
150	4,0	3.0	30	12	5200-8800	188380
150	4,5	3.5	30	12	5200-8800	188381
150	5,0	4.0	30	12	5200-8800	188382
150	6,0	4.0	30	12	5200-8800	188383
150	7,0	5.0	30	12	5200-8800	188384
150	8,0	5.0	30	12	5200-8800	188385
150	9,0	6.0	30	12	5200-8800	188386
150	10	6.0	30	12	5200-8800	188387
[mm]	[mm]	[mm]	[mm]		[min-1]	

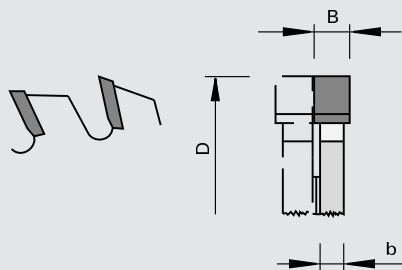
109010

Grooving Cutters HW

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l molders
l double end tenoners
l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

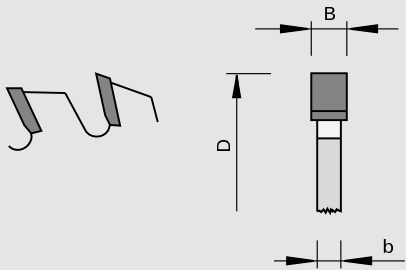
l for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
l groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
150	4,0	3,0	30	12		12700		160802
150	5,0	4,0	30	12		12700		001434
150	6,0	4,0	30	12		12700		161617
150	7,0	5,0	30	12		12700		161619
150	8,0	5,0	30	12		12700		161620
150	10	6,0	30	12		12700		161622
150	5,0	4,0	35	12	10x4	12700		001435 &
150	10	6,0	35	12	10x4	12700		161623 &
150	1,5	0,8	35	18	10x4	10200		001447
150	1,8	1,0	35	18	10x4	10200		001448
150	2,0	1,2	35	18	10x4	10200		001449
150	2,2	1,2	35	18	10x4	10200		001450 s
150	2,5	1,5	35	18	10x4	10200		001451
150	3,0	2,0	35	18	10x4	12700		001452
150	4,0	3,0	35	18	10x4	12700		001453
150	5,0	4,0	35	18	10x4	12700		001454
150	6,0	4,0	35	18	10x4	12700		161627
150	8,0	5,0	35	18	10x4	12700		161628
150	4,0	3,0	30	24		12700		169689
150	5,0	4,0	30	24		12700		169688
150	6,0	4,0	30	24		12700		169687
150	4,0	3,0	30	48 WS		12700		160804
180	4,0	3,0	30	12		10600		001442
180	5,0	4,0	30	12		10600		001443
180	6,0	4,0	30	12		10600		161624
180	8,0	5,0	30	12		10600		161625
180	10	6,0	30	12		10600		161626
180	4,0	3,0	30	18		10600		169685
180	5,0	4,0	30	18		10600		169684
180	8,0	5,0	30	18		10600		169683
180	10	6,0	30	18		10600		169682
180	4,0	2,8	65	24		10600	2 x 6/6,5/90	192991
180	3,5	2,5	65	24		10600	2 x 6/6,5/90	192990
180	3,0	2,2	65	24		10600	2 x 6/6,5/90	192989
196	6,0	5,0	30	12 WS		9500		163836
200	4,0	2,8	30	24		9500		1527332 o
200	4,5	2,8	30	24		9500		1527333 o
200	5,0	2,8	30	24		9500		1527334 o
200	5,5	2,8	30	24		9500		1527335 o
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

Ø D	B	b	Ø d	Z	DKN	nmax	NL	Ident-No.
200	6,0	2.8	30	24		9500		1527336 o
200	6,5	2.8	30	24		9500		1527337 o
200	7,0	5.0	30	24		9500		1527339 o
200	7,5	5.0	30	24		9500		1527340 o
200	8,0	5.0	30	24		9500		1527341 o
200	8,5	5.0	30	24		9500		1527342 o
200	9,0	5.0	30	24		9500		1527343 o
200	9,5	5.0	30	24		9500		1527344 o
200	10	5.0	30	24		9500		1527345 o
220	4,0	3.0	30	30		8700		1521934 o
220	4,5	3.0	30	30		8700		1521935 o
220	5,0	3.0	30	30		8700		1521936 o
220	5,5	3.0	30	30		8700		1521937 o
220	6,0	3.0	30	30		8700		1521938 o
220	6,5	3.0	30	30		8700		1521939 o
220	7,0	5.0	30	30		8700		1521941 o
220	7,5	5.0	30	30		8700		1521942 o
220	8,0	5.0	30	30		8700		1521943 o
220	8,5	5.0	30	30		8700		1521944 o
220	9,0	5.0	30	30		8700		1521945 o
220	9,5	5.0	30	30		8700		1521946 o
220	10	5.0	30	30		8700		1521947 o
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

109010

Grooving Cutters HW - CNC machining center

Product	Drawing	
		<p>LEUCO DUR</p> <p>Tungsten Carbide [HW]</p> <p>MEC</p>

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for chip-free grooving in solid woods and in wood-based panels 	<ul style="list-style-type: none"> positive hook angle without shear angle pin holes with countersink tooth configuration: flat "F" cutting material: HW HL Board 06 		

Ø D	B	b	Ø d	Z	NL	Ident-No.
100	3,2	2.2	30	20		Weeke 189571
100	4,0	3.0	30	20		Weeke 189647
100	5,0	3.0	30	20		Weeke 189260
120	4,0	3.0	35	30	4/6/50	Biesse, Felder Profit H22 189262
125	3,2	2.2	30	36	2x4/6,1/48	Weeke 189306
125	4,0	3.0	30	36	2x4/6,1/48	Weeke 189995
250	4,0	3.0	30	60	2/10/60	192470
[mm]	[mm]	[mm]	[mm]			

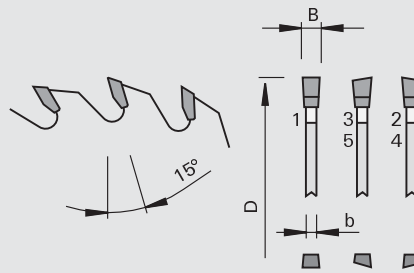
109080/122410

Grooving Cutters HW "G5"

Product



Drawing



LEUCO
G5 system

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | Weeke BHX series
- | CNC machining centers and aggregates
- | for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

- | tooth configuration: G5
- | cutting material: HW HL Board 03, HL Board 05

Advantages


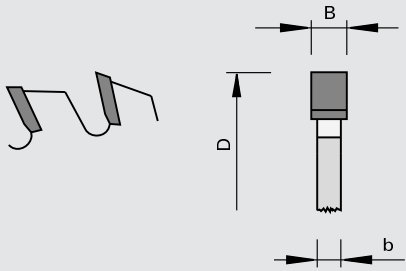
- | excellent cutting quality
- | especially low noise level
- | long edge lives also thanks to highly wear-resistant cutting material

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
100	4,0	2.8	30	35		Weeke BHX Series 050/055 189994
100	5,0	4.0	30	35		Weeke BHX Series 050/055 191947
100	8,5	3.5	20	30		HOLZ-HER 193135
100	8,5	3.5	30	30	2x4/5,5/48	Weeke BHX 050 series, Homag Drillteq V200/500 193134
120	4,0	2.8	20	35		191948
120	5,0	4.0	20	35		191949
120	4,0	2.8	20	35	2x3/4,5/35	SCM / Morbidelli 191950 &
120	5,0	4.0	20	35	2x3/4,5/35	SCM / Morbidelli 191951 &
120	4,0	2.8	35	35	2x4/6,3/50	Biesse 191952 &
120	5,0	4.0	35	35	2x4/6,3/50	Biesse 191953 &
125	4,0	2.8	30	35	2x4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates 189993
125	5,0	4.0	30	35	2x4/5,5/48	Weeke BHX 500 series and other machining centers and aggregates 191946
[mm]	[mm]	[mm]	[mm]			


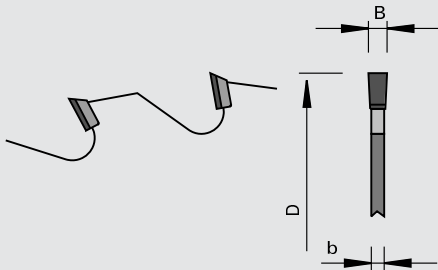
209010

Grooving Cutters DP - machining centers

Product		Drawing		Notes		
				Polycrystalline diamond [DP]		
Machine / Application		Design		Advantages		
<ul style="list-style-type: none"> CNC machining centers for chip-free grooving in solid woods and in wood-based panels 		<ul style="list-style-type: none"> positive hook angle without shear angle pin holes with countersink tooth configuration: flat "F" 		<ul style="list-style-type: none"> MEC 		
Ø D	B	b	Ø d	Z	NL	Ident-No.
125	3,2	2.2	30	36	4/6,1/48 + 4/6,1/48 Weeke	189649 s
125	4,0	3.0	30	36	4/6,1/48 + 4/6,1/48 Weeke	189648 s
[mm]	[mm]	[mm]	[mm]			

209010

Grooving Cutters DP

Product		Drawing		Notes			
				Polycrystalline diamond [DP]			
Machine / Application		Design		Advantages			
<ul style="list-style-type: none"> double end tenoners edge banding machines for chip-free grooving in solid woods and in wood-based panels 		<ul style="list-style-type: none"> resharpenable area 3.5 mm tooth configuration: flat 		<ul style="list-style-type: none"> application with feed number of teeth depends on the feed rate, the material to be cut and the desired cutting quality 			
Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
180	4,0	3.0	35	12	10x4	10000	178194 s
180	4,0	3.0	35	18	10x4	10000	178195 s
180	4,0	3.0	35	24	10x4	10000	178196 s
180	5,0	4.0	35	18	10x4	10000	178197 s
180	5,0	4.0	35	24	10x4	10000	178198 s
180	6,0	5.0	35	12	10x4	10000	178199 s
180	6,0	5.0	35	18	10x4	10000	178200 s
180	6,0	5.0	35	24	10x4	10000	178201 s
180	8,0	7.0	35	12	10x4	10000	178202 s
180	8,0	7.0	35	18	10x4	10000	178203 s
180	8,0	7.0	35	24	10x4	10000	178204 s
180	5,0	4.0	35	12	10x4	10000	178205 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

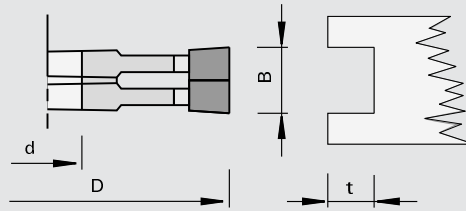
123455

Grooving Cutter Set HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | table shapers
- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- | application with and across the grain (solid wood)
- | cutting width adjustable with shims in 0.1 mm increments

Ø D	B	Ø d	Tmax	Z	KN	nmin-nmax	Ident-No.
120	1,8 - 3,4	30	18	4+4		6400-10000	006188 s
120	2,2-4,0	30	18	4+4		6400-10000	006189 s
150	4,0-7,5	30	37	4+4		5200-9000	006190 s
150	7,5-14,5	30	37	4+4		5200-9000	006191 s
140	2,2-4,0	30	20	4+4		5400-9000	171136
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

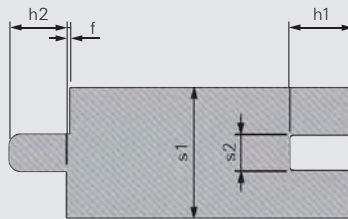
327300

Tongue and Groove Tools HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | molders
- | double end tenoners
- | for tongue and groove board with or without space allowance in material (=open joint) or chamfer in soft and hard woods

Design

- | body made from steel
- | adjustable by means of spacers
- | highest precision thanks to plane parallelism of all parts
- | secured against rotation by means of 3 driving pins on minor diameter 75 mm

Advantages

Notes

- | indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
- | without indications we will deliver according to diagram I
- | delivery with HW-tipping possible with surcharge

Profile	Ø D	B	Ø d	nmax	s1	s2	f	Z	Ident-No.
501/502	180	35	40	8000	12-36	4,5-7,5	0,5	6	58532354 s
505/506	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532358 s
512/513	180	35	40	8000	12-27	4,5-7,5		6+3	58532361 s
503/502	180	35	40	8000	12-36	4,5-7,5		6	58532382 s
529/530	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532384 s
507/508	180	35	40	8000	15-27	4,5-7,5		6	58532387 s
525/526	180	35	40	8000	12-27	4,5-7,5		6+3	58532390 s
541/540	180	35	40	8000	14-19	4,5-7,5		6+3	58532391 s
	[mm]	[mm]	[mm]	[min-1]	[mm]	[mm]	[mm]		

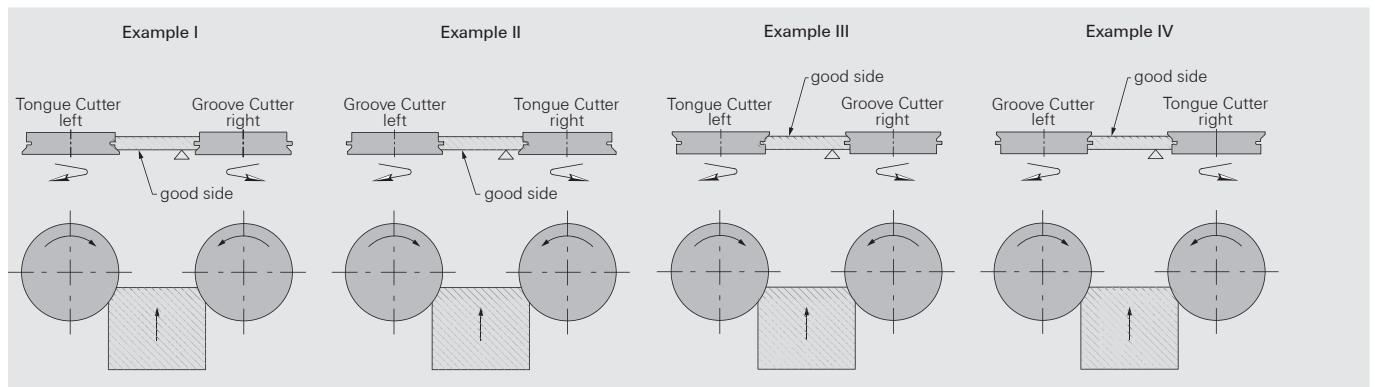
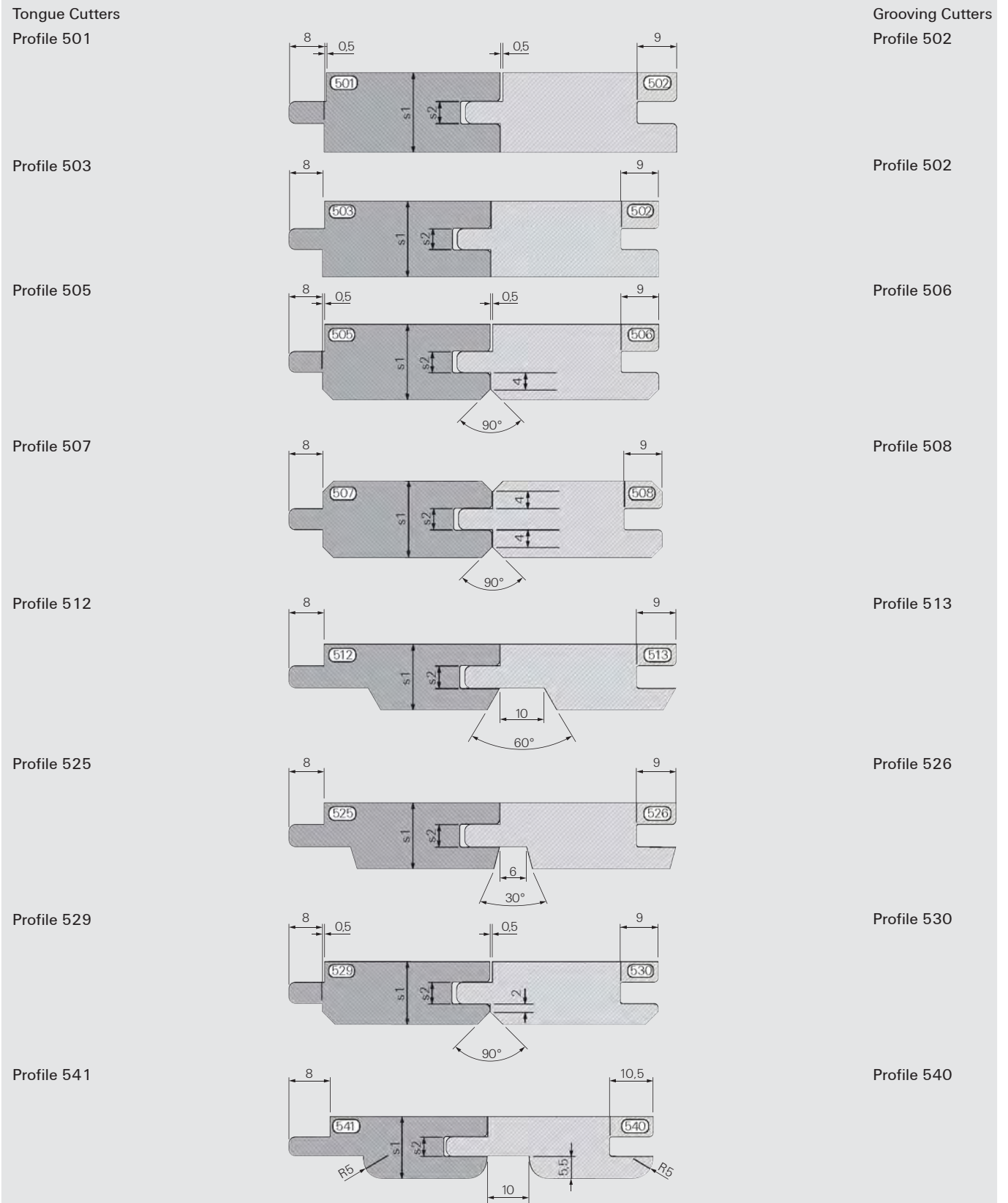


Diagram I



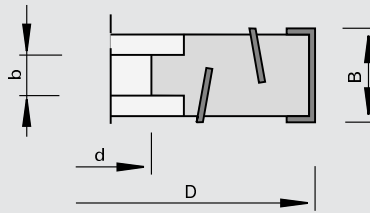
120215

Joining Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free joining of plastic-laminated panels

Design

l opposing shear angle
l cutting material: HW HL Board 05

Advantages

Notes

l application against feed with and across the grain

Ø D	B	b	Ø d	Z	DKN	nmin-nmax	Ident-No.
100	34	35	30	3+3	8x3	7700-13300	171972 s
125	56	54	30	3+3	8x3	6100-10500	177004
150	56	54	30	3+3	8x3	5200-8800	177006 s
180	56	25	35	3+3	10x4	4200-7200	177002 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	20	12	1.5	150515	10	003082
	30	12	1.5	150515	10	003083
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=17	171972	925300	2	167971
Pressure Jaws	28x11x6	177002, 177004, 177006	925300	2	180344
Clamping Pieces	12x8,5/M6L	177002, 177004, 177006	925100	2	180356
Set Screws	M8x12 DIN EN ISO 4028	171972	995161	10	180001
Clamping Set Screws	M6/M6Lx18	177002, 177004, 177006	995161	10	180338
Screwdrivers	SW4x100	171972	985730	1	166091
Screwdrivers	T15x80	177002, 177004, 177006	985730	1	171188
	[mm]				[pc.]

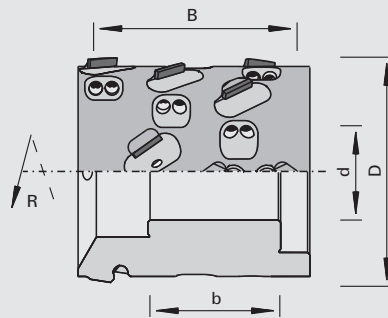
222220

DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
HOLZ-HER aggregate 1801 / 1802 / 1804
- for extremely noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with patented AirStream-System
- symmetrical and asymmetrical design
- 35° shear angle
- resharpening area 1.5 mm

Advantages

- optimal glueing of edges
- extremely noise and flow-optimized thanks to AirStream-System
- considerably increased chip caption degree thanks to AirStream-System
- increase of edge life thanks to reduction of multiple hogging
- less chips remain inside of the machine
- high cutting quality thanks to large shear angle

Notes

- compatible with Pro Lock clamping on older aggregates
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
70	48	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802 asymmetrical	185800	185801
70	64	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802 asymmetrical	185802	185803
70	48	41	30	3+3	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802 asymmetrical	185806 s	185807 s
70	64	41	30	3+3	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802 asymmetrical	185808 s	185809 s
100	63	40	30	3+3	8x3,3	18500	HOLZ-HER aggregate 1804 symmetrical	186495	186496
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

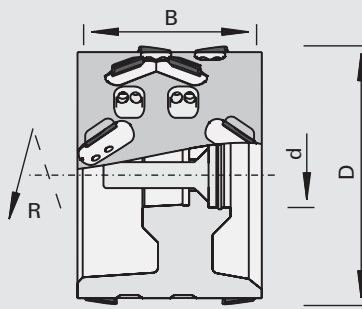
222220

DIAMAX Jointing Cutters DP HSK 32R - HOLZ-HER - AirStream-System

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | through feed machines HOLZ-HER aggregate FG701
- | for extremely noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | With patented AirStream-System
- | Symmetrical design
- | 35° shear angle
- | Integrated balance screws
- | HSK 32R
- | Resharpener area 1.5 mm

Advantages

- | Optimal glueing of edges
- | Very low noise levels and optimized flow thanks to AirStream-System
- | Significantly increased chip caption degree thanks to AirStream-System
- | Increased edge life thanks to reduction of multiple hogging and best concentricity
- | Reduced contamination of the machine with chips
- | Excellent cutting quality thanks to large shear angle and best concentricity

Notes

- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	n _{max}			Ident-No. [L]	Ident-No. [R]
100	63	34	HSK 32R	3+3	18500	HOLZ-HER FG701	symmetrical	186759	186760
[mm]	[mm]	[mm]	[mm]		[min-1]				

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M10x40 ISO 10642-10.9	995121	1	186761
Reducing Rings	25x3x9	955530	1	186762
Locking Rings	25x1,2 DIN 472	995460	10	177782
	[mm]		[pc.]	

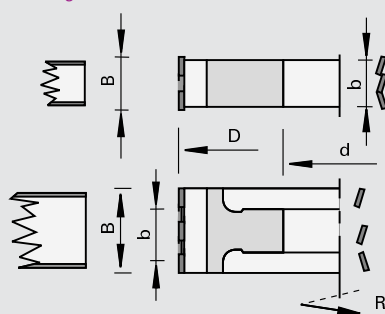
222220

DIAMAX airFace Jointing Cutters DP

Product



Drawing



LEUCO
DIAMAX
airFace

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of noise

Design

- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- compared to the LowNoise version, additional noise reduction by -1 dB(A) through airFace design and reduced gullet volume
- good durability and high cutting quality thanks to large shear angle
- machining of 8-mm panels is possible without adjustment

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
60	64,5	62	25	2+2	8x3,3	31000	Felder/Format 4	asymmetrical	186382	186381
70	43,2	61	25	2+2	8x3,3	24000	EBM, Hebrock	asymmetrical	186380 s	186379 s
70	50,3	31	30	2+2	8x3,3	24000	HOLZ-HER 1801 (old)	asymmetrical	186390 s	186389 s
80	36	53	30	3+3	8x3,3	23300	Biesse	quasi symmetrical	186364 s	186364 s
80	64	53	30	3+3	8x3,3	23300	Biesse	symmetrical	186365	186365
80	43,2	53	30	3+3	8x3,3	23300	Biesse	symmetrical	186366	186366
80	64,5	62	25	2+2	8x3,3	23300	Felder/Format 4	asymmetrical	186384 s	186383 s
85	43,2	50	30	3+3	8x3,3	22000	Ott	asymmetrical	186408	186409
85	64,5	70	30	3+3	8x3,3	22000	Ott	asymmetrical	186410 s	186411 s
100	64	75	30	3+3	8x3,3	19000	Biesse	symmetrical	186367 s	186367 s
100	43,2	75	30	3+3	8x3,3	19000	Biesse	symmetrical	186368 s	186368 s
100	64,5	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	186371	186372
100	43,2	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	186373	186374
100	43,2	42	25	2+2	8x3,3	19000	Brandt Ambition 1110 F (KDF 110), 1120 FC (KDF 120 C)	asymmetrical	186376 s	186375 s
100	43,2	61	30	2+2	8x3,3	19000	EBM / Hebrock	asymmetrical	186378	186377
100	43,2	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani	asymmetrical	186385	186386
100	64,5	60.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	186412	186413
100	43,2	60.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	186414	186415
100	64,5	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani, EBM	asymmetrical	186387	186388
125	64,5	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186391 s	186392 s
125	43,2	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186395	186396
125	43,2	40	30	3+3	8x3,3	15000	Homag	symmetrical	186399	186399
125	64	40	30	3+3	8x3,3	15000	Homag	symmetrical	186400	186400
125	29	34	30	3+3	8x3,3	15000	Homag	symmetrical	186401	186401
125	36	40	30	3+3	8x3,3	15000	Homag	symmetrical	186402	186402
125	64,5	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186393 s	186394 s
125	43,2	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186397	186398
125	43,2	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186404 s	186405 s
125	64,5	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186406 s	186407 s
150	43,2	40	30	4+4	8x3,3	12000	Homag	symmetrical	186403	186403
150	64	40	30	4+4	8x3,3	12000	Homag	symmetrical	186519	186519
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
150	29	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate asymmetrical AF11/AW22/AW12	186743	186744
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

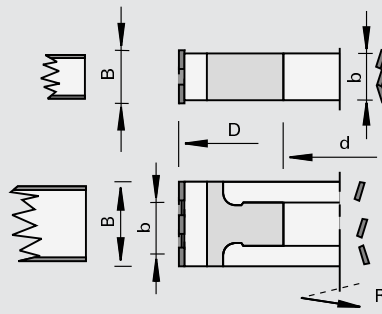
222220

DIAMAX Jointing Cutters DP LowNoise

Product



Drawing



LOW

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- symmetrical and asymmetrical design
- for left and right hand rotation
- opposing shear angle
- spiral cutting edges
- resharpening area 1.5 mm

Advantages

- optimal glueing of edges
- optimized as to noise level and chip flow

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
100	34	37.6	30	3+3	8x3,3	19000	IMA, Brandt	184673	184672
100	53	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961	182173 s	182172 s
100	63	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961 from 2008, Homag	182692 s	182693 s
125	43	40	30	3+3	8x3,3	15000	Homag	184029	184029
125	43	40	30	4+4	8x3,3	15000	Homag aggregate S2	185662 s	185662 s
125	63	40	30	3+3	8x3,3	15000	Homag	184030	184030
150	43	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate asymmetrical AF11/AW22/AW12	185258 s	185257 s
150	63	40	30	4+4	8x3,3	12000	Homag reference jointing (WZ10/WZ14), aggregate asymmetrical AF11/AW22/AW12	184763	184764
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

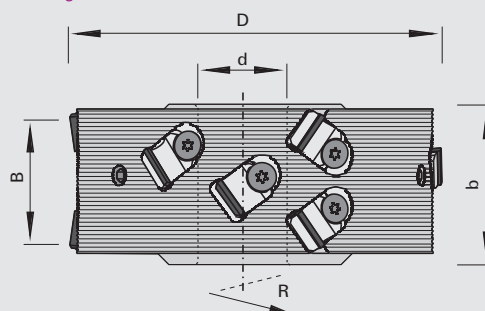
220220

DIAMAX SmartJointer airFace Jointing Cutterheads DP

Product



Drawing



LEUCO
SmartJointer airFace

Polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
for jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of unbalance and noise

Design

aluminum body with airFace surface
with exchangeable stainless steel DP cutting edges
DP cutting edges with integrated stainless steel gullet
shear angle 35°
resharpening area 1.5 mm

Advantages

additional noise reduction by up to -3 dB (A) thanks to the airFace design
reduced power consumption thanks to low-weight design with aluminum body
easy on spindle bearing thanks to less unbalance
exchangeable DP cutting edges incl. wear-resistant exchangeable gullet
excellent cutting quality thanks to large shear angle
corrosion protection of the entire tool by stainless steel segments

Notes

Attention: when changing the cutting edges please observe operating instructions
DP cutting edges packing unit 4 pieces
plug insert packing unit 2 pieces
sense of rotation according to DIN-EN 50144

SmartJointer airFace Ø D=70 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
70	43	61	25	2+2	18700	asymmetrical	EBM	8	186037	186038
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts

	Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=70 / 35° 17,2x8,9x14,2 [mm]	232239	4 [pc.]	186076

SmartJointer airFace Ø D=80 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
80	64	63	25	2+2	16400	asymmetrical	Felder/Format 4	12	186040 s	186039 s
80	43	53	30	2+2	16400	symmetrical	Biesse	8	186031	186031
80	64	52	30	3+3	16400	symmetrical	Biesse	18	186032 s	186032 s
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts

	Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=80 / 35° 17,2x8,9x14,2 [mm]	232239	4 [pc.]	186077

SmartJointer airFace Ø D=85 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]
85	48	50	30	3+3	15500	asymmetrical	Ott	15	186058	186057
85	63	50	30	3+3	15500	asymmetrical	Ott	18	186060 s	186059 s
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]		

Spare parts

	Dimension	Class-No.	PU	Ident-No.
DP cutting edges	Ø D=85 / 35° 17,2x8,9x14,2 [mm]	232239	4 [pc.]	186078

SmartJointer airFace Ø D=100 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]	
100	43	61	30	2+2	13000	asymmetrical	EBM	8	186034 s	186033 s	
100	64	61	30	2+2	13000	asymmetrical	EBM	12	186035 s	186036 s	
100	43	40.6	25	2+2	13000	asymmetrical	Brandt 1110F, 1120 FC	8	186071	186072	
100	43	40.6	30	3+3	13000	asymmetrical	Brandt	12	186065	186066	
100	64	40.6	30	3+3	13000	asymmetrical	Brandt, SCM	18	186073	186074	
100	85	85	30	3+3	13000	asymmetrical	Brandt	24	186067 s	186068 s	
100	106	85	30	3+3	13000	asymmetrical	Brandt	30	186069 s	186070 s	
100	43	60.6	30	3+3	13000	asymmetrical	SCM	12	186063	186064	
100	64	60.6	30	3+3	13000	asymmetrical	SCM	18	186062	186061	
100	64	75	30	3+3	13000	symmetrical	Biesse	18	186030 s	186030 s	
100	64	40	30	3+3	13000	symmetrical	HOLZ-HER 1804	18	186045 s	186046 s	
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]			
Spare parts							Dimension		Class-No.	PU	Ident-No.
DP cutting edges					Ø D=100 / 35°		17,2x8,9x14,2		232239	4	185250
							[mm]			[pc.]	

SmartJointer airFace Ø D=125 / 35°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]	
125	43	40	30	3+3	10500	symmetrical	Homag	12	186047	186047	
125	64	40	30	3+3	10500	symmetrical	Homag	18	186048	186048	
125	32,5	54	30	3+3	10500	asymmetrical	Homag	9	186307	186306	
125	43,2	54	30	3+3	10500	asymmetrical	Homag	12	185971	185970	
125	64,4	54	30	3+3	10500	asymmetrical	Homag	18	185973	185972	
125	43,2	72	30	3+3	10500	asymmetrical	IMA 08.378	12	186051	186052	
125	64,4	72	30	3+3	10500	asymmetrical	IMA 08.378	18	186049	186050	
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]			
Spare parts							Dimension		Class-No.	PU	Ident-No.
DP cutting edges					Ø D=125 / 35°		17,2x8,9x14,2		232239	4	185974
							[mm]			[pc.]	

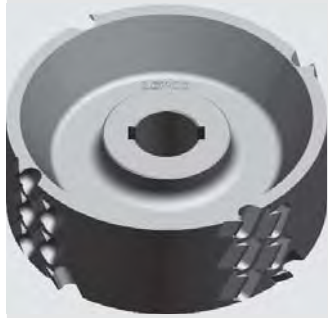
SmartJointer airFace Ø D=125 / 43°

Ø D	B	b	Ø d	Z	nmax			Number of cutting edges	Ident-No. [L]	Ident-No. [R]	
125	45	57	30	3+3	10500	asymmetrical	IMA 08.379	15	186053 s	186054 s	
125	63	57	30	3+3	10500	asymmetrical	IMA 08.379	21	186055	186056	
[mm]	[mm]	[mm]	[mm]		[min-1]			[pc.]			
Spare parts							Dimension		Class-No.	PU	Ident-No.
DP cutting edges					Ø D=125 / 43°		17,2x8,9x14,2		232239	4	186075
							[mm]			[pc.]	
Spare parts / Accessories							Dimension		Class-No.	PU	Ident-No.
Countersunk Screws							M5x13,5 T20		995125	10	185080
Plug Insert Torx							T20		985730	2	185293
Torque Screwdrivers							5,0 Nm		985730	1	185292
							[mm]			[pc.]	

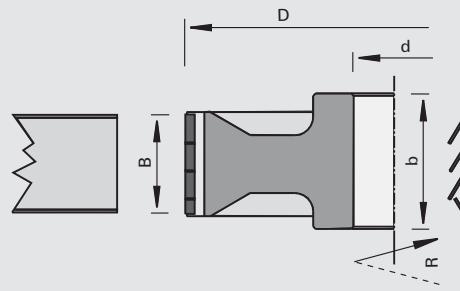
222220

DIAMAX Jointing Cutters CM DP - Homag

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines Homag
- for chip-free jointing of melamine-, paper-, HPL-laminated and veneered panels

Design

- opposing shear angle
- spiral cutting edges
- resharpenable area 1.5 mm

Advantages

- high quality in the decor
- optimized chip removal thanks to ChipMeister version (with i-System jointing aggregate)
- noise reduced

Notes

- application with or against feed
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]
180	63	58.5	35	4+4	10x3,3	10000	181261 s	181262 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

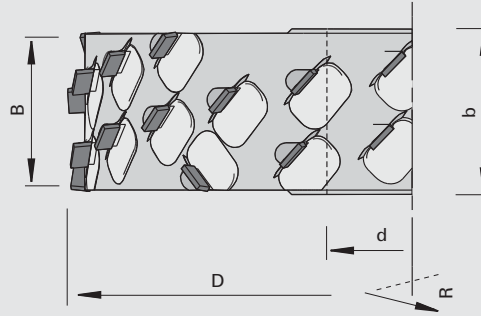
222020

Joining Cutter CM DP - one-part

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge banding machines
- | for use on milling aggregates
- | for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | asymmetrical design
- | large opposing shear angle
- | resharpening area 4 mm

Advantages

- | optimized chip removal thanks to ChipMeister version
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | optimal glueing of edges
- | excellent cutting quality even in the case of loose core
- | suitable for laser edging

Notes

- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
180	43	48	35	5+5	10x3,3	10000	asymmetrical	185065	185066
180	64,2	60	35	5+5	10x3,3	10000	asymmetrical	185067	185068
180	32,4	37	35	6+6	10x3,3	10000	asymmetrical	185131	185130
180	43	48	35	7+7	10x3,3	10000	asymmetrical	185047 s	185048 s
180	64,2	60	35	7+7	10x3,3	10000	asymmetrical	185049 s	185050 s
200	32,4	37	35	6+6	10x3,3	9000	asymmetrical	185133 #	185132 #
200	43	48	35	6+6	10x3,3	9000	asymmetrical	185069	185070
200	64,2	60	35	6+6	10x3,3	9000	asymmetrical	185051 s	185052 s
200	43	48	35	8+8	10x3,3	9000	asymmetrical	185053 s	185054 s
200	64,2	60	35	8+8	10x3,3	9000	asymmetrical	185055 s	185056 s
200	43	48	35	10+10	10x3,3	9000	asymmetrical	185057 s	185058 s
200	64,2	60	35	10+10	10x3,3	9000	asymmetrical	185059 s	185060 s
220	43	48	35	12+12	10x3,3	8500	asymmetrical	185061 s	185062 s
220	64,2	60	35	12+12	10x3,3	8500	asymmetrical	185063 s	185064 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

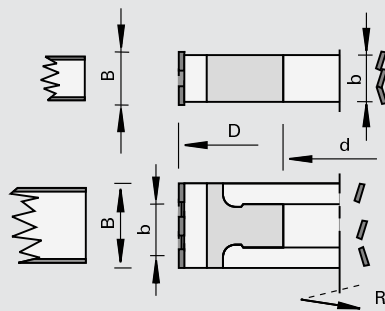
222120

DIAREX airFace Jointing Cutters DP

Product



Drawing



LEUCO
DIAREX
222120

Polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on noise reduction and quality standards

Design

- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 48°
- resharpening area 3 mm

Advantages

- compared to the LowNoise version, additional noise reduction by -2 dB(A) through airFace design and reduced gullet volume
- increased durability in comparison to standard jointing cutters
- optimum cutting quality thanks to a very large shear angle
- suitable for zero-joint technology
- suitable for demanding abrasive panel materials
- machining of 8-mm panels is possible without adjustment

Notes

- Z=4+4 tools for feed speed > 22 m/min!
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
70	48,1	41	30	3+3	8x3,3	24000	HOLZ-HER 1801 / 1802	asymmetrical	186316 s	186317 s
70	64	41	30	3+3	8x3,3	24000	HOLZ-HER 1801 / 1802	asymmetrical	186318 s	186319 s
80	42,8	53	30	2+2	8x3,3	23300	Biesse	symmetrical	186309 s	186309 s
85	48,1	50	30	3+3	8x3,3	22000	Ott	asymmetrical	186356 s	186357 s
85	64	70	30	3+3	8x3,3	22000	Ott	asymmetrical	186358 s	186359 s
100	64	75	30	3+3	8x3,3	18000	Biesse	symmetrical	186308 s	186308 s
100	42,8	40,6	30	3+3	8x3,3	18000	Brandt	asymmetrical	186312	186313
100	64	40,6	30	3+3	8x3,3	18000	Brandt	asymmetrical	186310 s	186311 s
100	42,8	61	30	2+2	8x3,3	18000	EBM, Hebrock	asymmetrical	186315 s	186314 s
100	64	40	30	3+3	8x3,3	18000	HOLZ-HER 1804	symmetrical	186320	186321
100	42,8	60,6	30	3+3	8x3,3	18000	SCM	asymmetrical	186362	186363
100	64	60,6	30	3+3	8x3,3	18000	SCM	asymmetrical	186360 s	186361 s
125	26,9	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186904 s	186905 s
125	32,2	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186900	186901
125	42,8	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186332	186333
125	42,8	54	30	4+4	8x3,3	15000	Homag	asymmetrical	186336 s	186337 s
125	64	54	30	3+3	8x3,3	15000	Homag	asymmetrical	186328	186329
125	64	54	30	4+4	8x3,3	15000	Homag	asymmetrical	186340 s	186341 s
125	32,2	36,8	30	3+3	8x3,3	15000	Homag	symmetrical	186322	186322
125	32,2	36,8	30	4+4	8x3,3	15000	Homag	symmetrical	186325	186325
125	42,8	40	30	3+3	8x3,3	15000	Homag	symmetrical	186323	186323
125	42,8	40	30	4+4	8x3,3	15000	Homag	symmetrical	186326	186326
125	64	40	30	3+3	8x3,3	15000	Homag	symmetrical	186324	186324
125	64	40	30	4+4	8x3,3	15000	Homag	symmetrical	186327 s	186327 s
125	26,9	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186906 s	186907 s
125	32,2	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186902 s	186903 s
125	42,8	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186334	186335
125	64	72	30	3+3	8x3,3	15000	IMA 08.378	asymmetrical	186330	186331
125	42,8	72	30	4+4	8x3,3	15000	IMA 08.378	asymmetrical	186338 s	186339 s
125	64	72	30	4+4	8x3,3	15000	IMA 08.378	asymmetrical	186342 s	186343 s
125	26,9	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186910 s	186911 s
125	32,2	77	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186908 s	186909 s
125	42,8	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186350 s	186351 s
125	64	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	186348 s	186349 s

[mm] [mm] [mm] [mm]

[mm] [min-1]

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	42,8	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	186352 s	186353 s
125	64	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	186354 s	186355 s
150	42,8	70/30	4+4	12000	IMA 08.378 - Hydro	asymmetrical	186344	186345
150	64	70/30	4+4	12000	IMA 08.378 - Hydro	asymmetrical	186346 s	186347 s
[mm]	[mm]	[mm]		[min-1]				

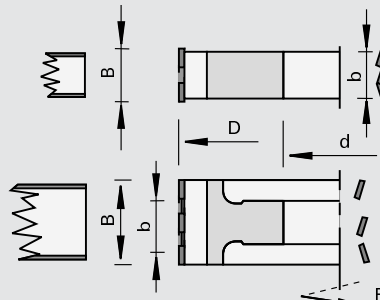
222120

DIAREX Jointing Cutters CM DP LowNoise

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines
- | for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | symmetrical and asymmetrical design
- | large opposing shear angle
- | uneven cutting edge configuration
- | resharpening area 3 mm

Advantages

- | optimized chip removal thanks to ChipMeister version
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | optimal glueing of edges
- | optimized as to noise level and chip flow
- | excellent cutting quality even in the case of loose core
- | suitable for laser-edge-technology

Notes

- | sense of rotation according to DIN-EN 50144

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	43	70/30	3+3	15000	IMA 08.378 - Hydro	asymmetrical	184969 s	184970 s
125	43	70/30	4+4	15000	IMA 08.379 - Hydro	asymmetrical	185119 s	185118 s
125	43	70/30	5+5	15000	Homag Performance S2 - Hydro	symmetrical	185169	185170
125	63	70/30	5+5	15000	Homag Performance S2 - Hydro	symmetrical	185171	185172
150	43	70/30	5+5	12000	Homag Power S2 / Performance S2 - Hydro	symmetrical	185165	185166
150	63	70/30	5+5	12000	Homag Power S2 / Performance S2 - Hydro	symmetrical	185167	185168
[mm]	[mm]	[mm]		[min-1]				

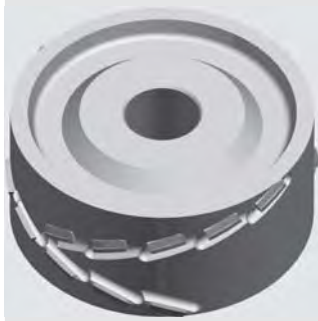
mounted on tool holder HSK 63 F, modified Ident-No. 184787

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
150	43	HSK 63F	5+5	12000	Homag Power S2 HSK 63F	symmetrical	185173 s	185174 s
150	63	HSK 63F	5+5	12000	Homag Power S2 HSK 63F	symmetrical	185175 s	185176 s
[mm]	[mm]	[mm]		[min-1]				

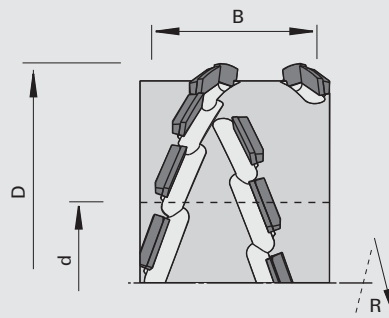
222226

p-System Jointing Cutters CM DP - MAN

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MAN

Machine / Application

- | table shaper
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical design
- | non-convex design
- | extremely scoring cut
- | resharpening area 1.5 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible

Notes

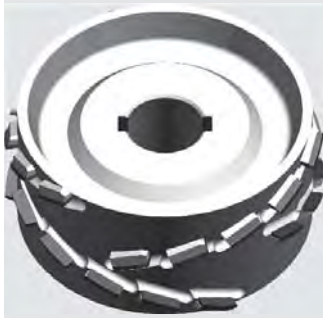
- | application against feed
- | recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- | crowned design on request
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Shear∠	nmin-nmax		Ident-No. [L]	Ident-No. [R]
125	28,2	35.2	30	2+2	70	6100-10500	symmetrical	184332	184332
125	47,8	54.8	30	2+2	70	6100-10500	symmetrical	184333	184333
125	28,2	35.2	30	3+3	70	6100-10500	symmetrical	184329 s	184329 s
125	47,8	54.8	30	3+3	70	6100-10500	symmetrical	184330 s	184330 s
[mm]	[mm]	[mm]	[mm]		[°]	[min-1]			

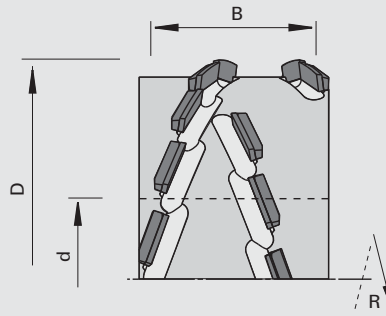
222324

p-System High-Performance Jointing Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge banding machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical and asymmetrical design
- | extremely scoring cut
- | resharping area 4 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | perfectly suitable for laser-edge-technology

Notes

- | application against feed
- | recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- | crowned design on request
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
70	47,8	41	30	3+3	8x3,3	27000		asymmetrical	184079 s 184078 s
100	42,9	40.6	30	3+3	8x3,3	19000	Brandt, SCM	asymmetrical	184074 s 184073 s
100	62,5	40.6	30	3+3	8x3,3	19000	Brandt, SCM	asymmetrical	184077 s 184076 s
125	33,1	25	30	3+3	8x3,3	15000	Homag	symmetrical	185818 185818
125	42,9	40.6	30	3+3	8x3,3	15000	Homag, IMA 08.378	asymmetrical	184961 s 184962 s
125	42,9	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	184987 s 184988 s
125	47,8	40	30	3+3	8x3,3	15000	Homag	symmetrical	184071 184071
125	61,5	40	30	3+3	8x3,3	15000	Homag	quasi symmetrical	184328 s 184327 s
125	62,5	40.6	30	3+3	8x3,3	15000	Homag, IMA 08.378	asymmetrical	184963 s 184964 s
125	62,5	57	30	3+3	8x3,3	15000	IMA 08.379	asymmetrical	184989 s 184990 s
180	42,9	58.5	35	5+5	10x3,3	10000		quasi symmetrical	184085 s 184063 s
180	62,5	58.5	35	5+5	10x3,3	10000		quasi symmetrical	184086 s 184064 s
180	62,5	58.5	35	8+8	10x3,3	10000		quasi symmetrical	184087 s 184065 s
200	42,9	50	35	5+5	10x3,3	9000		quasi symmetrical	184088 s 184066 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax		Ident-No. [L]	Ident-No. [R]
125	42,9	70/30	3+3	15000	IMA 08.378 Hydro	asymmetrical	184977 s 184978 s
125	42,9	70/30	4+4	15000	IMA 08.379 Hydro	asymmetrical	185127 s 185126 s
125	62,5	70/30	3+3	15000	IMA 08.378 Hydro	asymmetrical	184979 s 184980 s
125	62,5	70/30	4+4	15000	IMA 08.379 Hydro	asymmetrical	185129 s 185128 s
[mm]	[mm]	[mm]		[min-1]			

mounted on Hydro-Bushing Ident-No. 172678

Ø D	B	Ø d	Z	nmax		Ident-No. [L]	Ident-No. [R]
200	42,9	60/40	8+8	9000		asymmetrical	184068 s 184067 s
200	62,5	60/40	8+8	9000		asymmetrical	184070 s 184069 s
[mm]	[mm]	[mm]		[min-1]			

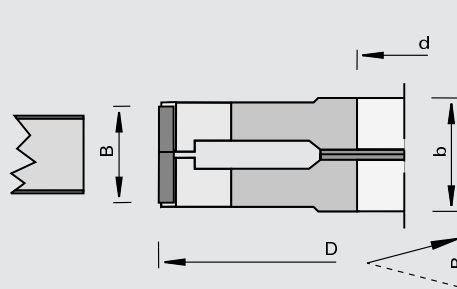
223020

Jointing Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- resharpenable area 3.5 mm
- opposing shear angle
- Ø 150 mm: n max = 12,000 min-1 / Ø 200 mm: n max = 9,000 min-1
- two-part version with spacer rings

Advantages

- tool allows for 3 adjustments = four single edge lives between sharpenings

Notes

- the specified feed rates are based on Ø = 150 mm: n = 9,000 min-1 / Ø = 200 mm: n = 6,000 min-1
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Recommended feed	Ident-No.
150	22-28	32	30	3+3	8x3	23	178798 s
200	22-28	32	35	4+4	10x4	20	178801 s
200	22-28	32	35	5+5	10x4	25	179073 s
200	22-28	32	35	6+6	10x4	30	178804 s
[mm]	[mm]	[mm]	[mm]		[mm]	[m/min]	

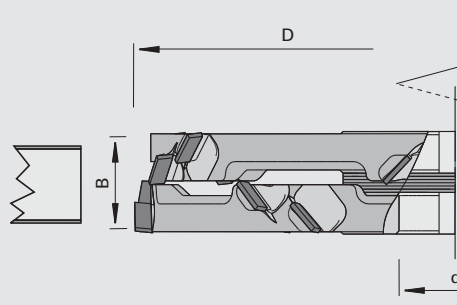
223020

Jointing Cutter CM DP - two-part

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- symmetrical design
- two-part adjustable via spacers
- large opposing shear angle
- resharpening area 4 mm

Advantages

- tool allows for 3 adjustments = four single edge lives between sharpenings
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- optimal glueing of edges
- excellent cutting quality even in the case of loose core
- suitable for laser edging

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]
200	22-28	32	35	6+6	10x3,3	9000	185079	185079
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

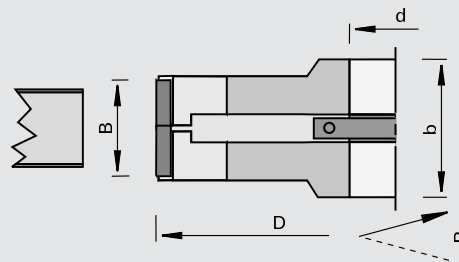
223020

Joining Cutters DP progressively adjustable

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners with precision spindle (hexagon adapter)
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- resharpenable area 4.0 mm
- Ø 200 mm: n max = 9,000 min-1 / Ø 240 mm: n max = 6,000 min-1

Advantages

- clear increase of edge life thanks to concentric accuracy achieved by hydro clamping
- adjusting several times allows the addition of edge lives
- reduction of machine down-times thanks to of user-friendly adjustment device

Notes

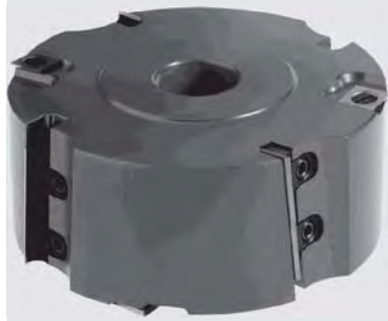
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No. [L]	Ident-No. [R]
200	22-28	101	40	2x(4+4)	25	180099 s	180098 s
200	22-28	101	40	2x(6+6)	35	180101 s	180100 s
200	22-28	101	40	2x(8+8)	45	180103 s	180102 s
200	22-28	101	40	2x(10+10)	55	180105 s	180104 s
240	22-28	101	40	2x(12+12)	65	180107 s	180106 s
240	22-28	101	40	2x(14+14)	80	180180 s	180179 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

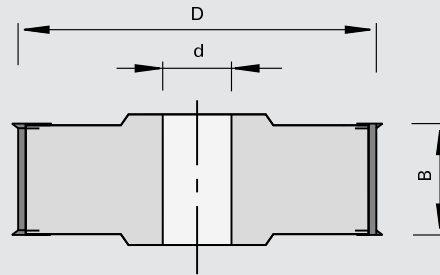
120265

Joining and Rabbeting Cutterheads HW with shear angle

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

table shapers
for chip-free joining and rabbeting in solid woods and wood-based panels
Ident-No. 179181 also suitable for PMMA (acrylic glass)

Design

with face shear angles from above and below
cutting material: HW HL Board 05
body made from high-quality light-metal alloy

Advantages

optimum cutting quality
plane surface

Notes

application against feed


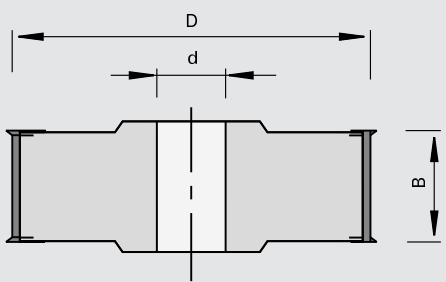

Ø D	B	Ø d	Z	nmin-nmax		Ident-No.
125	44	30	2+2	6100-10500	convex design	179181 s
140	60	30	4+4	5400-9400		179180
[mm]	[mm]	[mm]		[min-1]		

Turnover Knives		B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs		14	14	2.0	For all	150558	10	003079
Knives	convex design	49,6	11.8	1.5	179181	151567	10	179330
Turnover Knives		50	12	1.5	179180	150515	10	003085
		[mm]	[mm]	[mm]			[pc.]	

Spare parts		Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars		48x11x6	179181	925300	2	180632 s
Pressure Bars		48x11x6	179180	925300	2	180346
Clamping Pieces		12x8,5/M8L	For all	925100	2	180357
Clamping Set Screws		M8x26 SW4	For all	995161	10	180340
Countersunk Screws	for spur	M5x10,8 T15	For all	995125	10	180840
Screwdrivers		SW4x100	For all	985730	1	166091
Screwdrivers		T15x80	For all	985730	1	171188
		[mm]				

120255

Joining and Rabbeting Cutterheads HW without shear angle

<p>Product</p> 	<p>Drawing</p> 	 <p>Tungsten Carbide [HW]</p> <p>MAN</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> I table shapers I for joining and rabbeting in solid woods and wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> I cutting edges parallel to cutter axis I cutting material: HW HL Board 05 	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> I application against feed
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Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
85	50	30	2+4		9000-15500	167038
100	30	30	2+4		7700-13300	167039 s
100	50	30	2+4		7700-13300	167040 s
125	30	30	2+4		6100-10500	167041
125	50	30	2+4		6100-10500	167043
125	50	35	2+4	10x4	6100-10500	167044 &
125	50	30	4+4		6100-10500	167046
125	50	35	4+4	10x4	6100-10500	167047 &
125	50	40	4+4	12x5	6100-10500	167048 s
[mm]	[mm]	[mm]		[mm]	[min-1]	

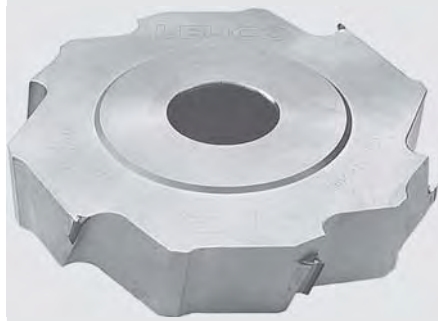
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Turnover Knives	30	12	1.5	150515	10	003083
Turnover Knives	50	12	1.5	150515	10	003085
	[mm]	[mm]	[mm]			[pc.]

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=30	167039, 167041	925300	2	164185
Pressure Bars	B=48	167038, 167040, 167043, 167044, 167046, 167047, 167048	925300	2	166984
Set Screws	M6x16 SW3	167039, 167041, 167043, 167044, 167046, 167047, 167048	995161	10	001617
Set Screws	M6x12 DIN EN ISO 4028	167038, 167040	995161	10	180214
Countersunk Screws	M5x10,8 T15	For all	995125	10	180840
Screwdrivers	SW3x100	For all	985730	1	166090
Screwdrivers	T15x80	For all	985730	1	171188
Adjusting Gauges	1,0	For all	985200	1	011103
	[mm]				[pc.]

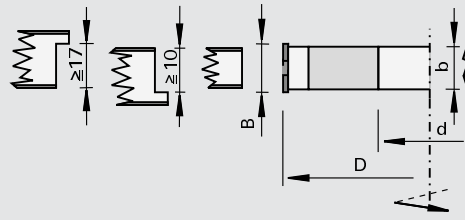
222225

DIAMAX Jointing / Rabbeting Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MAN

Machine / Application

- table shapers
- machines Homag
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels

Design

- opposing shear angle
- resharpenable area 1.5 mm

Advantages

Notes

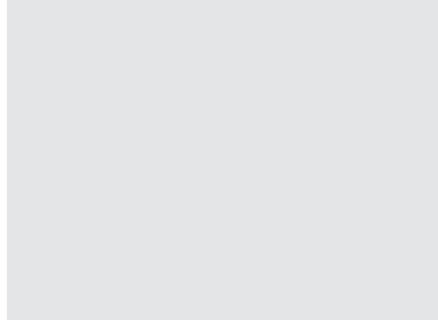
- application against feed
- sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
125	25	30	2+2	8x3	6100-10500	173710
125	25	50	2+2		6100-10500	173786 s
125	43	30	2+2	8x3	6100-10500	182705 s
[mm]	[mm]	[mm]		[mm]	[min-1]	

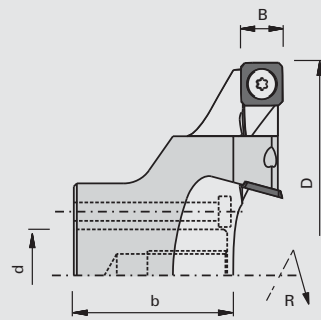
120200

Planing and Rabbeting Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design

- cutting material: HL Solid 20

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	DKN	Z	NL	nmax	Ident-No.
150	14	51.9	30	8x3,3	4	6/7/48	10100	182439 s
[mm]	[mm]	[mm]	[mm]	[mm]			[min-1]	

Turnover Knives

B

H

S

Class-No.

PU

Ident-No.

14

14

2.0

150557

10

180932

[mm]

[mm]

[mm]

[pc.]

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws

M5x6 T20

995125

10

176199

Screwdrivers

T20x100

985730

1

166092

[mm]

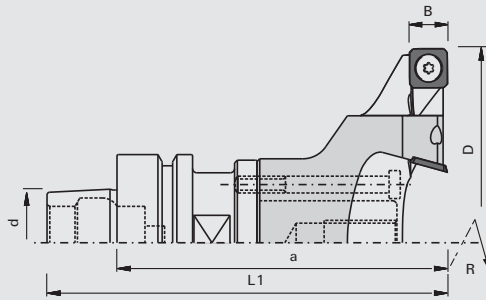
[pc.]

128200

Planing and Rabbeting Cutterheads HW - mounted on arbor

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l CNC routers
l for planing and rabbeting in wood-based panels

Design

l mounted on tool holder HSK 63 F

Advantages

l high milling performance when dressing the workbench boards, e.g. with Nesting-technology
l smooth surface thanks to special cutting edge geometry

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	L1	a	Z	nmax	Ident-No.
150	14	HSK 63F	138	113	4	10100	182440 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts

Mounting Arbors with HSK shank

Class-No.

PU

Ident-No.

933069

1

183748

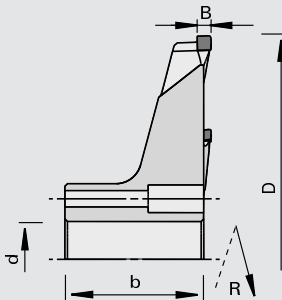
[pc.]

220020

Planing and Rabbeting Cutters DP

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

l CNC routers
l for planing, rabbeting and panel raising in wood-based panels

Design

l resharpening area 3.0 mm

Advantages

l high milling performance when dressing the workbench boards, e.g. with Nesting technology
l smooth surface thanks to special cutting edge geometry

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	nmax	Ident-No.
150	5,6	55	30	8	12700	182662 s
180	5,6	58	30	8	10300	182426 s
[mm]	[mm]	[mm]	[mm]		[min-1]	

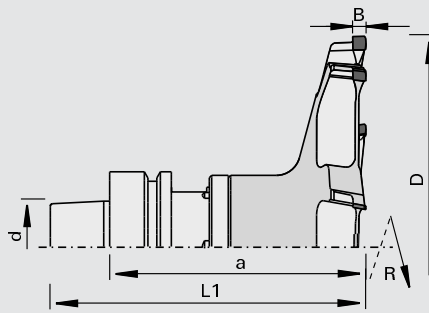
229020

Planing and Rabbeting Cutterheads DP - mounted on arbor

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for planing and rabbeting in wood-based panels

Design

- l mounted on tool holder HSK 63 F
- l resharpenable area 3.0 mm

Advantages

- l high milling performance when dressing the workbench boards, e.g. with Nesting-technology
- l smooth surface thanks to special cutting edge geometry

Notes

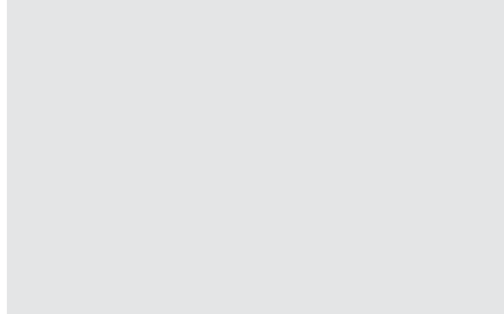
- l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	L1	a	Z	nmax	Ident-No.
150	5,6	HSK 63F	128	103	8	12700	182661 s
180	5,6	HSK 63F	128	103	8	10300	182425 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

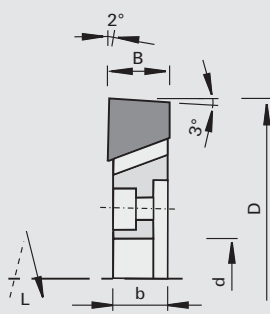
122200

Corner Notching Cutters HW - Homag

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- l CNC machining centers Homag / aggregate 7547
- l for sharp-edged cutting out of inside corners

Design

- l n max = 24.000 min-1

Advantages

Notes

- l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No.
75	15	13	16	4	182457
[mm]	[mm]	[mm]	[mm]		

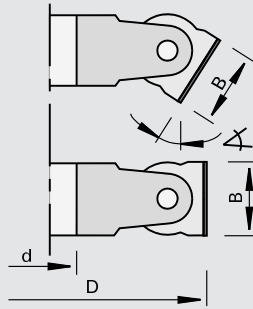
120305

Swivel Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

| table shapers
 | for chamfering, jointing and rabbeting with adjustable chamfer angle in solid woods and in veneered and plastic-coated panels

Design

| cutting edges parallel to cutter axis
 | cutting material: HW HL Board 05

Advantages
Notes

| application against feed
 | rabbeting with additional spur
 | pivot range up to 60 degree
 | Ø 120 mm chamfer angle adjustable from 5 degree to 5 degree
 | Ø 150 mm chamfer angle adjustable from 1 degree to 1 degree

Ø D	B	Ø d	Z	nmin-nmax	Ident-No. top
120	40	30	2	6400-11000	179184 s
150	50	30	2	5200-9000	179185
150	50	40	2	5200-9000	180903 s
160	50	50	2	4800-8000	180904 s
[mm]	[mm]	[mm]		[min-1]	

Pre-scoring discs	Ø D	B	Ø d	Z	Class-No.	PU	Ident-No.
	150	8,0	30	2	120255	1	179182 s
	[mm]	[mm]	[mm]			[pc.]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Turnover Knives	40	12	1.5	150515	10	164078
Turnover Knives	50	12	1.5	150515	10	003085
	[mm]	[mm]	[mm]			[pc.]

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=40	925300	2	50930125 s
Pressure Bars	B=50	925300	2	50930124
Countersunk Screws	M5x6,8 T15	995125	10	180839
Set Screws	M6x16 SW3	995161	10	001617
Screwdrivers	SW3x100	985730	1	166090
Cranked Wrench Keys	SW6 DIN ISO 2936	985730	1	009675
	[mm]			[pc.]

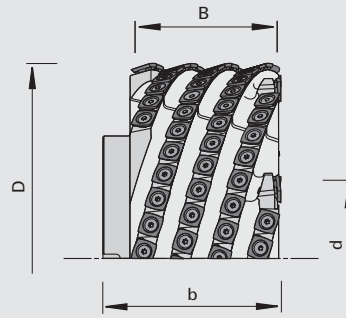
120281

p-System Profile Cutters HW

Product



Drawing



LEUCO
p-system

Tungsten Carbide [HW]

MEC

Machine / Application

- | machine
- | EWD FR15, FR16
- | Linck VPF340
- | for milling of corners / profiling

Design

- | one part and segmented
- | turnover knives can be used on all four sides
- | extremely scoring cut
- | cutting material: HW HL Solid 20

Advantages

- | no chippings due to knots
- | considerable improvement of surface quality compared to the existing chipping knives
- | small chips suitable for pellet production
- | extremely long edge lives (up to 8 million running meters)

Notes

- | chips are not suitable for paper industry
- | feed rate per tooth fz = 2-8 mm

Ø D	B	b	Ø d	Z	Shear∠		
360	139,5	164	110	8+8	70	vertical axis top	EWD
360	139,5	164	110	8+8	70	vertical axis bottom	EWD
402	139	164	110	8+8	70	vertical axis top	EWD
402	139	164	110	8+8	70	vertical axis bottom	EWD
402	121	139	120/200	8+8	70	vertical axis top	Linck
402	121	139	120/200	8+8	70	vertical axis bottom	Linck
360	64	164	60	4+4	70	horizontal axis right	EWD
360	64	164	60	4+4	70	horizontal axis left	EWD
360	64	164	60	5+5	70	horizontal axis right	EWD
360	64	164	60	5+5	70	horizontal axis left	EWD
360	64	164	60	8+8	70	horizontal axis right	EWD
360	64	164	60	8+8	70	horizontal axis left	EWD
360	89,2	164	60	6+6	70	horizontal axis right	EWD
360	89,2	164	60	6+6	70	horizontal axis left	EWD
[mm]	[mm]	[mm]	[mm]		[°]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
for Ø D=360 mm	21	21	5.5	HL Solid 60	151559	10	186110
for Ø D=402 mm	21	21	5.5	HL Solid 60	151559	10	186111
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Head Cap Screws	M14x60 ISO 4762 12.9	995111	10	185008	
Head Cap Screws	M14x80 DIN 4762 12.9	995111	10	185181	
Conical Screws	M6x10 D7.8x20GRD 10.9	995191	10	184891	
Countersunk Screws	M7x17 T30 10.9	995125	10	185643	
Repair set	thread inserts, twist drills, hand tap, spindle insert, tang break-off tool	M7	985200	1	185881 s
Helicoil®	M7x10,5	995490	10	50930340	
	[mm]		[pc.]		

Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for Ø D=360 mm left and Helicoil® d=7.5 mm	997600	1	186440 s
Drilling fixture	for Ø D=360 mm right and Helicoil® d=7.5 mm	997600	1	186441 s
Drilling fixture	for Ø D=360 mm left and core hole d=5.5 mm	997600	1	186442 s
Drilling fixture	for Ø D=360 mm right and core hole d=5.5 mm	997600	1	186443 s
Drilling fixture	for Ø D=402 mm left and Helicoil® d=7.5 mm	997600	1	186444 s
Drilling fixture	for Ø D=402 mm right and Helicoil® d=7.5 mm	997600	1	186445 s
			[pc.]	

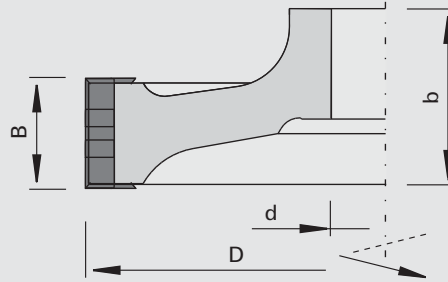
Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for $\varnothing D=402$ mm left and core hole $d=5.5$ mm	997600	1	186446 s
Drilling fixture	for $\varnothing D=402$ mm right and core hole $d=5.5$ mm	997600	1	186447 s
[pc.]				

120261 Tenoning Cutterheads surfCut HW

Product



Drawing



LEUCO
surfCut

Tungsten Carbide [HW]

MEC

Machine / Application

- | Hundegger, Weinmann joinery centers
- | for milling tenons, lap joints, profiles and notches

Design

- | with shear angle
- | with four-sided turnover knives
- | spurs HW
- | high-tensile aluminum body

Advantages

- | high milling performance
- | less rework
- | clean-cut look
- | variable use
- | reduced frequency of cutting edge replacement
- | longer edge life

Notes

- | for HSK mounting arbors with double key without spacer
- | exact dimensions and hub design to be cleared with the LEUCO Application Engineering Dept.

$\varnothing D$	B	b	$\varnothing d$	Z	DKN		Ident-No.
250	125	125	55	4+4		Weinmann	186169 s
300	20	80	55	4+4		Weinmann	186170 s
300	40	80	55	4+4		Weinmann	186171 s
350	40	75	55	4+4	16x4,3	Hundegger	186174 s
350	20	75	55	4+4	16x4,3	Hundegger	186175 s
350	60	75	55	4+4	16x4,3	Hundegger	186176 s
[mm]	[mm]	[mm]	[mm]		[mm]		

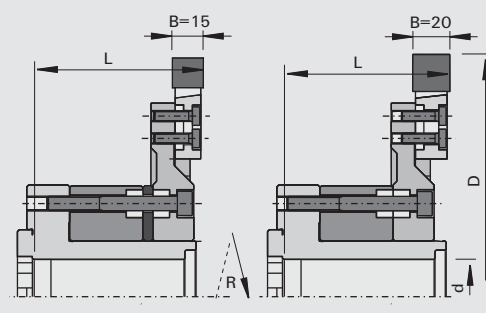
296590

Profile Cutterhead Sets - flooring - unprofiled

Product



Drawing



LEUCO
DIA

Polycrystalline diamond [DP]

Machine / Application

- | through-feed machines
- | double end tenoners
- | for profiling of the longitudinal and transverse profiles in machining of flooring (laminated, parquet and LVT)

Design

- | cutting edges unprofiled
- | modular design: bushing, flange, cutterhead and cutting edge
- | design from Z2 until Z12
- | all parts are available from stock

Advantages

- | fast, customer-specific profiling
- | tools are available on short notice
- | ideal for profile developments and tests

Notes

- | single parts are mounted to sets
- | cutting inserts can be profiled separate from the cutterhead
- | reproducibility after exchange: max 0.05 mm in runout-accuracy / concentricity

Ø D	B	Ø d	Z	L	nmax	Ident-No. [L]	Ident-No. [R]
251	15	40	2	98	6000	185309 &	185308 &
251	15	40	3	98	6000	185311 &	185310 &
251	15	40	4	98	6000	185313 &	185312 &
251	15	40	6	98	6000	185315 &	185314 &
251	15	40	12	98	6000	185317 &	185316 &
[mm]	[mm]	[mm]		[mm]	[min-1]		

Ø D	B	Ø d	Z	L	nmax	Ident-No. [L]	Ident-No. [R]
260.4	20	40	2	98	6000	185371 &	185381 &
260.4	20	40	3	98	6000	185372 &	185382 &
260.4	20	40	4	98	6000	185373 &	185383 &
260.4	20	40	6	98	6000	185374 &	185384 &
260.4	20	40	12	98	6000	185375 &	185385 &
[mm]	[mm]	[mm]		[mm]	[min-1]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Cutting edges DP-tipped unprofiled	B=15	232921	4	185045
Cutting edges DP-tipped unprofiled	B=20	232921	4	185370
Tool body profile cutterheads	210X23X60	396291	1	185043
Spacers (only for B=15)	Ø119x5,0xØ60	955520	1	185365
Spacers	Ø119x39,5xØ60	955520	1	185044
Head Cap Screws	M6x20-8.8 DIN 6912	995111	10	185355
Head Cap Screws	M8x70 DIN EN ISO 4762	995111	10	179470
Hydro Clamping Bushing	Ø120x96xØ60/40	933030	1	172678
	[mm]		[pc.]	

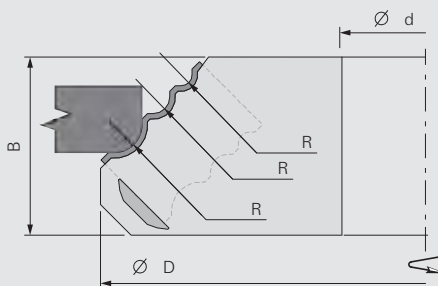
120325

Round Star Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | spindle moulder
- | for profiling of solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Solid 20
- | high-tensile aluminum body
- | chip limiter design

Advantages

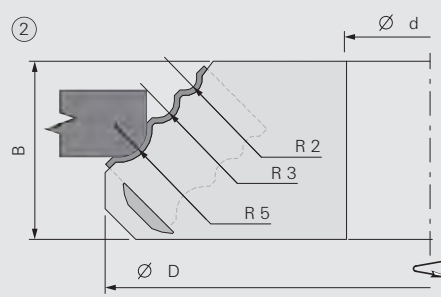
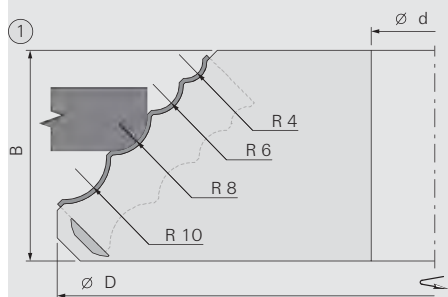
Notes

- | application against feed

R	Ø D	B	Ø d	Z	Type	nmin-nmax	Ident-No.
2, 3, 5	140	32	30	2	2	5400-6400	50661673 s
4, 6, 8, 10	180	50	30	2	1	4600-7800	50661672 s
[mm]	[mm]	[mm]	[mm]			[min-1]	

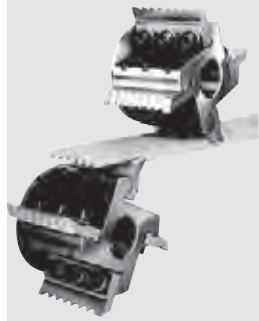
Turnover Knives	Type	R	B	H	S	Class-No.	PU	Ident-No.
Profile Knives KB19	2	2, 3, 5	25	16	2.0	151547	2	50820002
Profile Knives KB20	1	4,6,8,10	50	16	2.0	151547	2	50820001
		[mm]	[mm]	[mm]	[mm]			[pc.]

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	23x11x6	925300	2	50591382 s
Pressure Bars	48x11x6	925300	2	180346
Clamping Pieces	12x8,5/M8L	925100	2	180357
Clamping Set Screws	M8x26 SW4	995161	10	180340
Screwdrivers	SW4x100	985730	1	166091
	[mm]			[pc.]

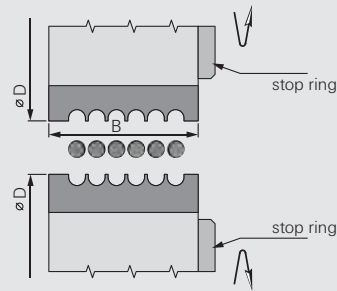


Multi Dowel Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | multi spindle milling machines
- | for the production of smooth round bars of 2 to 16 mm and of corrugated dowels of 6.1 to 16.1 mm in solid woods

Design

- | body made from steel
- | 2 or 4 knife holders

Advantages

- | quick knife change
- | self-centering knife seat

Notes

- | guide-plate for axial adjustment of knives
- | further profiles on request

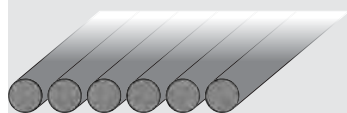
$\varnothing D$	B	$\varnothing d$	$\varnothing d_{max}$	Z	nmax	Ident-No.
102	50	35	40	2	6000	50389261 s
102	75	35	40	2	6000	50389262 s
102	100	35	40	2	6000	50389263 s
102	50	40	40	2	6000	50389264 s
102	75	40	40	2	6000	50389265 s
102	100	40	40	2	6000	50389266 s
102	125	40	40	2	6000	50389267 s
102	150	40	40	2	6000	50389268 s
102	50	35	40	4	6000	50389269 s
102	75	35	40	4	6000	50389270 s
102	100	35	40	4	6000	50389271 s
102	50	40	40	4	6000	50389272 s
102	75	40	40	4	6000	50389273 s
102	100	40	40	4	6000	50389274 s
102	125	40	40	4	6000	50389275 s
102	150	40	40	4	6000	50389276 s
[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M8x30	995111	10	180005
Washers	B=8,4 DIN 125	995410	10	50945505 s
Cranked Wrench Keys	SW6x100	985730	1	180383 o
	[mm]		[pc.]	

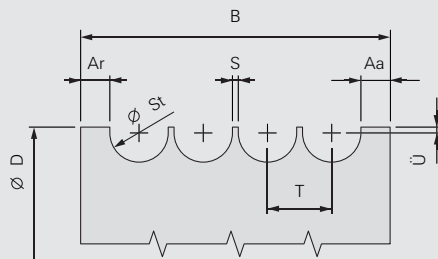
332990

Knives HS - smooth round bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- | small quantities: surcharge of 50%
- | intermediate dimensions: surcharge of 25% on the next lower dimension
- | indicate machine type when placing an order
- | price per piece when ordering 8 identical knives

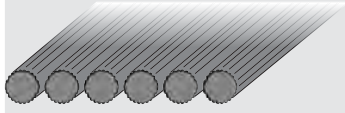
Knives

St= bar Ø	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
S = bridge	1	1	1	1	1	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	3	4	5	6	7	8	9	10	11	12,5	13,5	14,5	15,5	16,5	17,5
D= diameter	127	127	127	127	127	127	135	135	135	135	135	135	135	135	135
B=50 No. of bars	12	9	8	7	6	5	4	4	3	3	3	3	2	2	2
Ident-No. 50...	389200	389201	389202	389203	389204	389205	389206	389207	389208	389209	389210	389211	389212	389213	389214
B=75 No. of bars		16	13	11	9	8	7	6	6	5	5	4	4	4	4
Ident-No. 50...		389215	389216	389217	389218	389219	389220	389221	389222	389223	389224	389225	389226	389227	389228
B=100 No. of bars			18	15	13	11	10	9	8	7	6	6	6	5	5
Ident-No. 50...			389229	389230	389231	389232	389233	389234	389235	389236	389237	389238	389239	389240	389241
B=125 No. of bars				16	14	13	11	10	9	8	8	7	7	7	7
Ident-No. 50...				389242	389243	389244	389245	389246	389247	389248	389249	389250	389251	389252	
B=150 No. of bars								14	13	11	10	9	9	8	8
Ident-No. 50...								389253	389254	389255	389256	389257	389258	389259	389260

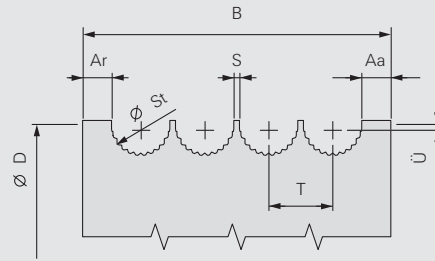
332990

Knives HS - ripple bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- | small quantities: surcharge of 50%
- | intermediate dimensions: surcharge of 25% on the next lower dimension
- | indicate machine type when placing an order
- | price per piece when ordering 8 identical knives

Knives

St= bar \varnothing	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
No. of serrations	16	16	20	22	22	22	22	22	22	22
S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
D= diameter	127	127	135	135	135	135	135	135	135	135
B=50										
No. of bars	6	5	4	3	3	3	3	2	2	2
Ident-No. 50...	389300	389301	389302	389303	389304	389305	389306	389307	389308	389309
B=75										
No. of bars	9	8	7	6	5	5	4	4	4	3
Ident-No. 50...	389310	389311	389312	389313	389314	389315	389316	389317	389318	389319
B=100										
No. of bars	12	11	10	8	7	6	6	5	5	5
Ident-No. 50...	389320	389321	389322	389323	389324	389325	389326	389327	389328	389329
B=125										
No. of bars	16	14	13	10	9	8	8	7	7	6
Ident-No. 50...	389330	389331	389332	389333	389334	389335	389336	389337	389338	389339
B=150										
No. of bars				12	11	10	9	9	8	8
Ident-No. 50...				389340	389341	389342	389343	389344	389345	389346

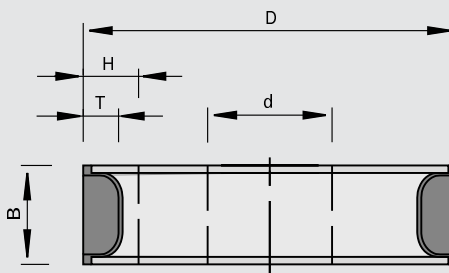
120607

SuperProfiler HW (inside profile) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

table shapers
for planing and profiling of solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
n = 6.200 - 10,700 min-1
cutting material: HW HL Board 06 for hard woods and wood-based panels
cutting material: HW HL Solid 60 for soft woods

Advantages

cutterhead for mounting of several profile knives

Notes

application against feed
profile knife can be profiled per customer specifications
included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 1	167263
125	60	30	35	15	2	SP 2	167264
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 1	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 1	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 2	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 2	152529	10	177368
support plates	40	26.5		SP 1	925402	2	178007
support plates	60	28.5		SP 2	925402	2	178008
deflector plates	40	28		SP 1	925407	1	167267
deflector plates	60	30		SP 2	925407	1	167268
	[mm]	[mm]					[pc.]

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167263	925300	2	166737
Pressure Bars	58x12x8	167264	925300	2	166738
Special Set Screws	M8x24	For all	995191	10	167269
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]				[pc.]

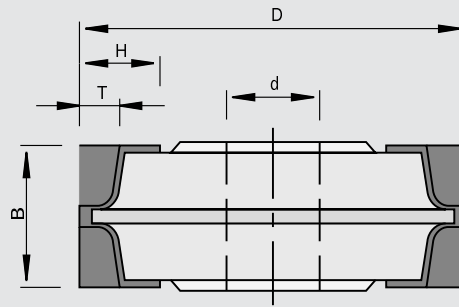
120607

SuperProfiler HW (outside profile) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- n = 6.200 - 10,700 min-1
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- application against feed
- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 3	167897 s
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

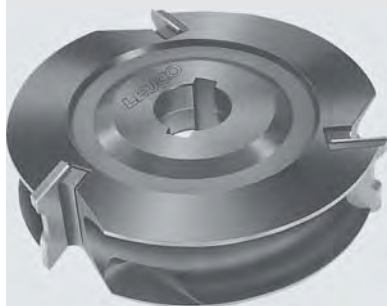
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 3	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 3	152529	10	177367
support plates	40	26.5		SP 3	925402	2	178011
deflector plates	40	28		SP 3	925407	1	167898
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	925300	2	166737
Special Set Screws	M8x24	995191	10	167269
Screwdrivers	SW4x100	985730	1	166091
	[mm]		[pc.]	

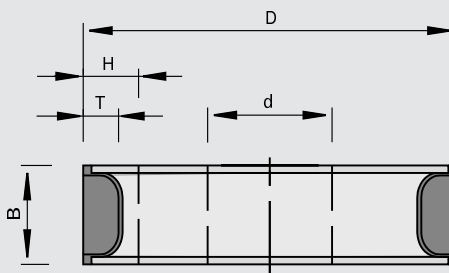
120602

SuperProfiler HW (inside profile) - MEC

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- molders
- profiling unit and length processing unit IMA
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives and support plates

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	nmax	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	8x3	12000	SP 7	167439 s
125	40	31,75	35	13	2		12000	SP 7	167440 s
125	60	31,75	35	15	2		12000	SP 5	167442 s
150	40	30	50	13	3	8x3	10000	SP 7	166971
150	40	31,75	50	13	3		10000	SP 7	176184 s
150	40	35	50	13	3	10x4	10000	SP 7	166972
150	40	40	50	13	3	12x5	10000	SP 7	166973
150	60	30	50	15	3	8x3	10000	SP 5	166975 s
150	60	40	50	15	3	12x5	10000	SP 5	166977 s
150	60	31,75	35	25	3		7200	SP 4	176230 s
165	40	30	50	20	3	8x3	8500	SP 33	176088
180	40	35	50	13	3	10x4	8000	SP 7	166720 s
180	40	40	50	13	3	12x5	8000	SP 7	166721 s
180	60	35	50	15	3	10x4	8000	SP 5	166723 s
180	60	40	50	15	3	12x5	8000	SP 5	166724 s
180	60	31,75	50	25	3		6000	SP 4	168127 s
180	60	50	50	25	3		6000	SP 4	168131 s
180	80	40	50	25	3	12x5	6000	SP 6	167993 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 7	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 7	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 5	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 5	152529	10	177368
SP blanks	40,6	40.6	HL Board 06	SP 33	152526	10	179115
SP blanks	40,6	40.6	HL Solid 60	SP 33	152529	10	178844
SP blanks	60,6	45.6	HL Board 06	SP 4	152526	10	179999
SP blanks	60,6	45.6	HL Solid 60	SP 4	152529	10	178845
SP blanks	80,6	45.6	HL Board 06	SP 6	152526	10	180016
SP blanks	80,6	45.6	HL Solid 60	SP 6	152529	10	180017
support plates	40	26.5		SP 7	925402	2	178007
support plates	40	38		SP 33	925402	2	178006
support plates	60	28.5		SP 5	925402	2	178008
support plates	60	43		SP 4	925402	2	178009
support plates	80	43		SP 6	925402	2	178013
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For drawing/foil	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	SP 7	925300	2	166737
Pressure Bars	36x14x8	SP 33	925300	2	176096 s
Pressure Bars	56x12x8	SP 4	925300	2	167055
Pressure Bars	58x12x8	SP 5	925300	2	166738
Pressure Bars	76x15x8	SP 6	925300	2	167989 s
Set Screws	M8x20 DIN EN ISO 4028		995161	10	001625
Screwdrivers	SW4x100		985730	1	166091
	[mm]			[pc.]	

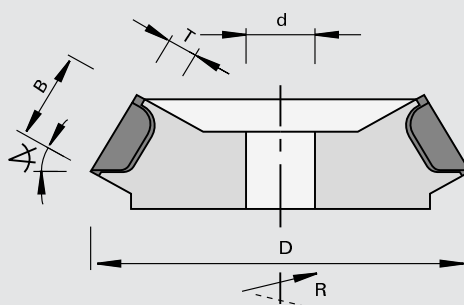
120622

SuperProfiler HW (outside profile) - MEC

Product



Drawing



**SUPER
PROFILER**

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- molders
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives and support plates
- sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	Crank∠	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]	[Foil]	167967 s	167968 s
165	40	30	40	13	3	8x3	30	9000	SP 13		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
	[mm]	[mm]				[pc.]	
SP blanks	40,6	28.2	HL Board 06	SP 12 / 13	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 12 / 13	152529	10	177367
support plates	40	26.5		SP 12 / 13	925402	2	178007

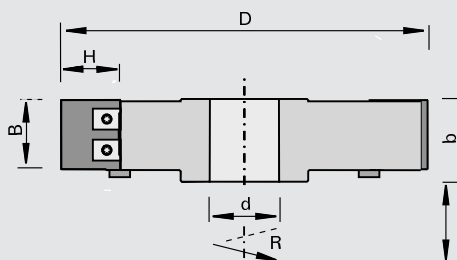
Spare parts	Dimension	For drawing/foil	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	left	925300	2	166736
Pressure Bars	36x12x8	right	925300	2	166737
Set Screws	M8x20 DIN EN ISO 4028		995161	10	001625
Screwdrivers	SW4x100		985730	1	166091
	[mm]			[pc.]	

120603

EcoPro Cutterheads HW (straight) - MAN

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | special aluminum cutterhead body
- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead body and knives will be profiled according to customer specifications

Notes


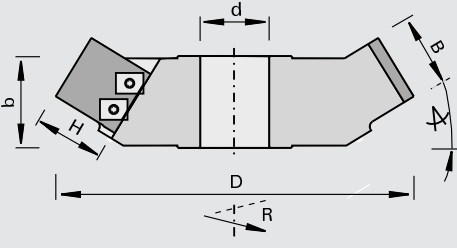

- | profile knives can be profiled according to customer specifications
- | cutterhead body can be used only for one profile
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	b	Ø d	Ø dmax	Z	nmin-nmax	EP-No.	Drawing	Ident-No. unprofiled
125	30	30	36	30	30	3	7700-10480	50	EP 382	179050 s
125	40	30	46	30	30	3	7700-9480	51	EP 384	179051 s
125	50	33	56	30	30	3	7700-8420	52	EP 386	179052 s
150	30	30	36	30	50	3	6200-9620	53	EP 382	179053 s
150	40	30	46	30	50	3	6200-8420	54	EP 384	179054 s
150	50	33	56	30	50	3	6200-7300	55	EP 386	179055 s
180	30	30	36	30	50	4	4800-8600	56	EP 382	179056 s
180	40	30	46	30	50	4	4800-7520	57	EP 384	179057 s
180	50	33	56	30	50	4	5200-6500	58	EP 386	179058 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Board 06	EP 382	152586	10		178528
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Solid 60	EP 382	152589	10		179528
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Board 06	EP 384	152586	10		178534
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Solid 60	EP 384	152589	10		179534
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06	EP 386	152586	10		178540
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60	EP 386	152589	10		179540
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Board 06 topline	EP 382	152786	10	179585 &	179586 &
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Solid 60 topline	EP 382	152789	10	179659 &	179660 &
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Board 06 topline	EP 384	152786	10	179597 &	179598 &
	[mm]	[mm]				[pc.]		

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Solid 60 topline	EP 384	152789	10	179671 &	179672 &
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06 topline	EP 386	152786	10	179609 &	179610 &
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60 topline	EP 386	152789	10	179683 &	179684 &
	[mm]	[mm]					[pc.]	
Spare parts	Dimension			Class-No.	PU	Ident-No.		
Screws	M4,5x4,6x9 T15			995195	10	178239		
Screwdrivers	T15x80			985730	1	171188		
	[mm]						[pc.]	

120613 EcoPro Cutterheads HW (cranked) - MAN

Product	Drawing	
		 Tungsten Carbide [HW] MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machining centers double end tenoners molders table shapers for profiling of solid woods and wood-based panels 	<ul style="list-style-type: none"> with shear angle cutting material: HW HL Board 06 for hard woods and wood-based panels cutting material: HW HL Solid 60 for soft woods 	<ul style="list-style-type: none"> cutterhead body and knives will be profiled according to customer specifications 	<ul style="list-style-type: none"> profile knives can be profiled according to customer specifications cutterhead body can be used only for one profile sense of rotation according to DIN-EN 50144

Ø D	B	H	b	Ø d	Ø dmax	Z	Crank∠	nmin-nmax	EP-No.	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
150	40	30	49	30	30	3	30	6300-7460	59	EP 390	179350 s	179059 s
180	40	30	50	30	50	4	30	5000-6580	61	EP 390	179355 s	179061 s
180	50	33	57	30	50	4	30	5000-5700	62	EP 392	179358 s	179062 s
165	40	30	46	30	30	3	45	5300-6920	63	EP 396	179360 s	179063 s
165	50	33	53	30	30	3	45	4600-6040	64	EP 398	179362 s	179064 s
195	40	30	46	30	50	4	45	5300-6160	65	EP 396	179365 s	179065 s
195	50	33	53	30	50	4	45	4600-5320	66	EP 398	179368 s	179066 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[min-1]		[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30,4	HL Board 06	EP 396	152586	10		178534
	[mm]	[mm]					[pc.]	

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30,4	HL Solid 60	EP 396	152589	10		179534
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Board 06	EP 398	152586	10		178540
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Solid 60	EP 398	152589	10		179540
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30,4	HL Board 06 topline	EP 390, EP 396	152786	10	179597 &	179598 &
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30,4	HL Solid 60 topline	EP 390, EP 396	152789	10	179671 &	179672 &
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Board 06 topline	EP 392 / 398	152786	10	179609 &	179610 &
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Solid 60 topline	EP 392 / 398	152789	10	179683 &	179684 &
	[mm]	[mm]				[pc.]		
Spare parts			Dimension		Class-No.	PU	Ident-No.	
Screws			M4,5x4,6x9 T15		995195	10	178239	
Screwdrivers			T15x80		985730	1	171188	
			[mm]			[pc.]		

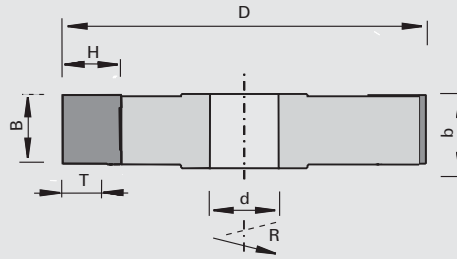
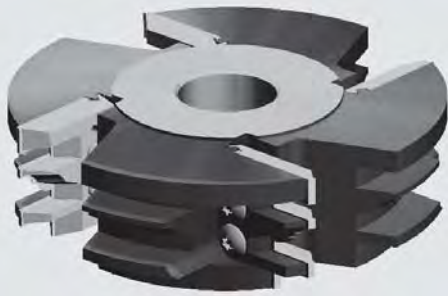


120604/120606

UltraProfilier plus - Cutterheads HW (straight) - MAN

Product

Drawing



LEUCO
ultraprofilier plus

Tungsten Carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | cutterhead body made from extremely tight aluminum alloy with shear angle
- | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- | large profile depths possible
- | cutterhead body and knives will be profiled according to customer specifications
- | cutting speed up to 80 m/s
- | concentric accuracy 0,03 mm

Notes

- | knives available in Topline design (polished face, ultra-fine ground clearance surface)
- | with a larger shear angle, the number of teeth may be lower
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	Ø d	Ø dmax	T	Z	nmin-nmax
115	15	30	30	30	15	2-3	6500-13300
125	15-60	40	30	30	26	2-4	6500-12300
150	15-60	40	30	50	26	2-6	5500-10200
180	15-60	40	30	50	26	2-6	5000-8500
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	15	30.4	2.0	HL Board 06	152516	10	183056
	20	40.4	2.0	HL Board 06	152516	10	183057
	25	40.4	2.0	HL Board 06	152516	10	183058
	32	40.4	2.0	HL Board 06	152516	10	182419
	40	40.4	2.0	HL Board 06	152516	10	182420
	50	40.4	2.0	HL Board 06	152516	10	182421
	60	40.4	2.0	HL Board 06	152516	10	182422
	[mm]	[mm]	[mm]				[pc.]

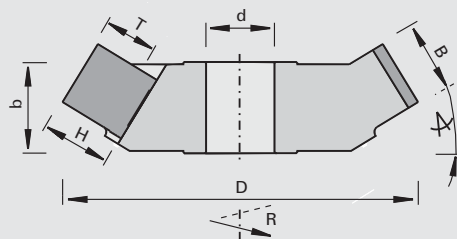
Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 o	183680 o
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 o	183681 o
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 o	183682 o
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 o	182562 o
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 o	182564 o
	50	40.4	2.0	HL Board 06 topline	152716	10	182567	182566
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 o	182568 o
	[mm]	[mm]	[mm]				[pc.]	

120614/120616

UltraProfiler plus - Cutterheads HW (cranked) - MAN

Product

Drawing



LEUCO
ultra profiler plus

Tungsten Carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | cutterhead body made from extremely tight aluminum alloy with shear angle
- | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- | large profile depths possible
- | cutterhead body and knives will be profiled according to customer specifications
- | cutting speed up to 80 m/s
- | concentric accuracy 0,03 mm

Notes

- | knives available in Topline design (polished face, ultra-fine ground clearance surface)
- | with a larger shear angle, the number of teeth may be lower
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	Ø d	Ø dmax	T	Z	nmin-nmax
150	32-40	40	30	30	26	2-6	5100-10200
165	32-50	40	30	30	26	2-6	5100-9200
180	40-60	40	30	50	26	2-6	5000-8500
195	40-60	40	30	50	26	2-8	4800-7800
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	15	30.4	2.0	HL Board 06	152516	10	183056
	20	40.4	2.0	HL Board 06	152516	10	183057
	25	40.4	2.0	HL Board 06	152516	10	183058
	32	40.4	2.0	HL Board 06	152516	10	182419
	40	40.4	2.0	HL Board 06	152516	10	182420
	50	40.4	2.0	HL Board 06	152516	10	182421
	60	40.4	2.0	HL Board 06	152516	10	182422
	[mm]	[mm]	[mm]				[pc.]

Blanks	B	H	S	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	152716	10	183680 o	183680 o
	20	40.4	2.0	HL Board 06 topline	152716	10	183681 o	183681 o
	25	40.4	2.0	HL Board 06 topline	152716	10	183682 o	183682 o
	32	40.4	2.0	HL Board 06 topline	152716	10	182563 o	182562 o
	40	40.4	2.0	HL Board 06 topline	152716	10	182565 o	182564 o
	50	40.4	2.0	HL Board 06 topline	152716	10	182567	182566
	60	40.4	2.0	HL Board 06 topline	152716	10	182569 o	182568 o
	[mm]	[mm]	[mm]				[pc.]	

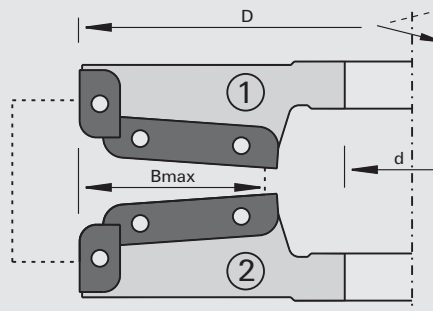
120645

Panel Raising Cutterheads HW - Silverline

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

l spindle moulder
l for panel-raising of door panels in solid woods and wood-based panels

Design

l tool body made from steel
l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05

Advantages

l up to 12 different profiles in the same tool body possible
l further versions possible thanks to height adjustment

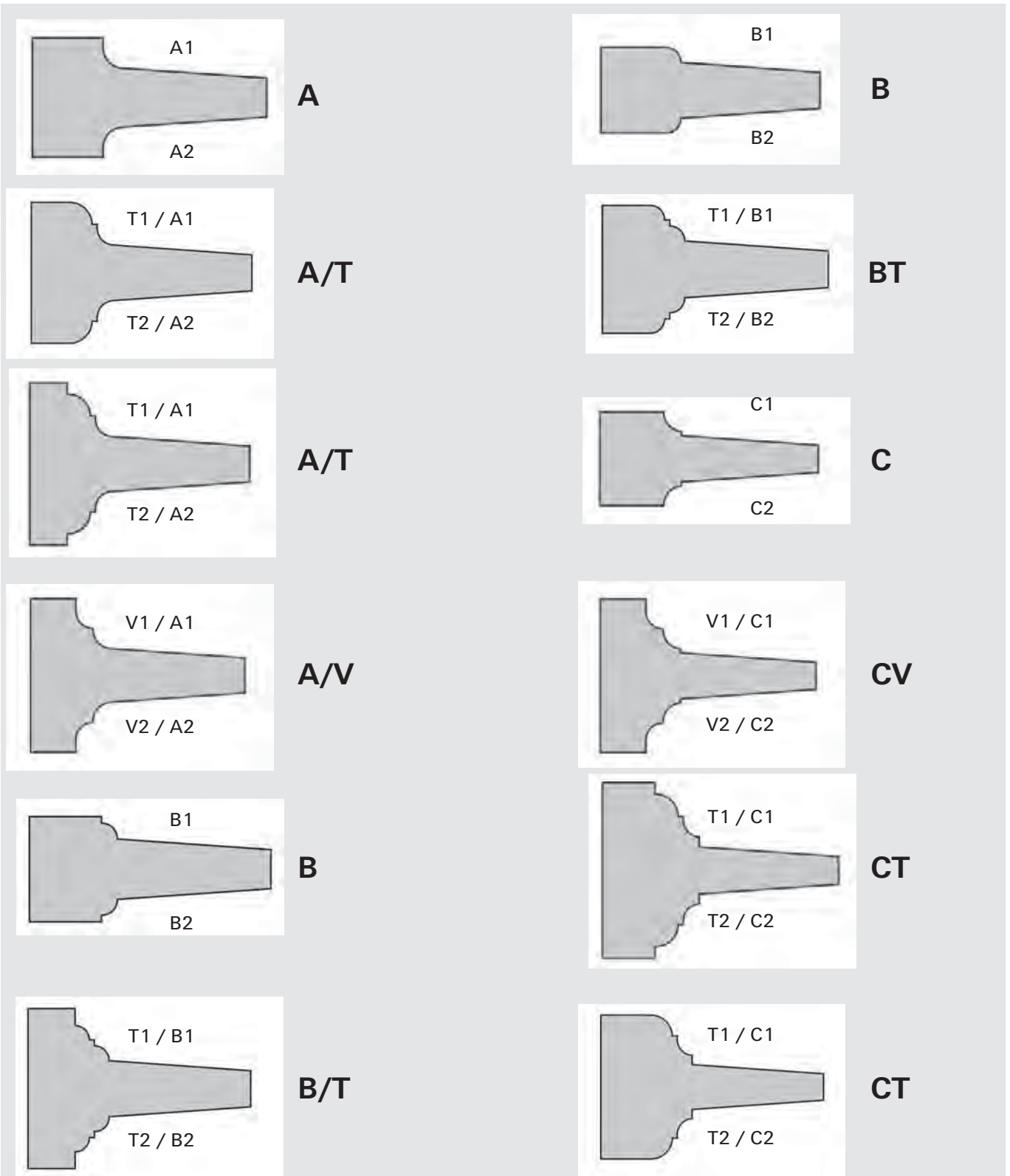
Notes

l included in delivery: 1 panel raising cutterhead with mounted knives for profile B (62556021, 62556022)
l alternative profiles not included in delivery

Cutter-no.	Ø D	Bmax	Ø d	Z	nmin-nmax	Ident-No.
1	200	60	30	2+2	3800 - 6500	L 68255130 o
2	200	60	30	2+2	3800 - 6500	R 68255230 o
1	200	60	40	2+2	3800 - 6500	L 68255140 o
2	200	60	40	2+2	3800 - 6500	R 68255240 o
1	200	60	50	2+2	3800 - 6500	L 68255150 o
2	200	60	50	2+2	3800 - 6500	R 68255250 o
	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Profile Panel Raising Cutting Edges A1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556011 o
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255240, 68255250	151549	6 R	62556012 o
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556021 o
Profile Panel Raising Cutting Edges B2	60x12x1,5	68255230, 68255240, 68255250	151549	6 R	62556022 o
Profile Panel Raising Cutting Edges C1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556031 o
Profile Panel Raising Cutting Edges C2	60x12x1,5	68255230, 68255240, 68255250	151549	6 R	62556032 o
Profile Peripheral Cutting Edges T1	20x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556023 o
Profile Panel Raising Cutting Edges T2	20x12x1,5	68255230, 68255240, 68255250	151549	6 R	62556024 o
Profile Peripheral Cutting Edges V1	20x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556013 o
Profile Panel Raising Cutting Edges V2	20x12x1,5	68255230, 68255240, 68255250	151549	6 R	62556014 o
	[mm]				[pc.]

Profile combinations



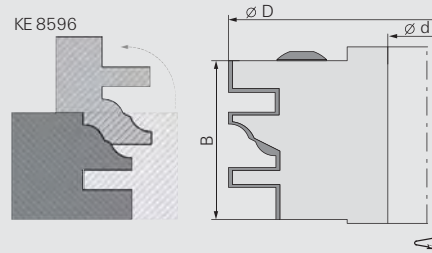
121625

Counter Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- spindle moulder
- for milling of length- and counterprofiles on doors, furniture parts and door panels in solid woods and wood-based panels

Design

- body made from high-strength aluminium
- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06
- chip limiter design

Advantages

- cutterhead for mounting of several profile knives
- simple knife change

Notes

- counter profile set with profile KE8596
- alternative profiles not included in delivery

$\varnothing D$	B	$\varnothing d$	Z	nmin-nmax	Ident-No.
130 [mm]	40 [mm]	30 [mm]	2	6000-12000 [min-1]	50664637

Turnover Knives

LEUCODUR

Class-No.

PU

Profile Knives	HL Board	Class-No.	PU	Ident-No.
Profile Knives KE7824	HL Board 06	151586	6	50687824 s
Profile Knives KE7826	HL Board 06	151586	2	50687826
Profile Knives KE7828	HL Board 06	151586	6	50687828 s
Profile Knives KE8596	HL Board 06	151586	6	50688596 s
Profile Knives KE8598	HL Board 06	151586	6	50688598 s

[pc.]

Spare parts

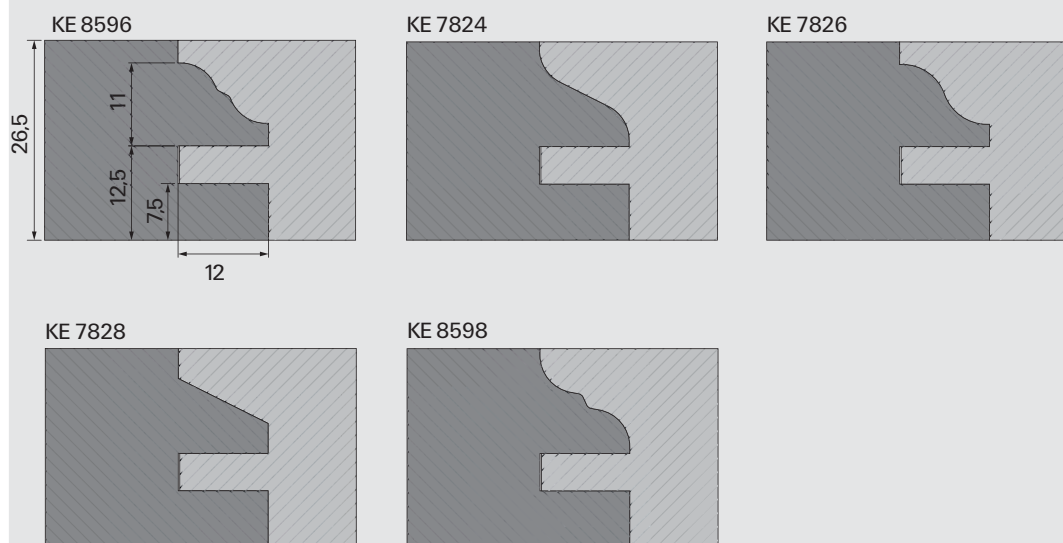
Dimension

Class-No.

PU

Ident-No.

Pressure Bars	B=36	925300	2	50773906 #
Set Screws	M6x16 SW3	995161	10	001617
Screwdrivers	SW3x100 [mm]	985730	1	166090 [pc.]



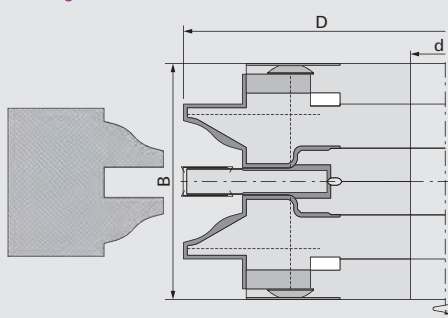
121625

Counter Profile Set HW

Product



Drawing



LEUCO DUR
Tungsten Carbide [HW]
MAN

Machine / Application

- spindle moulder
- for cutting of profile and counter profile in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW
- modular combination tool

Advantages

- cutterhead for mounting of several profile knives
- universal application with low expenses

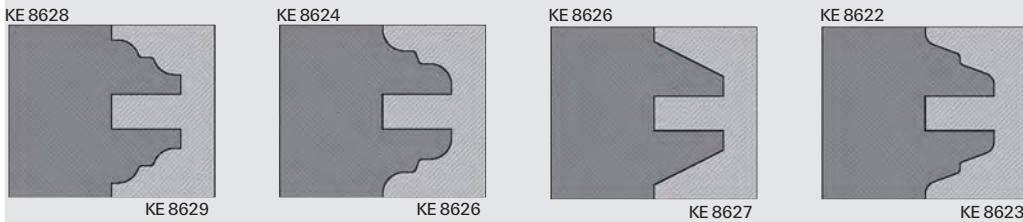
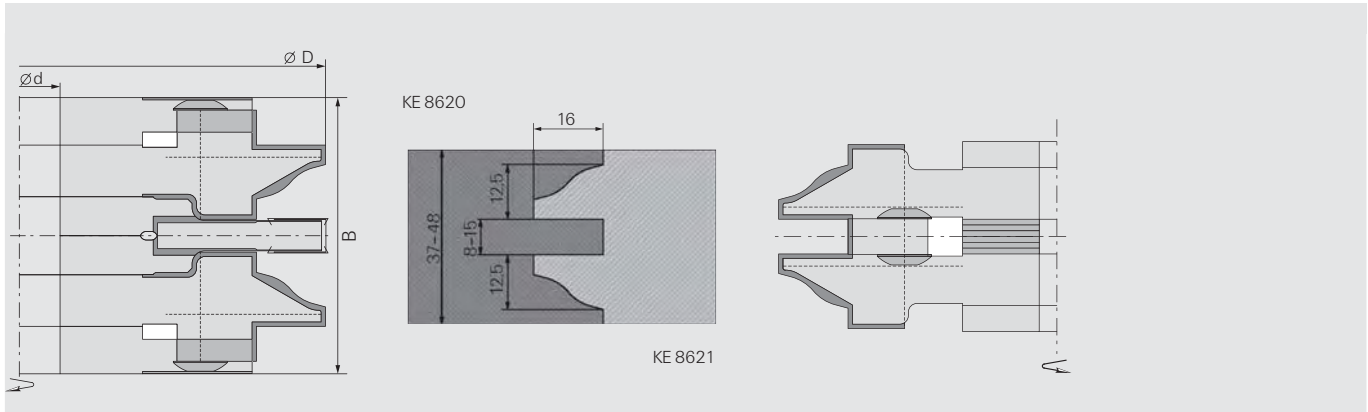
Notes

- counter profile set with profile A
- alternative profiles not included in delivery

Ø D	B	Ø d	Z	Profile	nmin-nmax	Ident-No.
160	37-48	30	2	A	4800-8200	50664655
[mm]	[mm]	[mm]			[min-1]	

Knives	Profile	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
Profile Knives KE8620	A	25,3	29	2.0	HL Board 06	151586	6	50688620 s
Profile Knives KE8621	A	25,3	29	2.0	HL Board 06	151586	6	50688621 s
Profile Knives KE8622	B	25,3	29	2.0	HL Board 06	151586	2	50688622 #
Profile Knives KE8623	B	25,3	29	2.0	HL Board 06	151586	6	50688623 s
Profile Knives KE8624	C	25,3	29	2.0	HL Board 06	151586	6	50688624 s
Profile Knives KE8625	C	25,3	29	2.0	HL Board 06	151586	6	50688625 s
Profile Knives KE8626	D	25,3	29	2.0	HL Board 06	151586	6	50688626 s
Profile Knives KE8627	D	25,3	29	2.0	HL Board 06	151586	6	50688627 s
Profile Knives KE8628	E	25,3	29	2.0	HL Board 06	151586	6	50688628 s
Profile Knives KE8629	E	25,3	29	2.0	HL Board 06	151586	6	50688629 s
Raker Turnover Knives		7,5	12	1.5	HL Board 05	150515	10	50820007
Turnover Knives		14	14	2.0	HL Solid 30	150518	10	50820014
		[mm]	[mm]	[mm]			[pc.]	

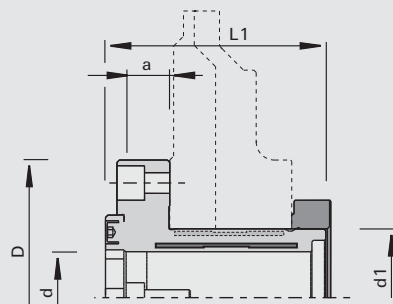
Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=23	925300	2	50774798 #
Pressure Bars	B=7,2	925300	2	168074
Set Screws	M6x16 SW3	995161	10	001617
Set Screws	M5x12 DIN EN ISO 4028	995161	10	050565
Countersunk Screws	M5x6 T20	995125	10	176199
Screwdrivers	SW3x100	985730	1	166090
Cranked Wrench Keys	SW2,5 DIN ISO 2936	985730	1	009671
Screwdrivers	T20x100	985730	1	166092
Adjusting Gauges	0,3	985200	1	055883
Spacer Sets	65/30x20 TK48	955521	1	50252708
	[mm]		[pc.]	



993030
Adjustment unit - ecoline - flooring

Product

Drawing



Machine / Application

- | through-feed machines
- | double end tenoners
- | for profiling of the longitudinal and transverse profiles in machining of flooring (laminate, parquet and LVT)

Design

- | unit for adjustable 2-piece profile tool
- | single (184765) and double (184770) pressure zone
- | impressurement hydro bushing radial

Advantages

- | system independent from tools, reusable
- | adjustable from top via adjustment nut

Notes

- | starter model
- | version without tool
- | included in delivery: bushing, nut, spring assembly

Ø D	Ø d	Ø d1	a	L1		Ident-No.
120	40	60	20	98	with one clamping zone	184765
120	40	60	20	98	with two pressure zones	184770
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Hydro Clamping Bushings	Ø120x96xØ60/40	184765	933030	1	184766
Hydro Clamping Bushings	Ø120x96xØ60/40	184770	933030	1	184771
Adjustment Nuts	M60x0,5x20,5 [mm]	For all	997300	1	184767
				[pc.]	

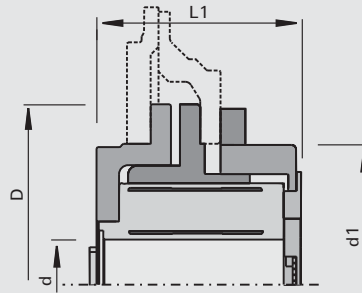
993030

Adjustment unit - topline - flooring

Product



Drawing



Machine / Application

- | through-feed machines
- | double end tenoners
- | for profiling of the longitudinal and transverse profiles in machining of flooring (laminated, parquet and LVT)

Design

- | unit for adjustable 2-part profiling tools
- | double clamping zone
- | pressurization through axial hydrobushing

Advantages

- | tool-independent system, reusable
- | adjustment from the top via nut
- | concentricity tolerance / run-out tolerance 0.03 mm

Notes

- | topline model
- | version without tool
- | included in delivery: bushing, flanges

Ø D	Ø d	Ø d1	L1	Ident-No.
160 [mm]	40 [mm]	125 [mm]	93.7 [mm]	186416

Spare parts	Dimension	Class-No.	PU	Ident-No.
Hydro Clamping Bushings	Ø90x82xØ40 [mm]	933030	1 [pc.]	186417

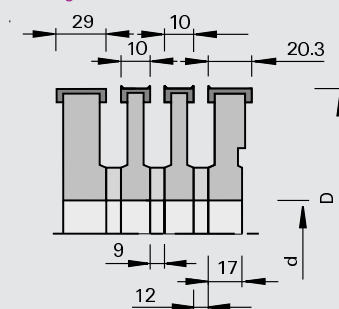
120450

Groove Bed Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l molders with groove bed section Weinig
- l for cutting of guide grooves in solid woods

Design

- l n max = 10,700 min-1
- l single tools with spur
- l Ident-No. 180536, 186498 without spur

Advantages

Notes

- l application with the grain
- l attention: replacement parts for old cutterhead sets: cutterhead width = 9 mm can be replaced with new cutterhead width = 10 mm when spacer width = 10 mm is replaced with spacer width = 9 mm cutterhead width = 10.5 mm can be replaced with cutterhead width = 10 mm

Ø D	B	Ø d	Z	Ident-No.
140	10	40	2+2	176066
140	20,3	40	2+2	176067
140	29	40	2	180536 s
140	39,5	40	2	186498 s
140	10	50	2+2	176069
140	20,3	50	2+2	176070
[mm]	[mm]	[mm]		

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	70	9	40	955520	1	177308
Spacers	70	12	40	955520	1	162706
Spacers	70	9	50	955520	1	177309 s
Spacers	70	10	50	955520	1	163886
Spacers	70	12	50	955520	1	163887 s
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Turnover Knives	9,6	12	1.5	150515	10	171163
Turnover Knives	20	12	1.5	150516	10	178287
Turnover Knives	29,5	12	1.5	150515	10	180825
Turnover Knives	39,5	12	1.5	150515	10	171149
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=7,2	176066, 176069	925300	2	168074
Set Screws	M5x12 DIN EN ISO 4028	176066, 176069	995161	10	050565
Countersunk Screws	M5x6 T20	176066, 176069	995125	10	176199
Adjusting Gauges	0,7	176066, 176069	985200	1	056096
Pressure Bars	B=17	176067, 176070	925300	2	167971
Set Screws	M8x16 DIN EN ISO 4028	176067, 176070, 180536	995161	10	164422
Countersunk Screws	M5x10,8 T15	176067, 176070	995125	10	180840
Adjusting Gauges	1,0	176067, 176070, 180536, 186498	985200	1	011103
Pressure Bars	B=30	180536	925300	2	164185
Pressure Bars	B=38	186498	925300	2	50775234
	[mm]				[pc.]

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Set Screws	M6x12 T15	186498	995195	10	50930404
Screwdrivers	SW2,5x100	176066, 176069	985730	1	168010
Screwdrivers	SW4x100	176067, 176070, 180536	985730	1	166091
Screwdrivers	T15x100	176067, 176070	985730	1	180470
Screwdrivers	T15x140	186498	985730	1	179145
Screwdrivers	T20x100	176066, 176067, 176069, 176070, 180536	985730	1	166092
	[mm]				[pc.]

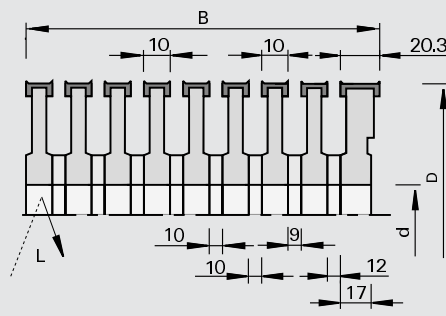
121450

Groove Bed Cutterhead Sets HW

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- l molders with groove bed section Weinig
- l for cutting of guide grooves in solid woods

Design

- l n max = 10,000 min-1

Advantages

Notes

- l application with the grain
- l complete tool sets for specific wood widths "B"

Ø D	B	Ø d	Z	Ident-No.
140	80	35	2+2	176071 &
140	100	35	2+2	176072 &
140	120	35	2+2	176073 &
140	140	35	2+2	176074 &
140	170	35	2+2	176075 &
140	80	40	2+2	176076 &
140	100	40	2+2	176077 &
140	120	40	2+2	176078 &
140	140	40	2+2	176079 &
140	170	40	2+2	176080 &
140	80	50	2+2	176081 &
140	100	50	2+2	176082 &
140	120	50	2+2	176083 &
140	140	50	2+2	176084 &
140	170	50	2+2	176085 &
[mm]	[mm]	[mm]		

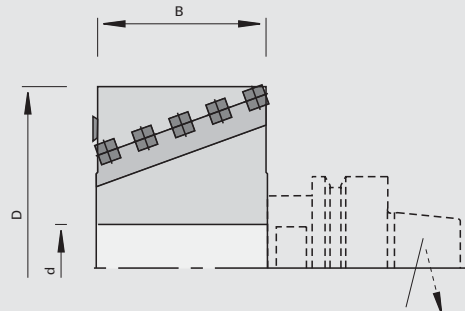
120760

Spiral Cutterheads HW

Product



Drawing



LEUCO
GNC

Tungsten Carbide [HW]

MEC

Machine / Application

- | stationary milling centers
- | for dressing, rough-planing, jointing, rabbeting, copying of solid woods and laminated timber

Design

- | with four-sided turnover knives, with rounded edges
- | 2 front spurs HW
- | spiral cutting layout of turnover knives and cut division
- | high-tensile aluminum body

Advantages

- | easy hogging, low cutting pressure and low noise level
- | high hogging volume

Notes

- | for HSK mounting arbors with double key without spacer
- | for Ident-No. 183678 clamping length 50 mm with HSK mounting arbor
- | for Ident-No. 183679 clamping length 80 mm with HSK mounting arbor

Ø D	B	Ø d	Z	nmax	Ident-No.
80	80	30	2+2+V2	18000	183678 s
80	100	30	2+2+V2	18000	183679 s
[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150517	10	180454
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x15,5 T20	995125	10	182112
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

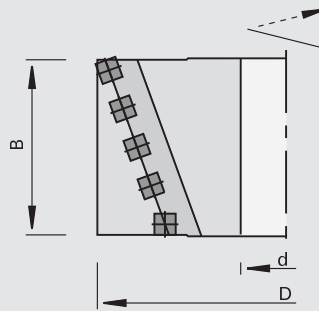
120710

Spiral Cutterheads HW - Finish

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l molders
l stationary milling centers
l for milling, rough-planing and finish-planing in solid woods

Design

l with four-sided turnover knives, with rounded edges
l spiral cutting layout of turnover knives and cut division
l high-tensile aluminum body

Advantages

l easy hogging, low cutting pressure and low noise level

Notes

l for finished cut

Ø D	B	Ø d	Z	n _{max}	Ident-No.
125	100	40	2+2	12000	182091 o
125	130	40	2+2	12000	182092 o
125	150	40	3+3	12000	185960 o
125	170	40	2+2	12000	182093 o
125	230	40	2+2	12000	182094 o
125	240	40	2+2	12000	182095 o
[mm]	[mm]	[mm]		[min ⁻¹]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150517	10	180454
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x15,5 T20	995125	10	182112
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

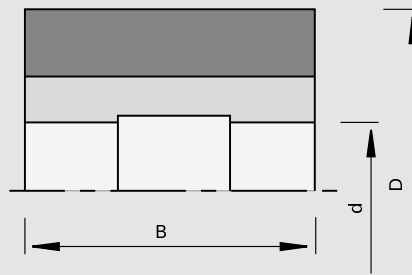
320700

Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | multi spindle plunging machines
- | for planing of solid woods

Design

- | n max = 9,000 min-1

Advantages

Notes

- | HS-tipped knives (18%) 30x3 mm
- | for adjusting the planing knives 2 adjustment rings are needed
- | alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Ident-No.
125	80	40	4	179204
125	100	40	4	181195
125	130	40	4	179194
125	150	40	4	179195
125	180	40	4	179196
125	230	40	4	181190
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=80	925300	2	179205 o
Pressure Bars	B=100	925300	2	181191 o
Pressure Bars	B=130	925300	2	179198 o
Pressure Bars	B=150	925300	2	179199 o
Pressure Bars	B=180	925300	2	179200 o
Pressure Bars	B=230	925300	2	181192 o
Adjustment Rings	125x40	985200	2	179201 o
Set Screws	M10x25 DIN EN ISO 4028	995161	10	168108
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	1	009674
	[mm]		[pc.]	

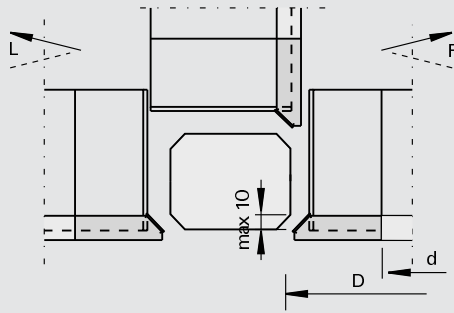
120301

Chamfering Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l molders
l for chamfering of solid woods

Design

l n max = 9,000 min⁻¹

Advantages

l possibility of simultaneous planing and chamfering of different wood cross-sections without changing tools thanks to the combination with planing cutterheads on vertical and horizontal spindles

Notes

l recommendation: run 4th chamfer on universal spindle
l sense of rotation according to DIN-EN 50144

Chamfer∠	∅ D	B	∅ d	∅ dmax	Z		Ident-No. [L]	Ident-No. [R]
10x45	145.6	15	40	50	4	for ∅ 125	181207 s	181206 s
10x45	160.6	15	40	50	4	for ∅ 140	181209 s	181208 s
[°]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	15	15	2.5	150517	10	181243
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M6x10 T20	995125	10	181244
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

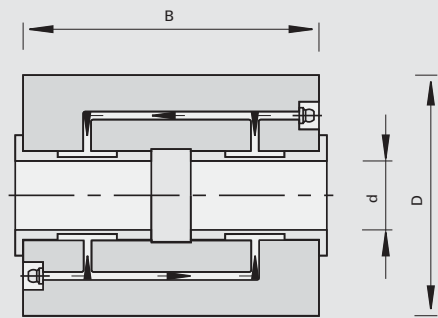
320200

Hydro Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

l hydro profile molders
l for planing of solid woods

Design

l n max = 9,000 min-1

Advantages

l high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
l high feed rates and optimum cutting quality

Notes

l HS-tipped knives 30 x 3 mm
l alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
143	60	40	4	27	178104 o
143	130	40	4	27	178105 o
143	230	40	4	27	178106 o
163	60	50	4	27	178107 o
163	100	50	4	27	178108 o
163	130	50	4	27	178109 o
163	150	50	4	27	178110 o
163	180	50	4	27	178112 o
163	230	50	4	27	178113 o
163	260	50	4	27	178115 o
163	310	50	4	27	178116 o
163	60	50	6	27	178117 o
163	100	50	6	27	178118 o
163	130	50	6	27	178119 o
163	150	50	6	27	178120 o
163	180	50	6	27	178122 o
163	230	50	6	27	178123 o
163	260	50	6	27	178125 o
163	310	50	6	27	178126 o
163	60	50	8	25	178127 o
163	100	50	8	25	178128 o
163	130	50	8	25	178129 o
163	150	50	8	25	178130 o
163	230	50	8	25	178131 o
163	260	50	8	25	178132 o
[mm]	[mm]	[mm]		[°]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[mm]			[pc.]

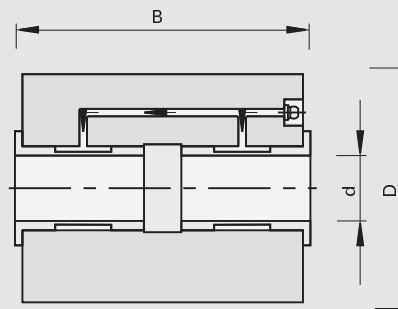
320200

Hydro-Rotaplane Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- $n_{max} = 6,000 \text{ min}^{-1}$

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
203	150	50	6	27	178133 o
203	230	50	6	27	178134 o
203	150	50	8	27	178136 o
203	230	50	8	27	178137 o
203	310	50	8	27	178139 o
203	150	50	10	23	178141 o
203	230	50	10	23	178142 o
203	310	50	10	23	178144 o
203	100	50	12	23	178145 o
203	150	50	12	23	178146 o
203	230	50	12	23	178147 o
203	310	50	12	23	178149 o
203	100	50	16	20	178150 o
203	150	50	16	20	178151 o
[mm]	[mm]	[mm]		[°]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[mm]		[pc.]	

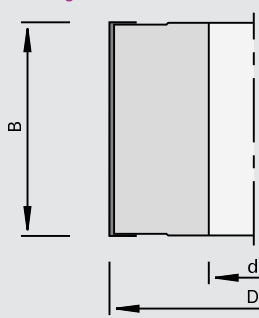
320700

Planing Cutterheads HS with centrifugal clamping

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | molders
- | four-side molders
- | for planing of solid woods

Design

- | aluminum body
- | n max = 9,000 min-1
- | spring-loaded balls (b) hold the knife before clamping

Advantages

- | quick tool change with centrifugal clamping, without clamping screws and without time-consuming adjustment procedure
- | tempered precision chip breaker (a) for precise positioning of the knives
- | very cost effective thanks to resharpenability
- | closed design for low noise level

Notes

- | HS-TRI -tipped knives
- | alternative cutting material: HW

Ø D	B	Ø d	Z	Ident-No.
100	80	30	3	70469103 s
100	180	30	3	70469104 s
100	120	30	3	70469105 s
125	130	40	4	70469108 s
120	120	40	4	70469109 s
125	230	40	4	70469110 s
125	180	40	4	70469112 s
120	130	40	4	70469113 s
120	180	40	4	70469115 s
120	230	40	4	70469116 s
125	80	40	4	70469117 s
125	100	40	4	70469121 s
125	120	40	4	70469122 s
125	240	40	4	70469128 s
125	130	40	2	70469159 s
125	180	40	2	70469162 s
125	230	40	2	70469163 s
125	240	40	2	70469164 s
125	190	40	4	70469209 s
125	190	40	2	70469212 s
[mm]	[mm]	[mm]		

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	60	HS-TRI	332121	2	70469707 o
	80	HS-TRI	332121	2	70469708 o
	100	HS-TRI	332121	2	70469710 o
	120	HS-TRI	332121	2	70469712 o
	130	HS-TRI	332121	2	70469713 o
	136	HS-TRI	332121	2	70469736 o
	140	HS-TRI	332121	2	70469714 o
	150	HS-TRI	332121	2	70469715 o
	160	HS-TRI	332121	2	70469716 o
	180	HS-TRI	332121	2	70469718 o
	186	HS-TRI	332121	2	70469786 o
	190	HS-TRI	332121	2	70469719 o
	200	HS-TRI	332121	2	70469720 o
	[mm]				[pc.]

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	210	HS-TRI	332121	2	70469721 o
	220	HS-TRI	332121	2	70469722 o
	230	HS-TRI	332121	2	70469723 o
	240	HS-TRI	332121	2	70469724 o
	260	HS-TRI	332121	2	70469726 o
	300	HS-TRI	332121	2	70469730 o
	310	HS-TRI	332121	2	70469731 o
	400	HS-TRI	332121	2	70469740 o
	410	HS-TRI	332121	2	70469741 o
	430	HS-TRI	332121	2	70469743 o
	500	HS-TRI	332121	2	70469750 o
	510	HS-TRI	332121	2	70469751 o
	610	HS-TRI	332121	2	70469761 o
	630	HS-TRI	332121	2	70469763 o
	640	HS-TRI	332121	2	70469764 o
	710	HS-TRI	332121	2	70469771 o
	1350	HS-TRI	332121	2	70469798 o
	[mm]				[pc.]
Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	80	HW	132121	2	70469908 o
	100	HW	132121	2	70469910 o
	120	HW	132121	2	70469912 o
	130	HW	132121	2	70469953 o
	140	HW	132121	2	70469914 o
	150	HW	132121	2	70469915 o
	160	HW	132121	2	70469916 o
	180	HW	132121	2	70469918 o
	200	HW	132121	2	70469920 o
	210	HW	132121	2	70469921 o
	220	HW	132121	2	70469922 o
	230	HW	132121	2	70469923 o
	240	HW	132121	2	70469924 o
	250	HW	132121	2	70469925 o
	260	HW	132121	2	70469926 o
	300	HW	132121	2	70469930 o
	610	HW	132121	2	70469999 o
	[mm]				[pc.]
Spare parts			Class-No.	PU	Ident-No.
Knife Changers			985720	1	70469100 o
					[pc.]

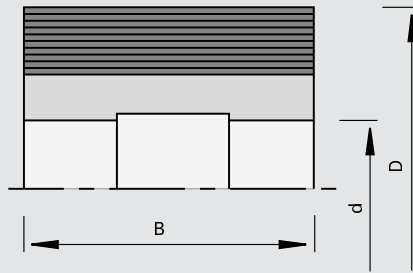
320600

Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- | molders
- | for profiling of solid woods

Design

- | hook angle 25 degrees
- | Ø 122 mm: n max = 9,000 min-1
- | Ø 137 mm: n max = 8,000 min-1

Advantages

- | high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- | precise serration (60 degrees, 1.6 mm pitch) ensures tight knife clamping
- | adjustable knives
- | profile depth and cutting circle Ø see table
- | for back-serrated blanks S = 5, 8, 10 mm
- | included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No.
122	40	40	4	179208
122	60	40	4	179209
122	80	40	4	179210
122	100	40	4	179211
122	130	40	4	179212
122	150	40	4	179213 o
122	180	40	4	179214
122	230	40	4	179215 o
137	60	50	4	179216 o
137	80	50	4	179217 o
137	100	50	4	179218 o
137	150	50	4	179219 o
137	180	50	4	179220 o
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=40	925300	2	179221 o
Pressure Bars	B=60	925300	2	179222 o
Pressure Bars	B=80	925300	2	179223 o
Pressure Bars	B=100	925300	2	179224 o
Pressure Bars	B=130	925300	2	179225 o
Pressure Bars	B=150	925300	2	179226 o
Pressure Bars	B=180	925300	2	179227 o
Pressure Bars	B=230	925300	2	179228 o
Dummy Pieces	B=40	925900	2	179229 o
Dummy Pieces	B=60	925900	2	179230 o
Dummy Pieces	B=80	925900	2	179231 o
Dummy Pieces	B=100	925900	2	179232 o
Dummy Pieces	B=130	925900	2	179233 o
Dummy Pieces	B=150	925900	2	179234 o
Dummy Pieces	B=180	925900	2	179235 o
Dummy Pieces	B=230	925900	2	179236 o
Set Screws	M10x20 DIN EN ISO 4028	995161	10	815807
Screwdrivers	SW5x150	985730	1	168703
	[mm]		[pc.]	

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
Dmax at D=137	176	176	186	196	196	216	216

Maximum RPM

B (mm)	50	55	60	70
Dmax at D=122	161	171	181	201
Max.RPM (min-1):	9000	8400	8000	7200
Dmax at D=137	176	186	196	216
Max.RPM (min-1):	8200	7700	7300	6600

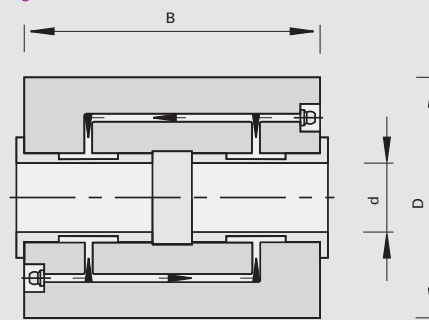
320600

Hydro Profile Cutterheads HS

Product



Drawing



MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- the max. RPM depends from the knife height (see table "Max. RPM")

Advantages

- best cutting quality without knife marks at high feed rates
- precise concentricity tolerance (system Weing) thanks to dual-chamber Hydro clamping
- high concentric accuracy and low operating vibration
- tight clamping thanks to precise serration (60 degrees, 1.6 mm pitch)

Notes

- adjustable knives
- profile depth and cutting circle \varnothing see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

$\varnothing D$	B	$\varnothing d$	Z	Ident-No.
137	60	40	4	176342 o
137	100	40	4	176343 o
137	130	40	4	176344 o
137	150	40	4	176345 o
137	180	40	4	176346 o
137	230	40	4	176347 o
150	60	50	4	176348 o
150	60	50	6	176349 o
150	100	50	4	176350 o
150	100	50	6	176351 o
150	130	50	4	176352 o
150	130	50	6	176353 o
150	150	50	4	176354 o
150	150	50	6	176355 o
150	180	50	4	176356 o
150	180	50	6	176357 o
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
150	230	50	4	176358 o
150	230	50	6	176359 o
150	260	50	4	176360 o
150	260	50	6	176361 o
150	310	50	4	176362 o
150	310	50	6	176363 o
163	60	50	8	176364 o
163	100	50	8	176365 o
163	130	50	8	176366 o
163	150	50	8	176367 o
163	180	50	8	176368 o
163	230	50	8	176369 o
163	260	50	8	176370 o
163	310	50	8	176371 o
195	60	50	10	176372 o
195	100	50	10	176373 o
195	130	50	10	176374 o
195	150	50	10	176375 o
215	60	50	12	176380 o
215	100	50	12	176381 o
215	130	50	12	176382 o
215	150	50	12	176383 o
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466
Screwdrivers	SW6x200	985730	1	167817
Grease presses		993270	1	163706
Grease Cartridges		993270	1	163707
	[mm]		[pc.]	

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=137	174	174	184	194	194	214	214
Dmax at D=150	189	189	199	209	209	229	229
Dmax at D=163	202	202	212	222	222	242	242

Maximum RPM

Knife height H [mm]	50	55	60	70
Dmax at D=137	174	184	194	214
Max.RPM (min-1):	8300	7800	7400	6700
Dmax at D=150	189	199	209	229
Max.RPM (min-1):	7700	7300	6900	6300
Dmax at D=163	202	212	222	242
Max.RPM (min-1):	7200	6800	6500	6000
Dmax for D=215	254	264	274	294
Max.RPM (min-1):	5700	5400	5200	4900

320208

Planing Cutterheads HS with Weinig HSK and Centrolock clamping bar

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

l molders "Weinig Powermat"
l for planing of solid woods

Design

l n max = 12,000 min-1

Advantages

l quick knife change thanks to
Centrolock clamping bar

Notes

l clamping by means of front
screw
l HS-tipped turnover knives
l alternative cutting material:
HW for hard woods, glued
timber and MDF
l picture shows sense of
rotation left (acc. to DIN left)
l Turnover Knives see chapter
Turnover Knives, Knives,
Inserts

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
93	60	Weinig-HSK	2	181728 o	181737 o
93	80	Weinig-HSK	2	181729 o	181738 o
93	100	Weinig-HSK	2	181730 o	181739 o
93	130	Weinig-HSK	2	181731 o	181740 o
93	150	Weinig-HSK	2	181732 o	181741 o
93	170	Weinig-HSK	2	181733 o	181742 o
93	190	Weinig-HSK	2	181734 o	181743 o
93	210	Weinig-HSK	2	181735 o	181744 o
93	240	Weinig-HSK	2	181736 o	181745 o
[mm]	[mm]	[mm]			

Spare parts

Hammer for Releasing the Knives
HSK-Mounting Device

Class-No.	PU	Ident-No.
985740	1	181746 o
985202	1	181747 o
	[pc.]	

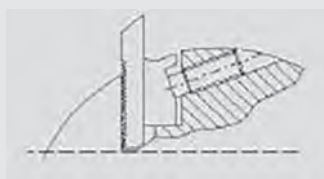
320608

Profile Cutterheads HS - Powerlock with Weinig HSK (blanks S=5,8,10 mm)

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- l molders "Weinig Powermat"
- l for profiling of solid woods

Design

- l hook angle 20 degrees (special 12 degrees)
- l n max = 12,000 min-1

Advantages

- l fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- l high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- l adjustable knives
- l possibility of sideways stop in the cutterhead
- l control of adjusting range of the knives through lunettes
- l picture shows sense of rotation right (acc. to DIN right)
- l for all back-serrated blanks S = 5, 8, 10 mm
- l included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 o	182314 o
90	60	Weinig-HSK	2	181766 o	181775 o
90	80	Weinig-HSK	2	181767 o	181776 o
90	100	Weinig-HSK	2	181768 o	181777 o
90	130	Weinig-HSK	2	181769 o	181778 o
90	150	Weinig-HSK	2	181770 o	181779 o
90	170	Weinig-HSK	2	181771 o	181780 o
90	190	Weinig-HSK	2	182313 o	181781 o
90	210	Weinig-HSK	2	181773 o	181782 o
90	240	Weinig-HSK	2	181774 o	181783 o
90	80	Weinig-HSK	4	181785 o	181794 o
90	100	Weinig-HSK	4	181786 o	181795 o
90	130	Weinig-HSK	4	181787 o	181796 o
90	150	Weinig-HSK	4	181788 o	181797 o
90	170	Weinig-HSK	4	181789 o	181798 o
90	190	Weinig-HSK	4	181790 o	181799 o
90	210	Weinig-HSK	4	181791 o	181800 o
90	40	Weinig-HSK	4	182315 o	182316 o
90	60	Weinig-HSK	4	181784 o	182317 o
90	240	Weinig-HSK	4	181792 o	182318 o
[mm]	[mm]	[mm]			

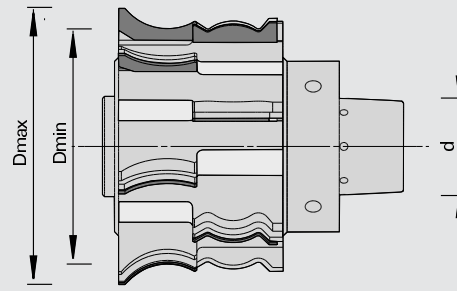
222068

PowerDiaProfiler DP

Product



Drawing



LEUCO
power
DIAProfiler

Polycrystalline diamond [DP]

MEC

Machine / Application

- | molding automats with HSK-interface
- | for profiling of MDF, hard and exotic woods

Design

- | topline (polished knife face and precise cutting edge)

Advantages

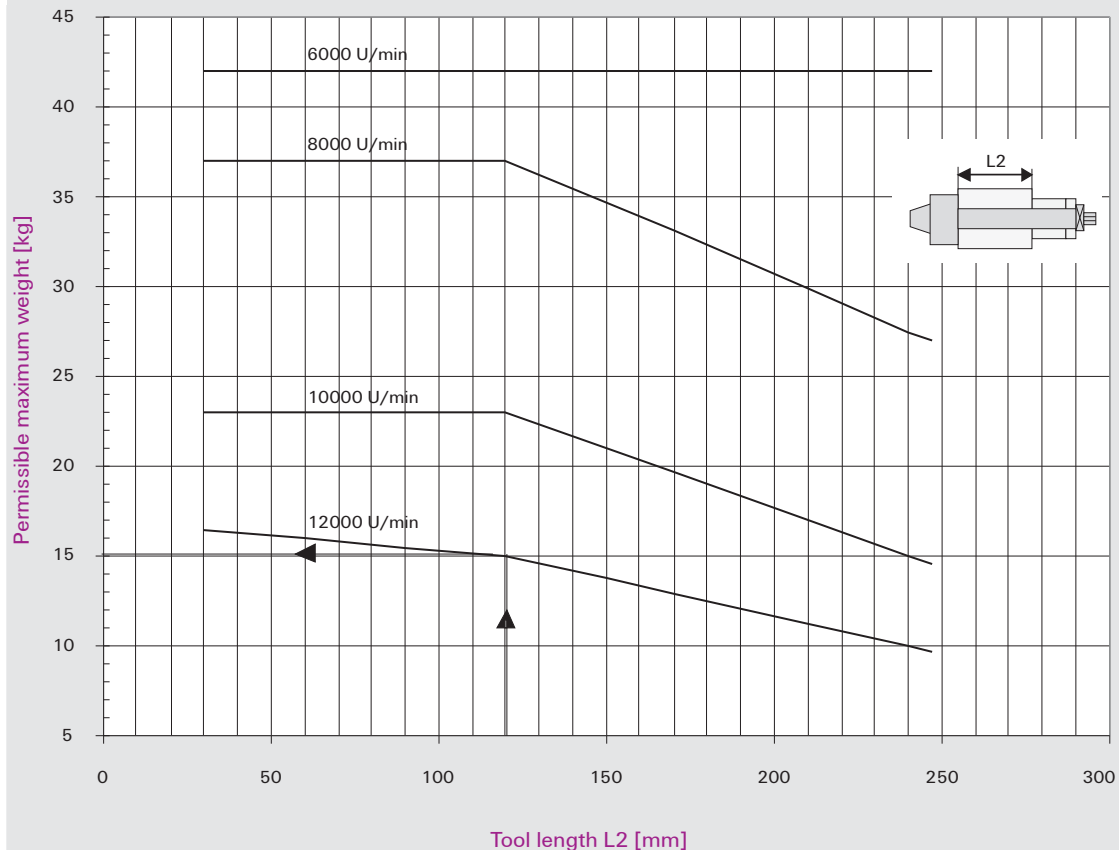
- | highest concentricity
- | feed speed and workpiece surface like in the case of jointed HW-tools

Notes

- | optimal cutting speed 80 - 100m/s
- | profiles according to customer specifications
- | price on request
- | n max = depending on L2 and weight (see chart)

Ø Dmax	Ø Dmin	Ø d	Z	Recommended feed
180	100	Weinig HSK	2	33
180	100	Weinig HSK	3	50
180	100	Weinig HSK	4	66
180	100	Weinig HSK	5	83
180	100	Weinig HSK	6	100
180	100	Weinig HSK	7	117
180	100	Weinig HSK	8	133
[mm]	[mm]	[mm]		[m/min]

Diagram for PowerLock-Adapter



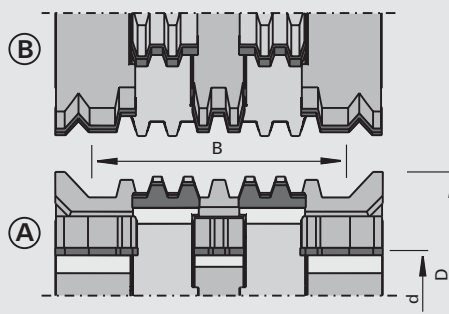
123600

HW Counter Profile Cutter set

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l molders
- l For manufacturing of longitudinal joints on block piles

Design

- l Body made from steel
- l Symmetrical design
- l Double keyway for twist locking

Advantages

- l Maximum possible precision thanks to plane parallelism of all parts

Notes

Ø D	B	Ø d	Z	nmax	Profile	Ident-No.
190	220	80	5x4	8000	A	192657 s
190	220	80	5x4	8000	B	192658 s
[mm]	[mm]	[mm]		[min-1]		

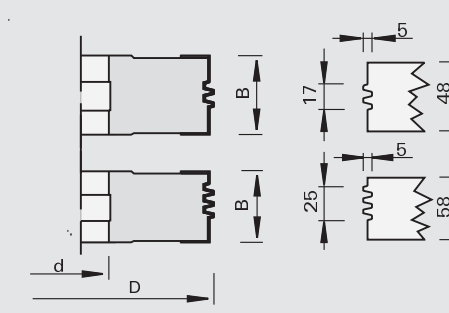
120505

Glue Joint Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- l molders
- l table shapers
- l for cutting of edge glue joints in solid woods

Design

- l cutting edges parallel to cutter axis
- l n = 5,700 - 9,800 min-1

Advantages

- l continuous high profile accuracy thanks to turnover knives

Notes

- l application against feed
- l fit of joints can be defined by moving the knives sideways by means of dials (see spare parts)
- l when delivered, tool is set to 0.3 mm joint play

Ø D	B	Ø d	Ø dmax	Z	H	Ident-No.
135	50	30	50	2	17-48	177007
135	60	30	50	2	25-58	177008 s
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	23	2.0	151555	10	180431
	60	23	2.0	151555	10	180432
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	177007	925300	2	50591365
Pressure Bars	58x11x6	177008	925300	2	180434
Clamping Pieces	12x8,5/M8L	For all	925100	2	180357
Clamping Set Screws	M8x26 SW4	For all	995161	10	180340
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

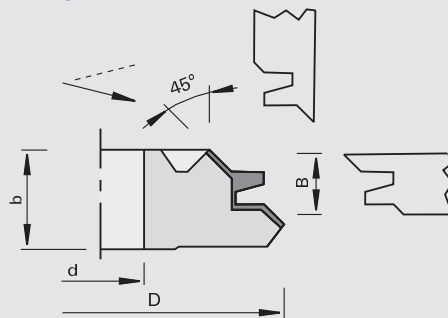
Spare parts	Dimension	Class-No.	PU	Ident-No.
Setting Discs	0,1 + 0,15	995490	1	180435
Setting Discs	0,15 + 0,2	995490	1	180436
Setting Discs	0,2 + 0,25	995490	1	180437
Setting Discs	0,25 + 0,3	995490	1	180438
Setting Discs	0,3 + 0,35	995490	1	180439
	[mm]		[pc.]	

120525 Miter Glue Joint Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | molders
- | table shapers
- | for cutting of miter lock joints in solid woods and wood-based panels

Design

- | body made from high-strength aluminium alloy
- | cutting edges parallel to cutter axis
- | n = 4,600 - 7,800 min-1

Advantages

- | continuous high profile accuracy thanks to profile knives
- | profile play adjustable by means of shims underneath the grooving/chamfering knives

Notes

- | application against feed wood thickness approx. 15 mm to max. 26 mm

Ø D	B	Ø d	Z	Ident-No.
174	26	30	2+2	176097
[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Grooving / Chamfering Knife	16	34	5.0	150508	5	184275
Miter Glue Joint Profile Knives	39,5	12	1.5	151547	10	165916
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	38x11x6	925300	2	180538
Clamping Pieces	12x8,5/M8L	925100	2	180357
Clamping Set Screws	M8x26 SW4	995161	10	180340
Countersunk Screws	M5x10,8 T15	995125	10	180840
Screwdrivers	SW4x100	985730	1	166091
Screwdrivers	T15x100	985730	1	180470
	[mm]		[pc.]	

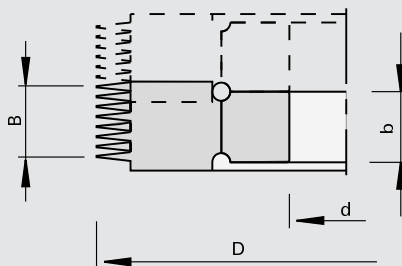
327110 / 327140 / 327130

Finger Joint Cutters HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | finger joint machines
- | machines with and without cross-cutting device
- | for longitudinal joints in soft woods

Design

- | standard, for PUR glueing and topcoat

Advantages

- | strong flank surface pressure for PUR glues (fiber-free)
- | increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

- | for machines with cross-cutting device, finger length 4/4,5, 10/11, 15/16,5, 20/22
- | for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	175740 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	175741
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	178966
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	181008 s
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	182122 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	175742
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	175743
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	182668 s
180	33	31	50	2+2	6.2	20/20	5	8000	175744
180	33	31	50	2+2	6.2	20/22	5	8000	175745 s
250	26	24	50	3+3	1.6	4/4,5	16	6000	182113 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	175746 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	175747
250	30	28	50	6+6	2.8	6/7	10	6000	192467 s
255	30	28	50	6+6	2.8	6/7	10	6000	192468 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	175748 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	175749
260	33	31	50	3+3	6.2	20/22	5	6000	175751
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	for PUR glueing 189715 s
180	33	31	50	2+2	6.2	20/20	5	8000	for PUR glueing 192262 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	for PUR glueing 189716 s
260	33	31	50	3+3	6.2	20/20	5	6000	for PUR glueing 192263 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	topcoat 192190 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	topcoat 192127 s
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	topcoat 192199 s
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	topcoat 192200 s
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	topcoat 192202 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	topcoat 192191 s
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	topcoat 192192
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	topcoat 192203 s
180	33	31	50	2+2	6.2	20/20	5	8000	topcoat 192193 s
180	33	31	50	2+2	6.2	20/22	5	8000	topcoat 192194 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	26	24	50	3+3	1.6	4/4,5	16	6000	topcoat	192201 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	topcoat	192195 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	topcoat	192126 s
250	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192466 s
255	30	28	50	6+6	2.8	6/7	10	6000	topcoat	192469 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	topcoat	192196 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	topcoat	192197 s
260	33	31	50	3+3	6.2	20/22	5	6000	topcoat	192198 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

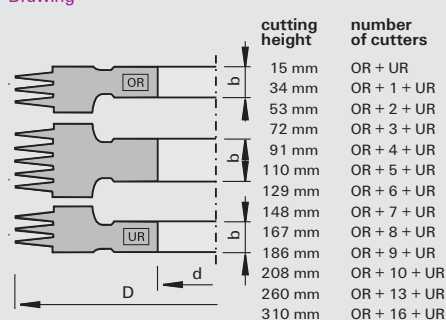
327610 / 327640 / 327630

Finger Joint Cutters HS - real Z=4 resp. Z=6

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

- real Z=4 or Z=6 for high feed rates
- standard, for PUR glueing and topcoat

Advantages

- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design
- longer edge life, higher wear resistance and gliding features thanks to topcoat coating

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter	182675 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter	182676 #
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter	182677 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter	182678 #
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter	182679 #
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter	182680 #
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter	189930
250	41	19	50	6	3.8	10/11	5	6000	base cutter	182682
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter	189931
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter for PUR glueing	192264 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter for PUR glueing	192265 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter for PUR glueing	192266 s
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter for PUR glueing	192267 s
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter for PUR glueing	192268 s
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter for PUR glueing	192269 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter/topcoat	192204 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter/topcoat	192205 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter/topcoat	192206 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	top finish cutter/topcoat	192207 s
170	41	19	50	4	3,8	15/16,5	5	8000	base cutter/topcoat	192208 s
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	bottom finish cutter/topcoat	192209 s
250	26,4	15,4	50	6	3,8	10/11	3	6000	top finish cutter/topcoat	192210 s
250	41	19	50	6	3,8	10/11	5	6000	base cutter/topcoat	192211 s
250	26,4	15,4	50	6	3,8	10/11	3	6000	bottom finish cutter/topcoat	192212 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

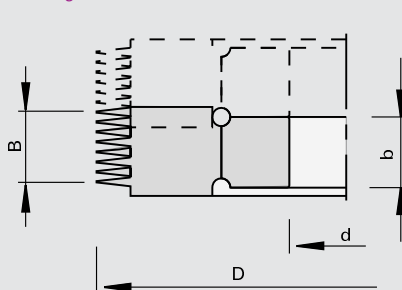
527110

Finger Joint Cutters HS - Solid 34

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- l finger joint machines
- l machines with and without cross-cutting device
- l for longitudinal joints in knotty soft woods

Design

- l cutting edge: HS Solid 34

Advantages

- l compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- l high bending strength
- l reduced risk of tooth breaking

Notes

- l for machines with cross-cutting device, finger length 10/11, 15/16,5, 20/22
- l for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26,6	50	2+2	3,8	10/10	7	8000		183231 s
160	28,6	26,6	50	2+2	3,8	10/11	7	8000		183232 s
160	32,4	30,4	50	2+2	3,8	10/11	8	8000		183233 s
160	28,6	26,6	50	3+3	3,8	10/11	7	8000		183234 s
170	28,6	26,6	50	2+2	3,8	15/16,5	7	8000		183235 s
170	28,6	26,6	50	2+2	3,8	15/15	7	8000		183230
170	28,6	26,6	50	3+3	3,8	15/16,5	7	8000		183236 s
180	33	31	50	2+2	6,2	20/20	5	8000		183237 s
180	33	31	50	2+2	6,2	20/22	5	8000		183238 s
250	28,6	31	50	3+3	3,8	10/10	7	6000		183239 s
250	28,6	26,6	50	3+3	3,8	10/11	7	6000		183228
260	28,6	26,6	50	3+3	3,8	15/15	7	6000		183240 s
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000		183229 #
260	33	31	50	3+3	6,2	20/22	5	6000		183241 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

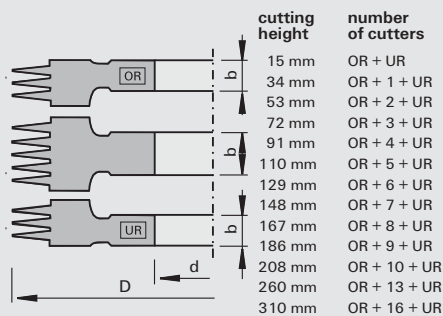
527610

Finger Joint Cutters HS - Solid 34 - real Z=4 or Z=6

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

- cutting edge: HS Solid 34
- real Z=4 or Z=6 for high feed rates

Advantages

- compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- high bending strength
- reduced risk of tooth breaking
- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter	183242 s
170	41	19	50	4	3.8	15/15	5	8000	base cutter	183243 s
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter	183244 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter	183247 s
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter	183245 s
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter	183246 s
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter	192270
250	41	19	50	6	3.8	10/11	5	6000	base cutter	183249
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter	192271
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

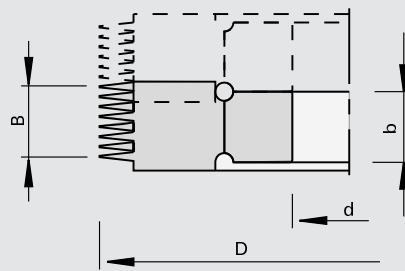
127110

Finger Joint Cutters HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | finger joint machines
- | machines with cross-cutting device
- | for longitudinal joints in hard and exotic woods

Design

Advantages

Notes

- | for machines with cross-cutting device, finger length 10/11, 15/16,5
- | for machines without cross-cutting device, finger length 10/10, 15/15

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26,6	50	2+2	3,8	10/10	7	8000	175732 s
160	28,6	26,6	50	2+2	3,8	10/11	7	8000	175733
170	28,6	26,6	50	2+2	3,8	15/15	7	8000	175734 s
170	28,6	26,6	50	2+2	3,8	15/16,5	7	8000	175735 s
250	28,6	26,6	50	3+3	3,8	10/10	7	6000	175736 s
250	28,6	26,6	50	3+3	3,8	10/11	7	6000	175737
260	28,6	26,6	50	3+3	3,8	15/15	7	6000	175738 s
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000	175739 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

396961

Finger Joint Cutterheads - with exchangeable HS cutting edges

Product



Drawing



LEUCO
TOP
COAT

High Speed Steel [HS]

MEC

Machine / Application

| finger joint machines
| for longitudinal joints in highly stressed components

Design

| tool body made from steel
| 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates
| secured against twisting
| cutting material: HS-topcoat

Advantages

| multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

| included in delivery: tool body without knife inserts

Ø D	Ø D1	B	b	Ø d	Z	nmax	Ident-No.
129.8	160/170	30,4	30.4	50	2+2	8500	192180 s
129.8	160/170	30,4	30.4	50	3+3	8500	192181 s
216	250/260	30,4	30.4	50	2+2	6000	192182 s
216	250/260	30,4	30.4	50	3+3	6000	192183 s
216	250/260	30,4	30.4	50	4+4	6000	192188 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Overview

wood width in mm	Number of cutters	wood width in mm	Number of cutters
27	1	179	6
58	2	210	7
88	3	240	8
118	4	271	9
149	5	297	10

Knives

	Class-No.	PU	Ident-No.
HS insert topcoat 10/10	332924	4	192184 s
HS insert topcoat 10/11	332924	4	192185 s
HS insert topcoat 15/15	332924	4	192186 s
HS insert topcoat 15/16.5	332924	4	192187
		[pc.]	

Spare parts

	Dimension	Class-No.	PU	Ident-No.
Set Screws	M8x20 DIN EN ISO 4028	995161	10	001625
	[mm]		[pc.]	

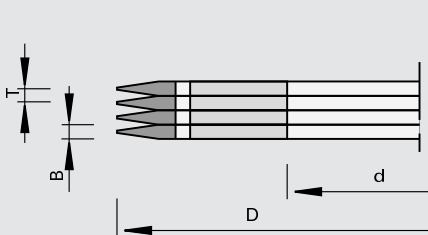
127210

Finger Joint Cutters disc-type HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- | machines with cross-cutting device
- | for longitudinal joints in soft and hard woods

Design

- | high-tensile steel body
- | topline grinding
- | Ø 160 mm: n max = 11,800 min-1
- | Ø 250 mm: n max = 7,400 min-1
- | Ø 260 mm: n max = 7,200 min-1

Advantages

- | extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges

Notes

- | adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length		Ident-No.
160	3,8	70	2	3.8	10/11	Soft wood	177561 s
160	3,8	70	2	3.8	10/11	hard woods/exotic woods	177562 s
160	3,8	70	4	3.8	10/11	Soft wood	177563
160	3,8	70	4	3.8	10/11	hard woods/exotic woods	177564
250	3,8	70	6	3.8	10/11	hard woods/exotic woods	180938
250	3,8	70	6	3.8	10/11	Soft wood	180939
260	3,8	70	6	3.8	15/16	Soft wood	178253 s
[mm]	[mm]	[mm]		[mm]	[mm]		

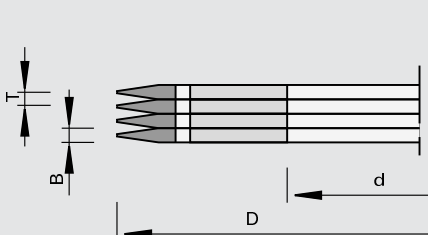
127230

Finger Joint Cutters disc-type HW - coated

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- | machines with cross-cutting device
- | for longitudinal joints in soft and hard woods

Design

- | high-tensile steel body
- | HW topcoat coating
- | Ø 160 mm: n max = 11,800 min-1
- | Ø 250 mm: n max = 7,400 min-1

Advantages

- | extremely long edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- | compared to traditional HW finger joint cutters the edge live is 2 - 3 times as long

Notes

- | adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length		Ident-No.
160	3,8	70	4	3.8	10/11		181230 s
250	3,8	70	6	3.8	10/11		181233 #
[mm]	[mm]	[mm]		[mm]	[mm]		

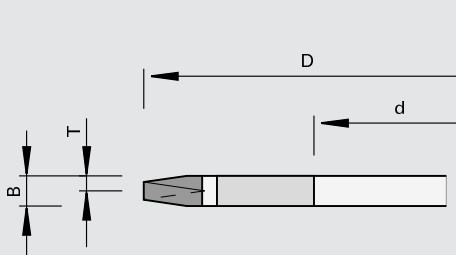
127310

Disc-type Edge Finger Joint Cutters HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | finger joint machines
- | for cutting of closed visible longitudinal joints in hard and soft woods

Design

- | high-tensile steel body
- | Ø 149 mm: n max = 12,700 min-1
- | Ø 160 mm: n max = 11,800 min-1
- | Ø 239 mm: n max = 7,900 min-1
- | Ø 250 mm: n max = 7,400 min-1

Advantages

Notes

- | in combination with finger joint cutters with same Ø and pitch
- | Ø 149 mm and Ø 239 mm (half shoulder) only with scoring saw blade

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
149	3,8	70	4	3.8	5	180916 s
160	11,4	70	4	3.8	10	177574
239	3,8	70	6	3.8	10	180917 s
239	11,4	70	6	3.8	10	181245
250	11,4	70	6	3.8	10	177576
[mm]	[mm]	[mm]		[mm]	[mm]	

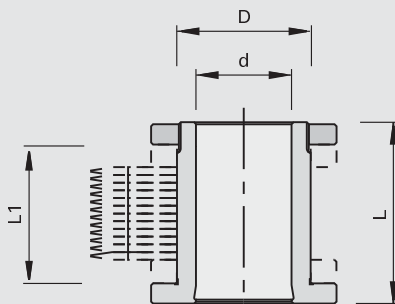
997300

Bushings for Finger Joint Cutters

Product



Drawing



Machine / Application

for clamping of finger joint cutters and edge finger joint cutters

Design

high-tensile steel body
spacers \varnothing 97 mm for cutters \varnothing 160-210 mm (not required)

Advantages

high concentric and runout accuracy
for varying wood thicknesses

Notes

- fill intermediate sizes with spacers
- for cutter \varnothing 250 mm install at least one spacer \varnothing 177 on top and bottom
- fastening nut or hydraulic clamping for cutter attachment must be ordered separately
- for cutter sets over 100 mm height we recommend hydraulic clamping
- the bushing length depends on the wood height "H" and on the type of nut
- accessories: mounting device, mounting ring and wrench is imperative for self-resharpening

\varnothing D	\varnothing d	L	L1	Ident-No.
70	50	90	57	178188
70	50	120	87	181035
70	50	130	97	178171
70	50	195	162	178172
70	50	220	187	178173
70	50	240	207	178174
[mm]	[mm]	[mm]	[mm]	

Spacer Rings	\varnothing D	B	\varnothing d	Class-No.	PU	Ident-No.
	100	7,6	70	955520	1	180940
	100	11,4	70	955520	1	180941
	175	7,6	70	955520	1	186163 s
	175	11,4	70	955520	1	181034
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Mounting Devices		997300	1	177103
Mounting Rings	96x70x60	955520	1	177546
Pin-type face wrenches		985720	1	177102
Fastening Nut	M68x1,5x14	995290	1	177104
Hydraulic Clumping Nuts	M68x1,5x56	933090	1	178787 s
Screwdrivers	SW4x100	985730	1	166091
	[mm]		[pc.]	

Finger Joint Cutters - Calculation of cutting width

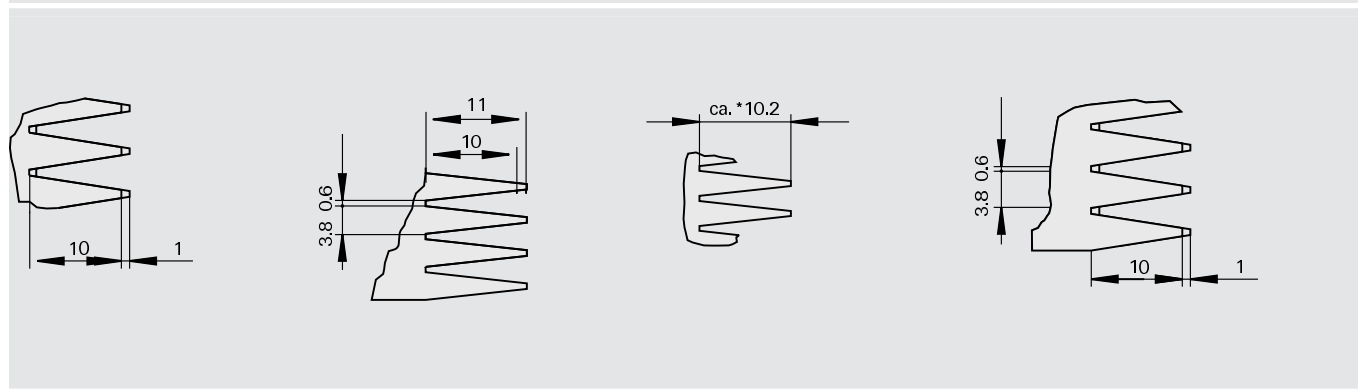
Combination of the cutter sets depending on the wood thickness

Finger length [mm]	Wood thickness [mm]	Number of cutters	Finger length [mm]	Wood thickness [mm]	Number of cutters
10+15	24	1	20	28	1
10+15	51	2	20	59	2
10+15	77	3	20	90	3
10+15	104	4	20	121	4
10+15	131	5	20	152	5
10+15	157	6	20	183	6
10+15	184	7	20	214	7
10+15	210	8	20	245	8
10+15	237	9	20	276	9
10+15	264	10	20	307	10

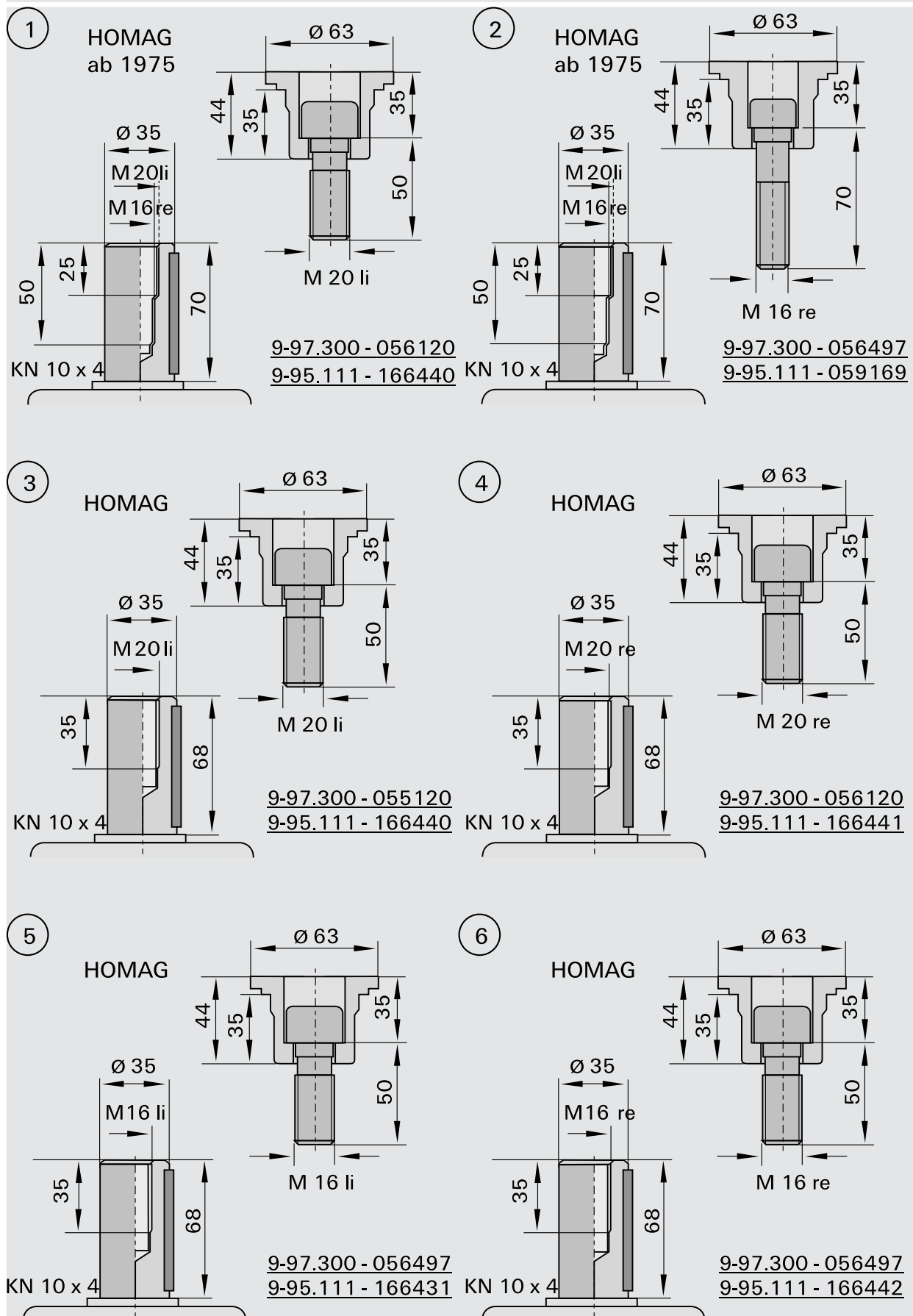
Finger joint cutters - cross cutting with extended finger joint profile

Finger length [mm]	For machines with sizing device	For machines without sizing device	Finger length [mm]
10/10		X	No
10/11	X		10-11
15/15		X	No
15/16,5	X		15-16,5
20/20		X	No
20/22	X		20-22

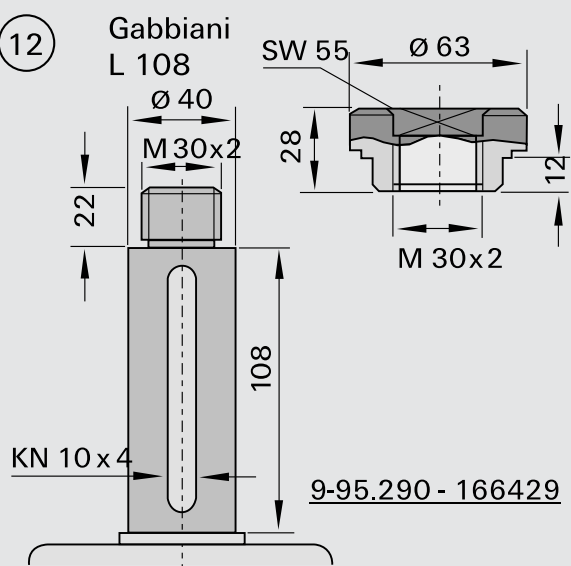
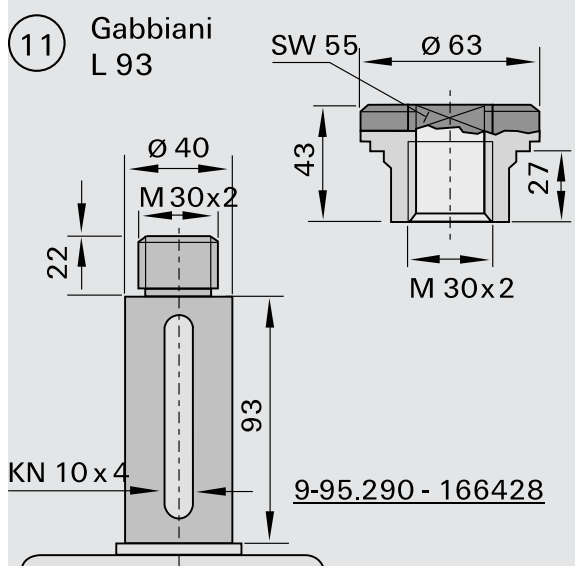
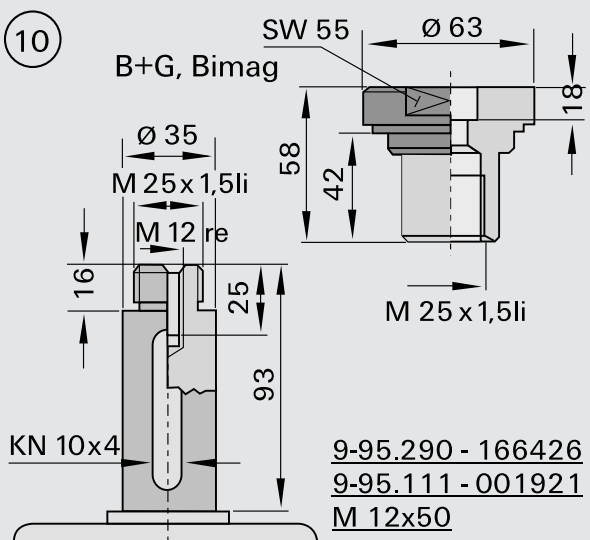
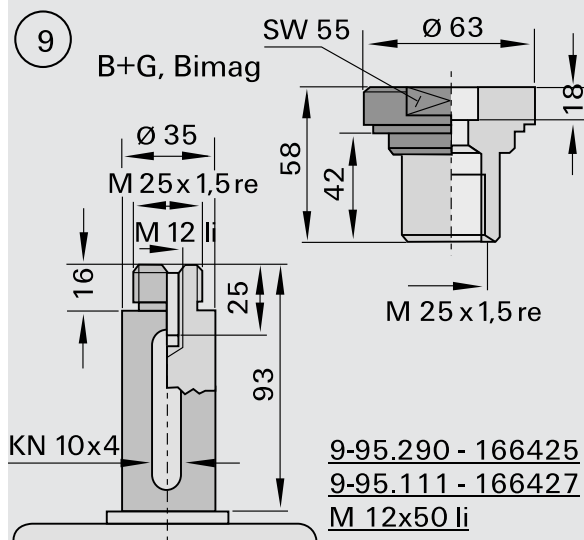
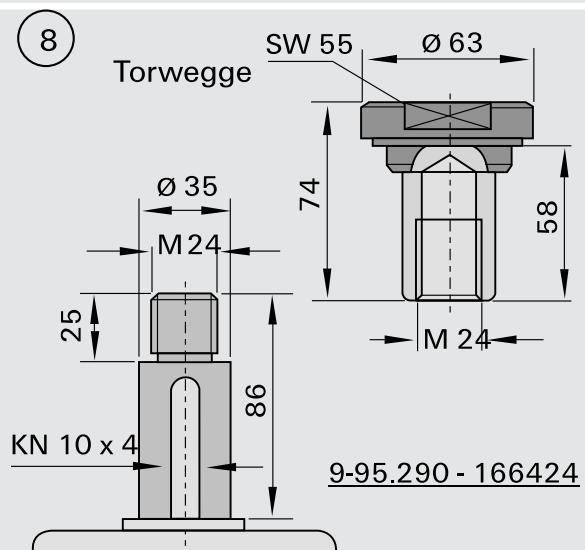
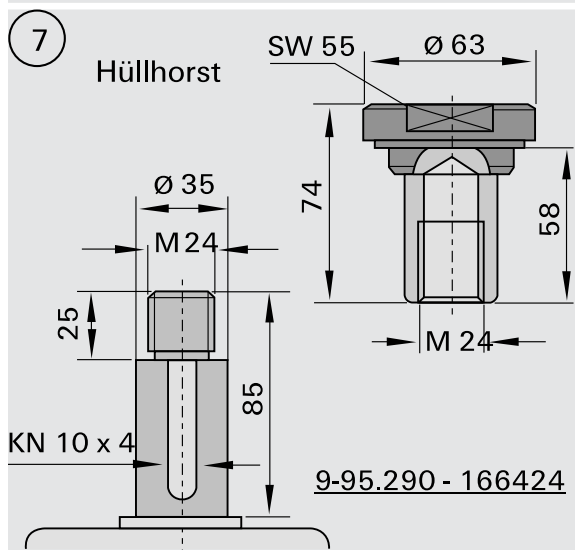
Drawing profile example



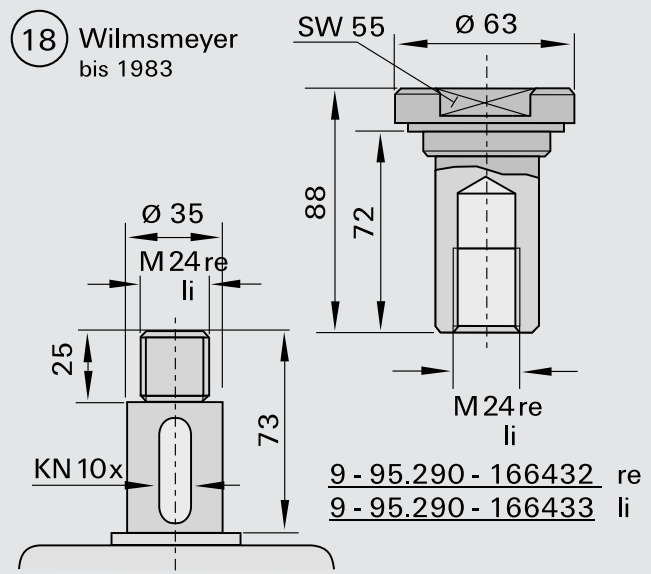
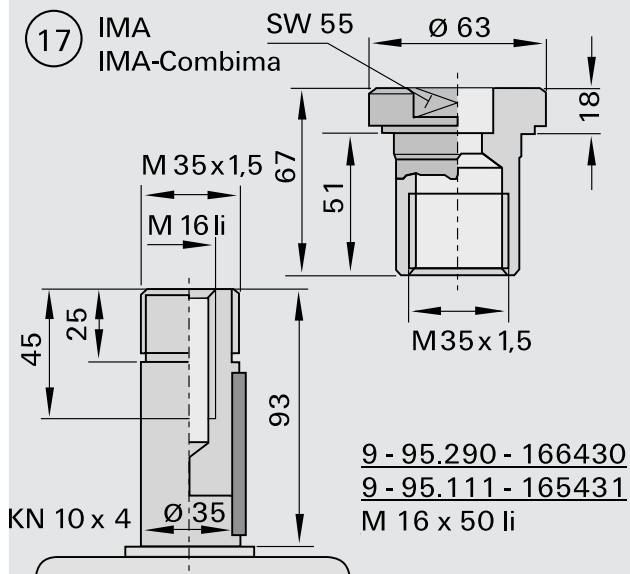
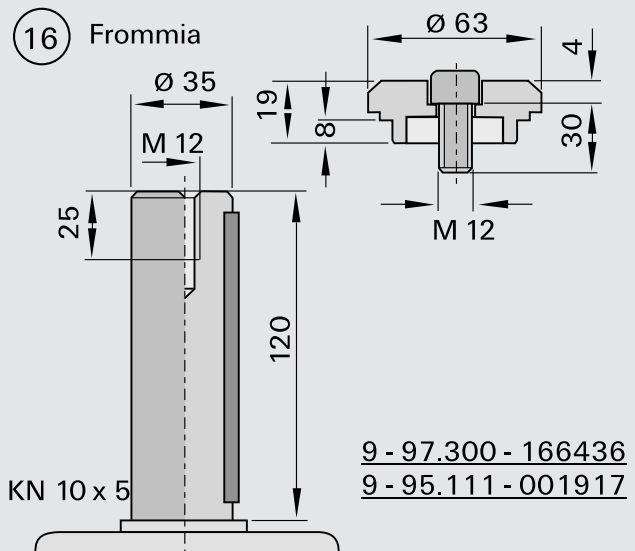
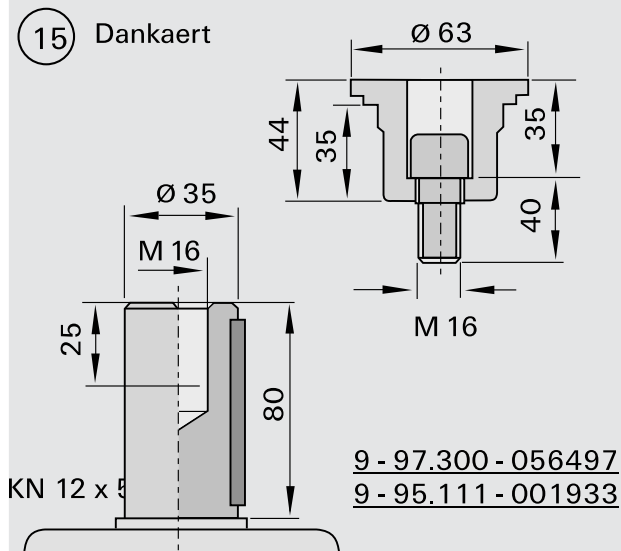
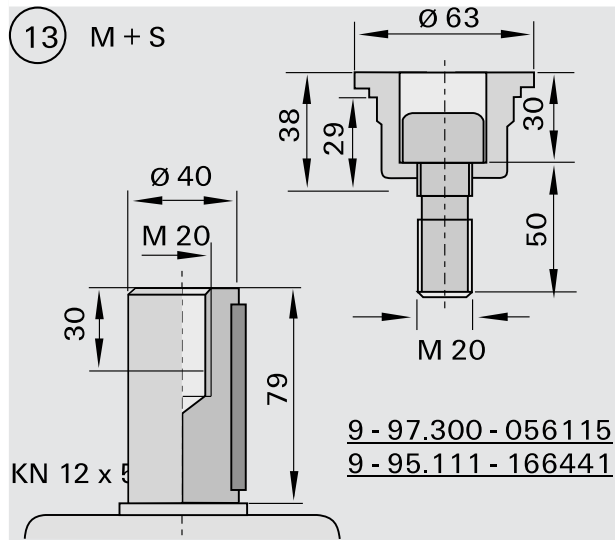
Fasteners for Jointing Cutterheads



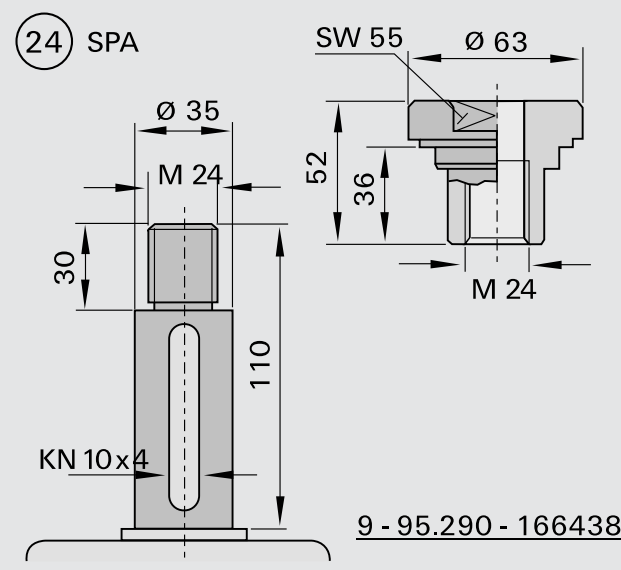
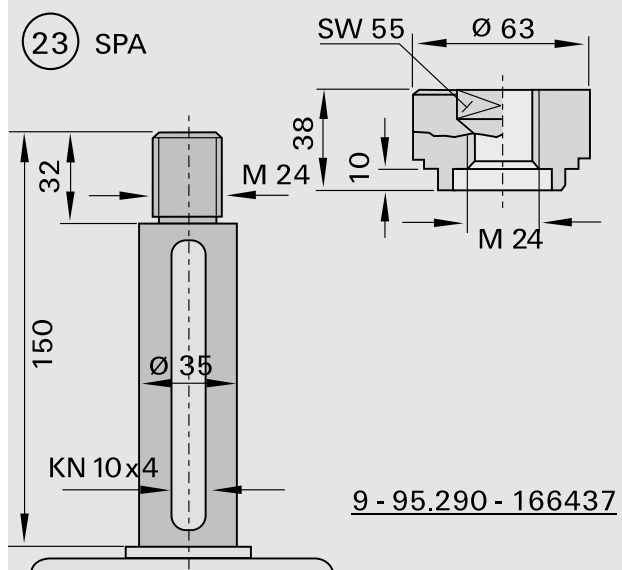
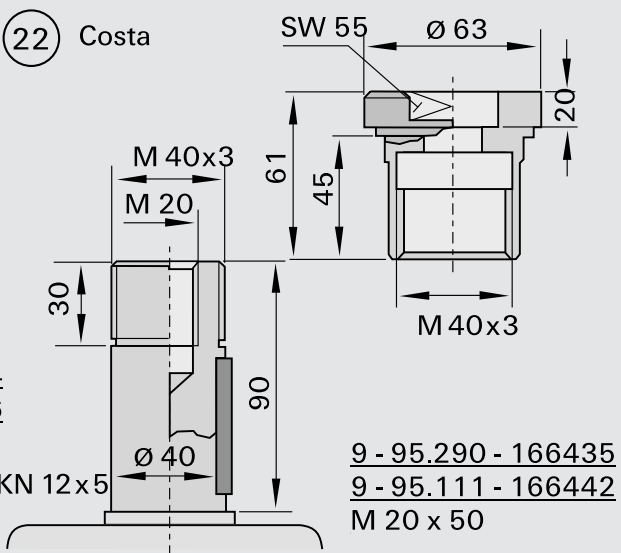
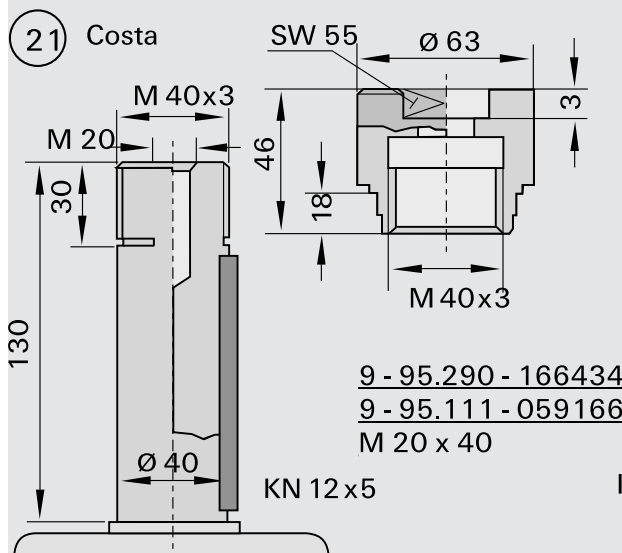
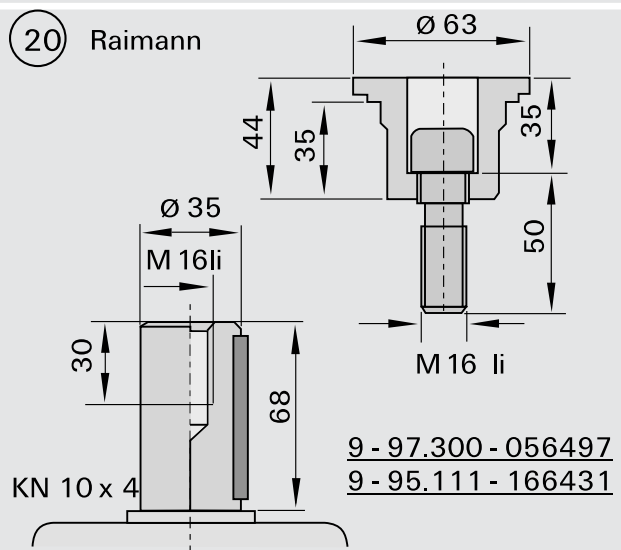
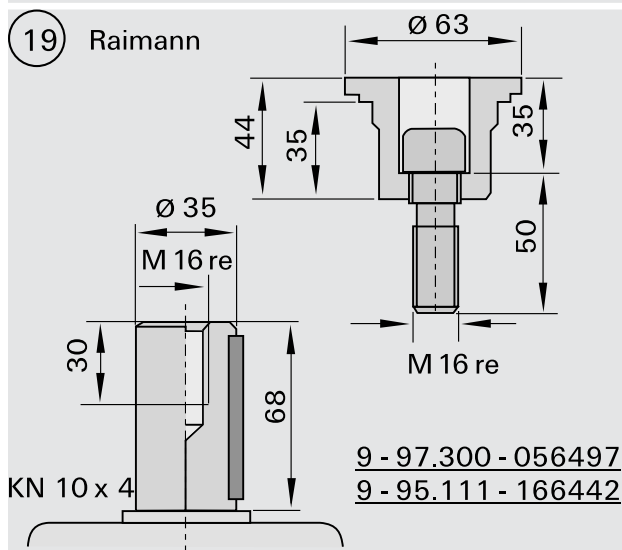
Fasteners for Jointing Cutterheads



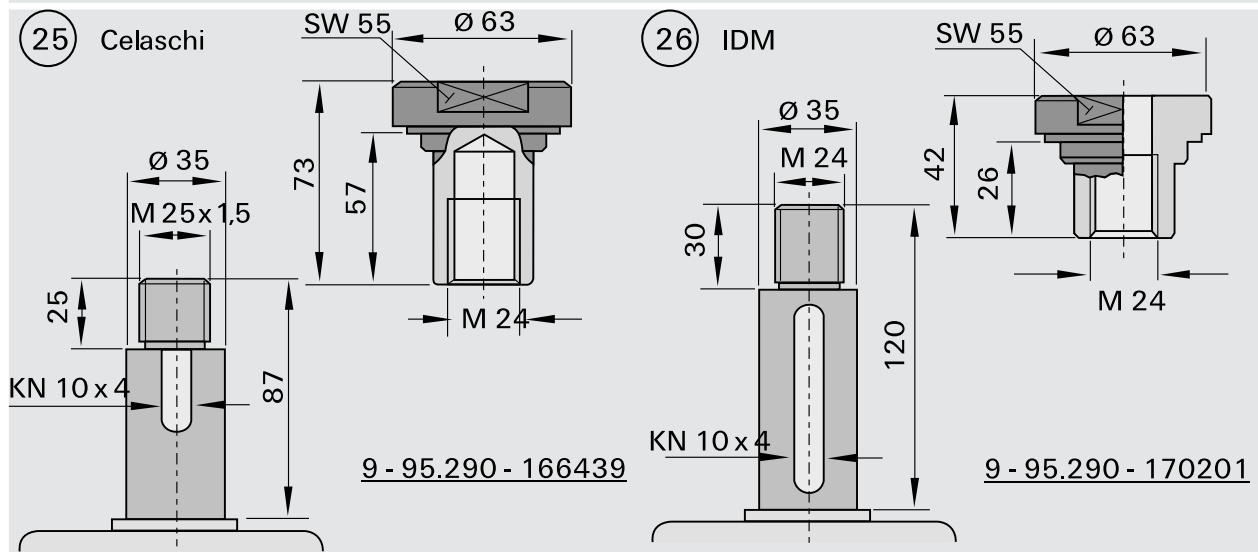
Fasteners for Jointing Cutterheads



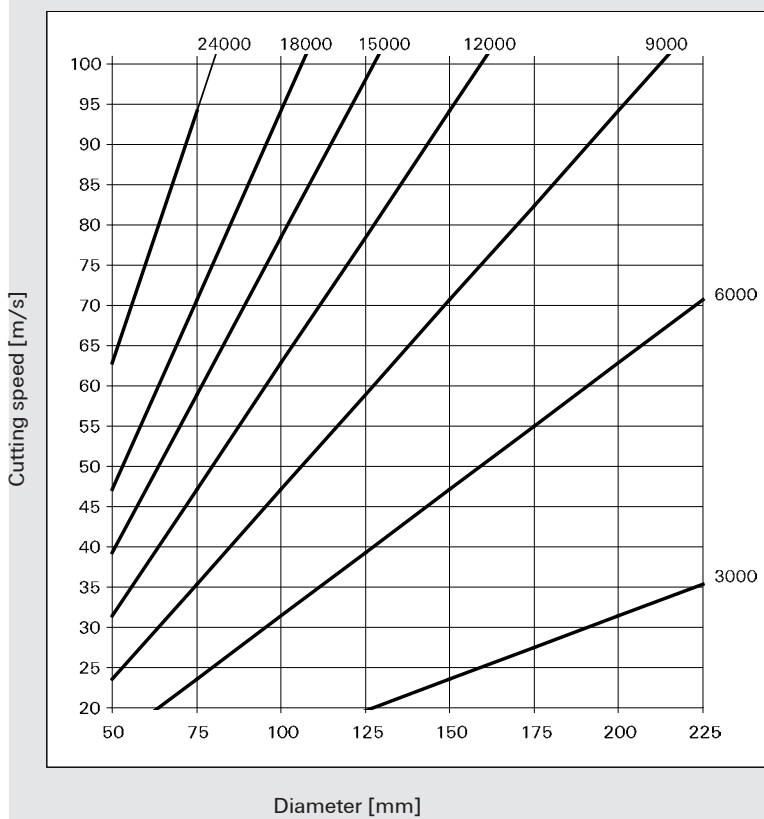
Fasteners for Jointing Cutterheads



Fasteners for Jointing Cutterheads



Determination of RPM [min-1]



Feed rate per tooth

Milling

Workpiece material	Feed rate per tooth fz [mm]
Solid woods with the grain	0,60 - 0,80
Solid woods across the grain	0,30 - 0,40
Laminated woods	0,40 - 0,50
Raw panels	0,50 - 0,70
Laminated panels	0,20 - 0,40
Veneered panels	0,10 - 0,15

Planing

Cutting quality	Effective feed rate per tooth fz eff [mm]	Formulas for calculation
Fine	1,3 - 1,7	Feed rate vf [m/min]
Medium	1,7 - 2,5	Rotations per minute (RPM) [min-1]
Coarse	2,5 - 5,0	Number of teeth z
		Effective feed rate per tooth (tooth/knife progression) fz eff [mm]
		Tools with conventional clamping
		$fz\ eff = (vf \times 1000) / (n \times 1)$
		Tools with Hydro clamping
		$fz\ eff = (vf \times 1000) / (n \times z)$

Order / Inquiry for Special Tools: Cutters with Bore

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	<input type="radio"/>
Company:	_____	Inquiry:	<input type="radio"/>
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Maker: _____

Model: _____

Type (e.g. DET, etc.): _____

RPM range [min-1] _____

Feed rate [m/min]: _____

Type of feed:	MAN	<input type="radio"/>	MEC	<input type="radio"/>
Sense of rotation:	Left	<input type="radio"/>	Right	<input type="radio"/>
Mode of application:	Against feed	<input type="radio"/>	With feed	<input type="radio"/>
No. of teeth [pcs.]:	_____			
Rakers:	_____			
Spur:	_____			
Grooving knives:	_____			
Edge breaker:	_____			
Arrangement of cutting edges:	_____			
Shear angle:	Single-sided	<input type="radio"/>		
	Alternate	<input type="radio"/>		

Workpiece

Description: _____

Cutting quality: _____

Direction of cut:

Solid wood	With grain	<input type="radio"/>
	Across grain	<input type="radio"/>
	On end	<input type="radio"/>
Wood-based materials	Top layer	<input type="radio"/>
	Middle layer	<input type="radio"/>
	Top and middle layer	<input type="radio"/>

Interface

Bore d [mm]: _____

Double keyway:	Height	Width
	_____	_____

Keyway:	Height	Width
	_____	_____

Coating

Yes	<input type="radio"/>	No	<input type="radio"/>
-----	-----------------------	----	-----------------------

Description: _____

Further Information _____

Tool

Single tool

Tool set:

With tipped cutting edges:	<input type="radio"/>
With exchangeable cutting edges:	
EcoPro Cutterhead	<input type="radio"/>
SuperProfiler	<input type="radio"/>
UltraProfiler	<input type="radio"/>
Standard	<input type="radio"/>

Cutting diameter D [mm]: _____

basic diameter D1 [mm]: _____

Cutting width B [mm]: _____

Depth of cut [mm]: _____

Clamping Bushing [Ø]: _____

Hydro Bushing [Ø]: _____

Hydro s-System: _____

s-System [Ø]: _____

Other: _____

check if applicable

Please indicate the following on workpiece samples or drawings:

Bottom side of workpiece	Dimensions
Sense of rotation	Application conditions
Motor spindle	Profile drawing
Hydro Bushing [Ø]:	Tool drawing

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.

Checklist for molders (incl. "Weinig Powermat" series)

Pos. 5

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 7

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 9

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 10

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 11

Spindle diameter (mm): _____

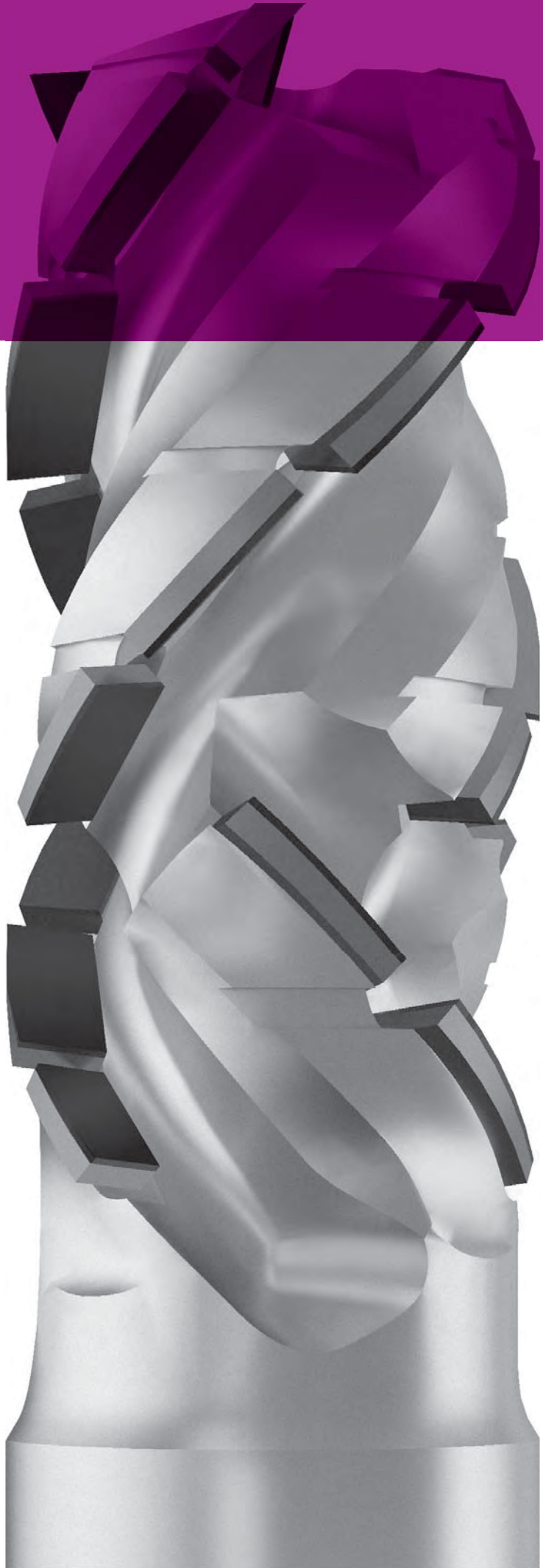
HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____



Shank-Type Cutters

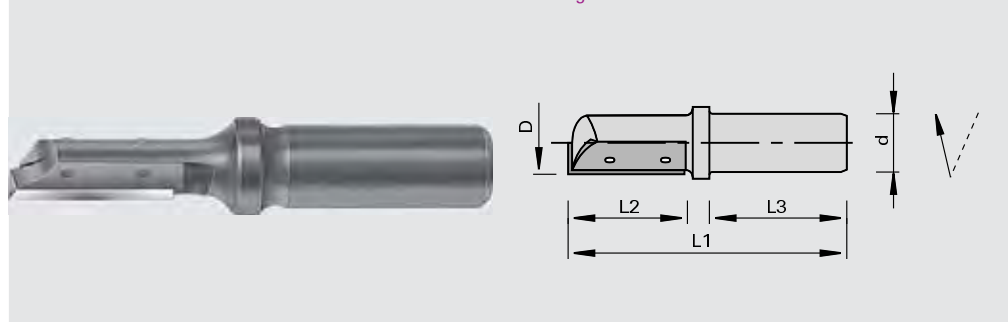
Product	Page
Straight Shank-Type Tools for stationary routers	4-1
Profiled Shank-Type Tools for stationary routers	4-52
Straight Shank-Type Tools for portable routers	4-80
Profiled Shank-Type Tools for portable routers	4-88
Modula	4-94
Technical Information	4-135

128415

Shank-Type Cutters with HW Turnover Knives - Z=1, MAN

Product

Drawing



LEUCO
GNC

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	20	12	40	70	1	R 175669
10	25	10	40	75	1	R 175678
10	25	12	40	75	1	R 175670
10	25	16	45	80	1	R 180797
12	30	12	40	80	1	R 175664
12	30	12	40	80	1	L 175665 o
14	30	12	40	80	1	R 175666
14	30	12	40	80	1	L 175667 o
16	50	12	40	100	1	R 175668
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480
for Ø D = 10	25	5.5	1.1	150535	10	173793
for Ø D = 12+14	30	5.5	1.1	150535	10	173482
for Ø D = 16	50	5.5	1.1	150535	10	173483
	[mm]	[mm]	[mm]		[pc.]	

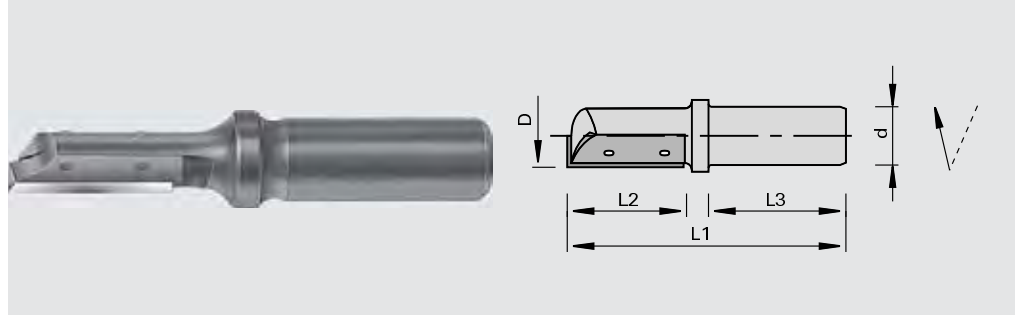
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	175669	925500	2	175722 o
Clamping Wedges	B=25	175670, 175678, 180797	925500	2	175724 o
Clamping Wedges	B=30	175664	925500	2	175726 o
Clamping Wedges	B=30	175665	925500	2	175730 o
Clamping Wedges	B=30	175666	925500	2	175728 o
Clamping Wedges	B=30	175667	925500	2	175731 o
Clamping Wedges	B=50	175668	925500	2	175729 o
Head Cap Screws	M2,5x3 T8	175669	995115	10	168237
Head Cap Screws	M2,5x4 T8	175670, 175678, 180797	995115	10	168238
Head Cap Screws	M3x5,5 T8	175664, 175665, 175666, 175667	995115	10	168239
Head Cap Screws	M3,5x5,5 T15	175668	995115	10	168236
Screwdriver with flag	T8	175664, 175665, 175666, 175667, 175669, 175670, 175678, 180797	985730	1	166499
Screwdrivers	T15	175668	985730	1	163161
	[mm]			[pc.]	

128415

Shank-Type Cutters with HW Turnover Knives - Z=1 with high breaking strength, MAN

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | tool body made of heavy metal
- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05

Advantages

- | high breaking strength

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	20	12	40	80	1	180816
10	25	12	40	80	1	180817
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480
for Ø D = 10	25	5.5	1.1	150535	10	173793
	[mm]	[mm]	[mm]		[pc.]	

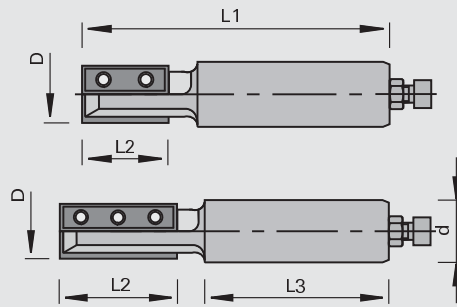
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	180816	925500	2	175722 o
Clamping Wedges	B=25	180817	925500	2	175724 o
Head Cap Screws	M2,5x3 T8	180816	995115	10	168237
Head Cap Screws	M2,5x4 T8	180817	995115	10	168238
Screwdriver with flag	T8	For all	985730	1	166499
	[mm]			[pc.]	

128410

Shank-Type Cutters with HW Turnover Knives - Z=2 with mini turnover knives

Product

Drawing



LEUCODUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to cutter axis; peripheral cutting and face cutting
- | cutting material: HW HL Board 05
- | cutting material: HW HL Board 03 for abrasive materials, e.g. laminated panel boards
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	100	2	180804
16	50	25	55	120	2	180805
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	29,5	9.0	1.5	HL Board 05	150515	10	180821
	29,5	9.0	1.5	HL Board 03	150513	10	180807
	50	9.0	1.5	HL Board 03	150516	10	181982
	[mm]	[mm]	[mm]			[pc.]	

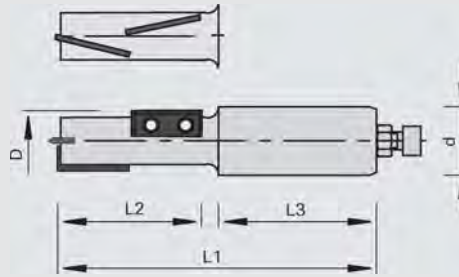
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3,5x4,8 T15	995195	10	180915
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

128260

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with alternating shear angle

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing of chip-free cutting edges in laminated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | with alternating shear angle
- | plunge tip: Ø 16 - Ø 18 HW-tipped; Ø 30 HW turnover knife
- | with attachment screw

Advantages

- | 2 edge lives by exchanging the upper and lower knife

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	110	1+1	R 180443 s
16	50	25	55	130	1+1	R 180444
18	50	25	55	130	1+1	R 180445 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
L2 = 30	16	7.0	1.5	150523	10	180262
L2 = 50	28	7.0	1.5	150523	10	180260
	[mm]	[mm]	[mm]		[pc.]	

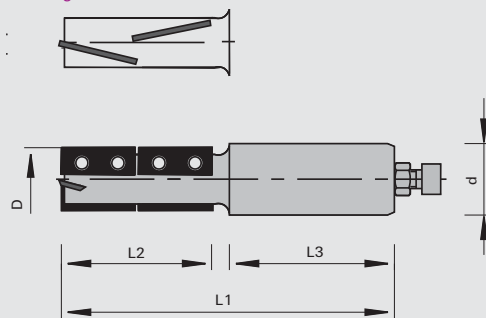
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449
Screwdrivers	T9x60	985730	1	173796
	[mm]		[pc.]	

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
 | for jointing, dividing, grooving and rabbeting in laminated panels and solid woods
 | traveling plunge cut using Z and X or Y axis

Design

| staggered HW knives with with alternating shear angle
 | plunge tip: 4-side HW turnover knife

Advantages

| 4 edge lives by turning the knives and exchanging the upper and lower turnover knife

Notes

| Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	33	25	55	110	2+2	R 184252
20	33	25	55	110	2+2	L 184255 s
20	53	20	55	125	2+2	R 184253
20	53	25	55	125	2+2	R 184254
20	53	25	55	125	2+2	L 184256 o
30	75	25	55	145	2+2	R 180814 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
L2 = 33	17,5	7.0	1.5	150515	10	184257
L2 = 53	29,5	7.0	1.5	150515	10	184258
L2 = 75	39,5	9.0	1.5	150515	10	180815
plunge tip for Ø 20	9,0	9.0	1.5	150515	10	184259
plunge tip for Ø 30	7,5	12	1.5	150515	10	052543
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	for Ø D = 20	995195	10 180449
Screwdrivers	T9x60	for Ø D = 20	985730	1 173796
Head Cap Screws	M3,5x5,5 T15	for Ø D = 30	995115	10 168236
Head Cap Screws	M4x5 T15	for Ø D = 30	995115	10 180819 o
Screwdrivers	T15	for Ø D = 30	985730	1 163161
	[mm]			[pc.]

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2, sense of rotation L+R

Product	Drawing		
			Tungsten Carbide [HW]
			MEC

<p>Machine / Application</p> <ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in solid woods and wood-based panels for cutting of cut-outs and contours traveling plunge cut using Z and X or Y axis 	<p>Design</p> <ul style="list-style-type: none"> cutting edges of RH resp. LH cutting parts with down-shear angle lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle with attachment screw 	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> workpiece secured on clamping blocks Clamping elements: ps-System, TRIBOS, draw-in collet chuck with attachment screw
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Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	28	25	55	130	2+2	180442 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
	28	7.0	1.5	150523	10	180260
	[mm]	[mm]	[mm]		[pc.]	

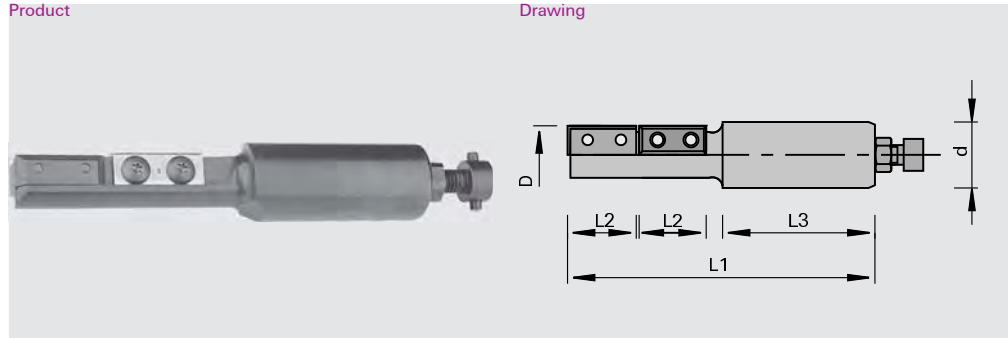
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449
Screwdrivers	T9x60	985730	1	173796
	[mm]		[pc.]	

128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1, 2+2 sense of rotation L+R

Product

Drawing



LEUCO DUR
 Tungsten Carbide [HW]
 MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to cutter axis; face cutting
- | customized direction of rotation (right or left) by installing the appropriate turnover knife
- | cutting material: HW HL Board 05
- | lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- | Ident-No. 172269 with attachment screw
- | Ident-No. 180227 without attachment screw

Advantages

Notes

- | workpiece secured on clamping blocks
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	132	1L+1R	172269
40	39	25	55	158	2L+2R	180227
[mm]	[mm]	[mm]	[mm]	[mm]		

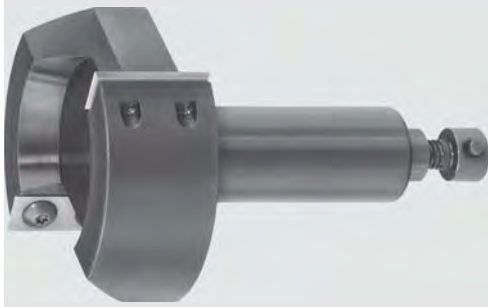
Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	29,5	12	1.5	150515	10	180825
	39,5	12	1.5	150515	10	171149
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=27	172269	925900	2	171068
Round Head Screws	M3,5x6 T15	180227	995195	10	177549
Round Head Screws	M3,5x12 T15	172269	995195	10	171067
Screwdrivers	T15x80	For all	985730	1	171188
	[mm]			[pc.]	

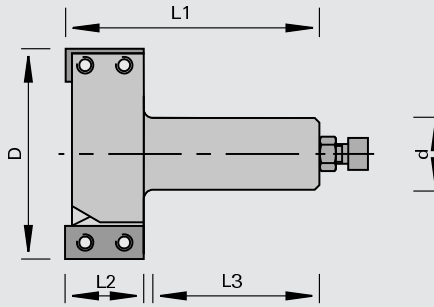
128210

Shank-Type Cutters with HW Turnover Knives for jointing, rabbeting, planing

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting and planing in solid woods and wood-based panels

Design

| cutting edge parallel to cutter axis and face cutting
 | cutting material: HW HL Board 05
 | with attachment screw

Advantages

Notes

| Clamping elements: ps-System, TRIBOS, draw-in collet chuck
 | with attachment screw

$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No.
80	30	25	55	89	2	168732
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	29,5	12	1.5	150515	10	180825
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Magnetic Stops	1,0	997800	1	166094
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

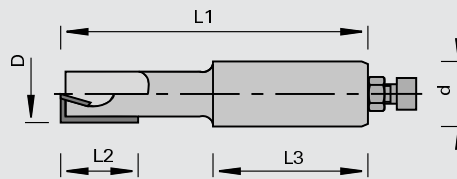
128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MEC

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	16	43	92	1+1	168682
20	30	16	43	96	1+1	168684
20	30	25	55	108	1+1	168685
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Plunge tip for Ø 16	7,5	12	1.5	150515	10	052543
plunge tip for Ø 20	9	12	1.5	150515	10	167256
Turnover Knives	29,5	12	1.5	150515	10	180825
	[mm]	[mm]	[mm]		[pc.]	

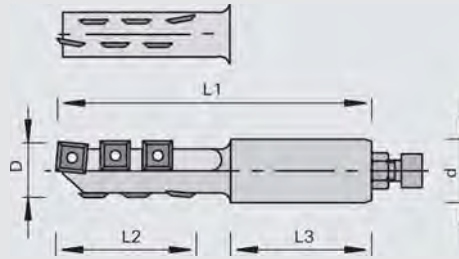
Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M3,5x3,8 T15	995115	10	162645
Round Head Screws	M3,5x4 T15	995195	10	168893
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

128210

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with high milling performance

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for pre-cutting and finish cutting in coated laminated materials
- | traveling plunge cut using Z and X or Y axis

Design

- | upper and lower turnover knife with shear angle
- | cutting material: HW HL Board 05
- | cutting material: HW HL Board 03
- | with attachment screw

Advantages

- | high hogging volume
- | chip-free cutting edges

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
22	60	25	55	131	1+1	180803 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	12	12	1.5	HL Board 05	150515	10	003080
	12	12	1.5	HL Board 03	150513	10	180820
	[mm]	[mm]	[mm]			[pc.]	

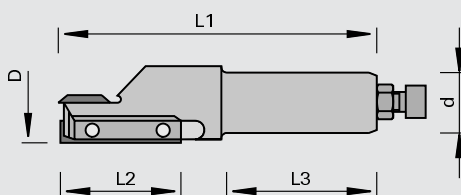
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	50	16	45	106	1+1	R 175714
16	50	25	55	116	1+1	R 175715
18	30	12	40	81	1+1	R 175707 o
18	50	16	45	106	1+1	R 180798
18	50	25	55	116	1+1	L 175717
18	50	25	55	116	1+1	R 175716
22	30	12	40	81	1+1	R 175711 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080
Mini Turnover Knives	30	5.5	1.1	150535	10	173482
Mini Turnover Knives	50	5.5	1.1	150535	10	173483
	[mm]	[mm]	[mm]		[pc.]	

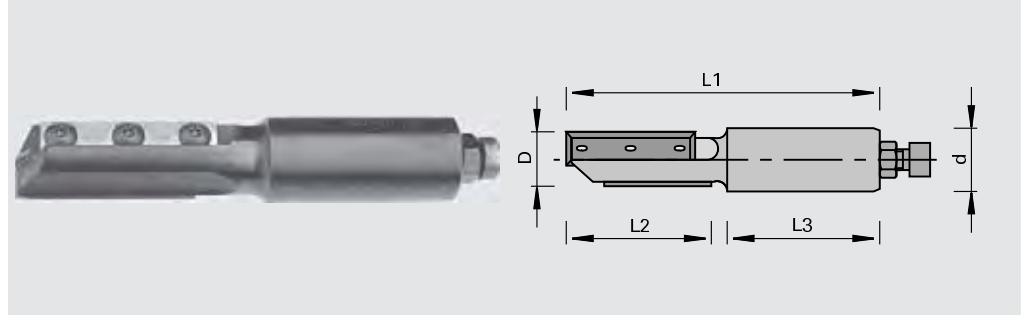
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175707	925500	2	169281 o
Clamping Wedges	B=50	175714, 175715	925500	2	171111 o
Clamping Wedges	B=50	175717	925500	2	171114 o
Clamping Wedges	B=50	175716, 180798	925500	2	171113 o
Clamping Wedges	B=30	175711	925500	2	169283 o
Head Cap Screws	M3,5x5,5 T15	175707, 175714, 175715, 175716, 175717, 180798	995115	10	168236
Head Cap Screws	M3,5x6,5 T15	175711	995115	10	163223
Round Head Screws	M4x5,9 T15	For all	995195	10	167966
Screwdrivers	T15	For all	985730	1	163161
	[mm]			[pc.]	

128215

Shank-Type Cutters with HW Turnover Knives - Z=2

Product

Drawing



LEUCO DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to axis in stepped design (Ident-No. 180799 without stepped design)
- | 1 plunging tip
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	55	25	55	125	2	180906	177156
20	55	25	55	125	2		177157
22	55	25	55	125	2		177158 o
25	50	25	55	119	2		180799
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	12	1.7	150516	10	179994
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Screwdrivers	T15	For all	985730	1	163161
Round Head Screws	M4x5,9 T15	177156, 177157, 177158, 177159, 180906	995195	10	167966
Head Cap Screws	M4x6 T15	180799	995195	10	180989 o
	[mm]			[pc.]	

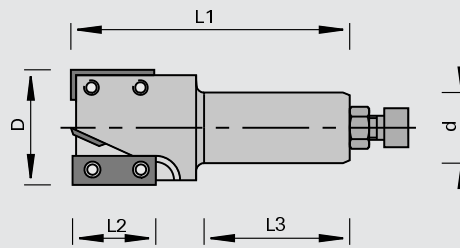
128410

Shank-Type Cutters with HW Turnover Knives - Z=2+1

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Dimension

- | 2 cutting edges parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]
40	30	16	43	91	2+1	168731
40	30	25	55	106	2+1	168730
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080
	29,5	12	1.5	150515	10	180825
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Magnetic Stops	1,0	997800	1	166094
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

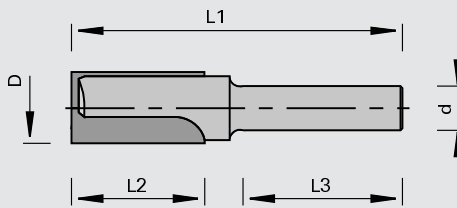
129415

Router Bits HW-tipped - face cutting

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: centric clamping chuck, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	23	10	35	70	2	160336
12	23	10	35	70	2	160337
16	23	10	35	70	2	160340 o
12	26	12	40	72	2	006229
14	28	12	40	76	2	006231 o
15	30	12	40	80	2	006232
16	35	12	40	90	2	180775
18	35	12	40	90	2	180776
20	35	12	40	90	2	180777
25	41	12	40	92	2	006240 o
[mm]	[mm]	[mm]	[mm]	[mm]		

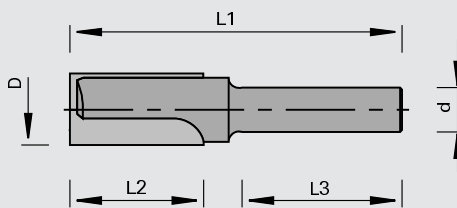
129415

Router Bits with solid carbide body - face cutting

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: centric clamping chuck, draw-in collet chuck

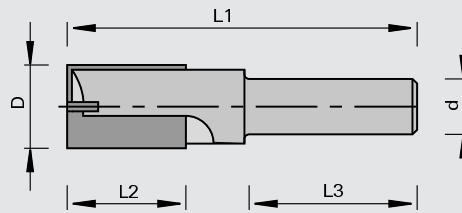
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
3.0	5,0	9,5	20	34	2	006219
5.0	7,0	9,5	20	39	2	006221
4.0	10	10	35	49	2	160332
5.0	12	10	35	49	2	160333
6.0	14	10	35	53	2	160334
8.0	20	10	35	60	2	160335
[mm]	[mm]	[mm]	[mm]	[mm]		

129415

Router Bits HW-tipped - face cutting and plunge tip

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design and plunging insert allows plunge-cuts
l clamping elements: centric clamping chuck, draw-in collet chuck

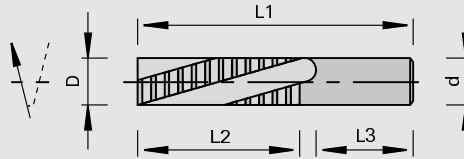
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	35	12	50	90	2	177160
12	35	12	50	90	2	177161
12	45	12	40	90	2	177162
14	35	12	50	90	2	177163 o
16	35	12	50	90	2	177164 o
18	35	12	50	90	2	177165 o
20	35	12	50	90	2	177166 o
22	35	12	50	90	2	177167 o
24	35	12	50	90	2	177168 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Roughing Cutters VHW - ecoline

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough-cutting in solid woods, plywood and uncoated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | well-priced version

Notes

- | ecoline design = reduced number of traces and less resharpener possibilities
- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
8.0	32	8,0	35	75	3	positive	183950
10	32	10	30	75	3	positive	183951
12	42	12	40	90	3	positive	183952
16	35	16	38	90	3	positive	183953
16	55	16	36	110	3	positive	183954
[mm]	[mm]	[mm]	[mm]	[mm]			

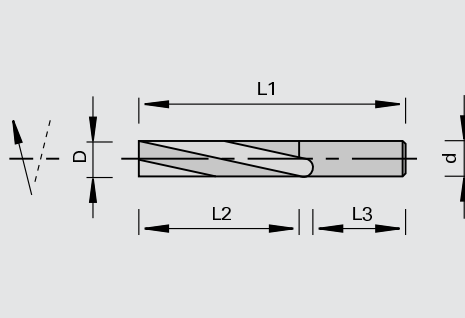
129460

Finishing Cutters VHW - ecoline

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for finish-cutting in solid woods, plywood and uncoated panels
- l for cutting of cut-outs and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l positive spiral for tightly clamped workpieces face side down
- l negative spiral for smaller workpieces hard to clamp with face side up
- l n max = 30,000 min-1

Advantages

- l high hogging volume
- l optimum upward chip evacuation thanks to positive spiral
- l optimum downward chip evacuation thanks to negative spiral
- l well-priced version

Notes

- l ecoline design = reduced number of traces and less resharping possibilities
- l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	15	3,0	36	60	2	positive	183937
3.0	15	6,0	36	60	2	positive	183938
4.0	15	4,0	36	60	2	positive	183939
4.0	15	4,0	28	60	2	negative	183940
4.0	15	6,0	36	60	2	positive	183941
5.0	15	6,0	36	60	2	positive	183942
6.0	22	6,0	30	60	2	positive	183943
6.0	22	6,0	30	60	2	negative	183944
8.0	30	8,0	36	75	2	positive	183945
8.0	30	8,0	36	75	2	negative	183946
10	30	10	35	75	2	positive	183947
10	30	10	36	75	2	negative	183948
12	42	12	40	90	3	positive	183949
[mm]	[mm]	[mm]	[mm]	[mm]			

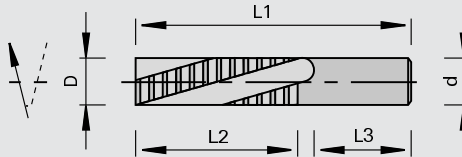
129460

Roughing Cutters VHW - negative spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | cutting pressure towards the bottom thanks to negative spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	30	10	40	75	2	178300
12	42	12	45	90	3	178304
14	35	14	45	90	3	178306 o
16	35	16	48	90	3	178311
16	55	16	48	110	3	178312
18	55	18	48	115	3	178317 o
20	55	20	50	115	3	178320
20	75	20	50	135	3	178323 o
[mm]	[mm]	[mm]	[mm]	[mm]		

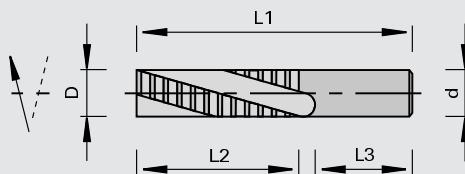
129460

Roughing Cutters VHW - positive spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

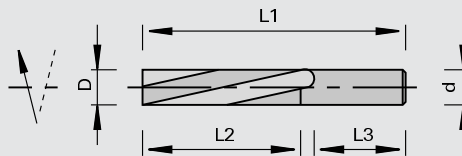
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	30	10	40	75	2	178301
12	45	12	45	90	2	178302
12	45	12	45	90	3	178303
14	35	14	45	90	3	178305
14	55	14	45	110	3	178307
16	35	16	48	90	2	178309
16	35	16	48	90	3	178310
16	55	16	48	110	2	178313
16	55	16	48	110	3	178314
18	55	18	48	115	2	178315 o
18	55	18	48	115	3	178316
20	55	20	50	115	2	178318
20	55	20	50	115	3	178319
20	75	20	50	135	2	178321 o
20	75	20	50	135	3	178322
20	110	20	48	170	3	185458
25	55	25	50	115	4	178324
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters VHW - negative spiral

Product

Drawing



LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | cutting pressure and chip evacuation towards the bottom thanks to negative spiral

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
4.0	15	4,0	28	60	2		178326
6.0	15	6,0	36	60	2		178327
8.0	30	8,0	36	75	2		178330
10	30	10	40	75	2		178332
12	42	12	45	90	2		178335
12	42	12	45	90	3		178336
14	35	14	45	90	2		178338 o
16	35	16	48	90	2		178342
16	35	16	48	90	3		178343
16	55	16	48	110	3	178349 o	178347
20	55	20	50	115	3		178354 o
20	75	20	50	135	3		178356
[mm]	[mm]	[mm]	[mm]	[mm]			

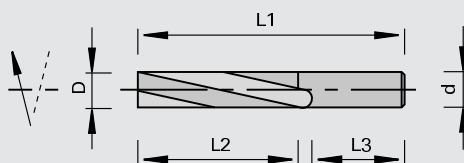
129460

Finishing Cutters VHW - positive spiral

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | optimal upward chip evacuation thanks to positive spiral

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

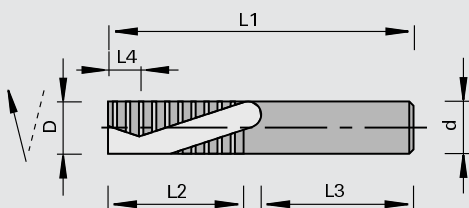
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
6.0	15	6,0	36	60	2		178328
8.0	30	8,0	36	75	2		178329
10	30	10	40	75	2		178331
12	42	12	45	90	2		178333
12	42	12	45	90	3		178334
14	35	14	45	90	3		178337
14	55	14	45	110	3		178339
16	35	16	48	90	2		178340
16	35	16	48	90	3		178341
16	55	16	48	110	2		178344
16	55	16	48	110	3	178348	178345
18	55	18	48	115	2		178350 o
18	55	18	48	115	3		178351
20	55	20	50	115	2		178352 o
20	55	20	50	115	3		178353
20	75	20	50	135	3		178355
20	110	20	48	170	3	variable pitch	185715
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Roughing Cutters VHW - positive/negative spiral with shear angle

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting of solid wood and plastics
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | two-sided shear angle
- | n max = 30,000 min-1

Advantages

- | optimum cutting quality in laminated panels thanks to shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

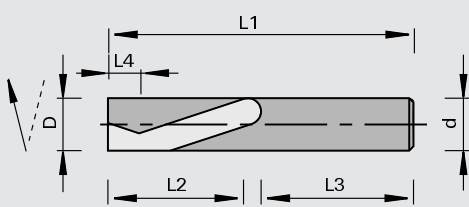
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
20	17	55	20	50	115	2+2	185838
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters VHW - magnet bond boards

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | specific for sizing and jointing magnet bond boards

Design

- | with shear angle on both sides
- | special tungsten carbide

Advantages

- | high cutting quality thanks to shear angle
- | tungsten carbide with better wear resistance for longer edge life compared to conventional VHW shank-type cutters

Notes

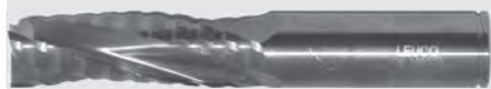
- | clamping elements: ps-System with reducing bushing Class-No. 933280, TRIBOS
- | recommended application parameters:
 - | feed (Vf) approx. 1 - 1,5 m/min
 - | RPM (N) approx. 3,000 - 4,500
 - | use with feed
 - | oscillating milling allows longer edge life

Ø D	L4	L2	Ø d	L1	Z	Ident-No.
12	7	36	12	90	2+2	186242
18	7	36	18	90	2+2	186243
[mm]	[mm]	[mm]	[mm]	[mm]		

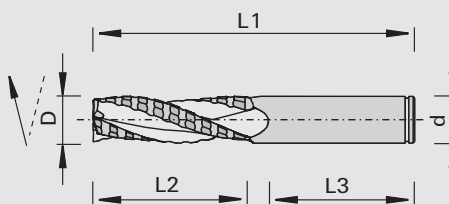
129460

Roughing / Finishing Cutter VHW "NF"

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for sizing and grooving particularly in soft and hard woods, glued woods, Multiplex, plywood and many wood-based panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | NF serration
- | Z=3 for high cutting performance
- | positive spiral for tightly clamped workpieces face side down
- | negative spiral for workpiece support with face side up
- | n max = 30,000 min-1

Advantages

- | cutting surfaces almost in finishing quality
- | reduced effort thanks to division of cut
- | smooth running

Notes

- | clamping elements: we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No. [L]	Ident-No. [R]
12	35	12	40	80	3	positive		185527
12	35	12	40	100	3	negative	185529	185528
12	42	12	45	90	3	positive		185530
14	42	14	50	100	3	positive		185531
16	52	16	55	110	3	positive	185533	185532
18	60	18	55	115	3	positive		185534
20	60	20	55	120	3	positive	185536	185535
20	75	20	50	130	3	positive	185538	185537
[mm]	[mm]	[mm]	[mm]	[mm]				

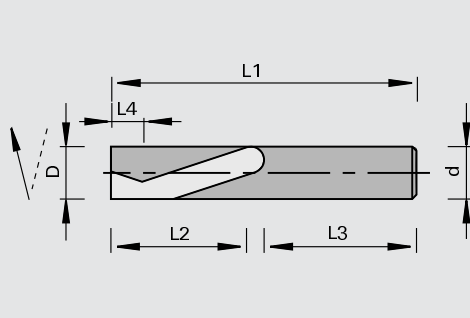
129460

Finishing Cutters VHW - positive/negative spiral with shear angle

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | two-sided shear angle
- | n max = 30,000 min⁻¹

Advantages

- | optimum cutting quality in laminated panels thanks to shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

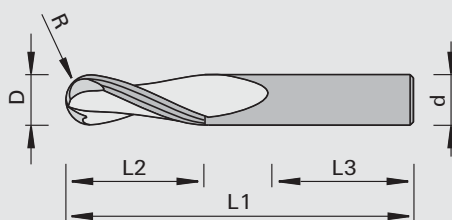
Ø D	L4	L2	Ø d	L1	Z	Ident-No.
8.0	7.0	32	8,0	80	2+2	180870
10	7.0	32	10	80	2+2	180871
12	7.0	42	12	90	2+2	180872
16	24	55	16	110	2+2	180873
18	30	55	18	110	2+2	180874
[mm]	[mm]	[mm]	[mm]	[mm]		

129660

Radius Shank-Type Cutter VHW

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for grooving, contour milling and template copying
- | for milling of contours, surface profiles, string wreaths, and other relief profile milling work
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral
- | face-ground
- | solid tungsten carbide (VHW)
- | right-hand cutting
- | no. of cutting edges Z=2 resp. Z=3

Advantages

- | long edge lives thanks to high-quality micrograin carbide

Notes

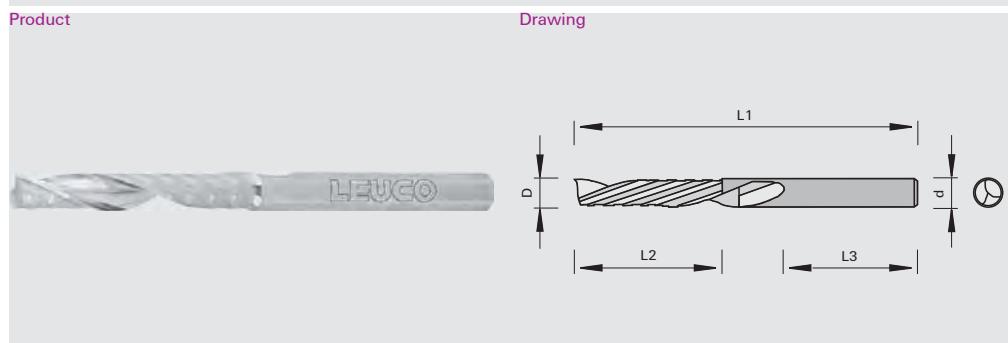
- | clamping elements: we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Ø D	L2	Ø d	L1	Z	R	Ident-No.
3.0	12	3,0	50	2	1,5	185208 o
4.0	15	4,0	50	2	2,0	185209
5.0	17	5,0	50	2	2,5	185210 o
6.0	22	6,0	60	2	3,0	185211
8.0	22	8,0	70	2	4,0	185212
10	32	10	70	2	5,0	185213
10	42	10	100	2	5,0	185214 o
12	32	12	80	2	6,0	185215
12	42	12	100	2	6,0	185216 o
14	42	14	100	2	7,0	185217 o
16	42	16	100	2	8,0	185218
16	52	16	100	2	8,0	185219 o
18	52	18	100	2	9,0	185220 o
20	52	20	100	2	10	185221
20	72	20	130	2	10	185222 o
[mm]	[mm]	[mm]	[mm]		[mm]	

Ø D	L2	Ø d	L1	Z	R	Ident-No.
8.0	22	8,0	70	3	4,0	185223 o
10	32	10	70	3	5,0	185224 o
10	42	10	100	3	5,0	185225 o
12	32	12	80	3	6,0	185226 o
12	42	12	100	3	6,0	185227 o
14	42	14	100	3	7,0	185228 o
16	42	16	100	3	8,0	185229 o
16	52	16	100	3	8,0	185230 o
18	52	18	100	3	9,0	185231 o
20	52	20	100	3	10	185232 o
20	72	20	130	3	10	185233 o
[mm]	[mm]	[mm]	[mm]		[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of plastic - Z1



LEUCO DUR

Solid Tungsten Carbide

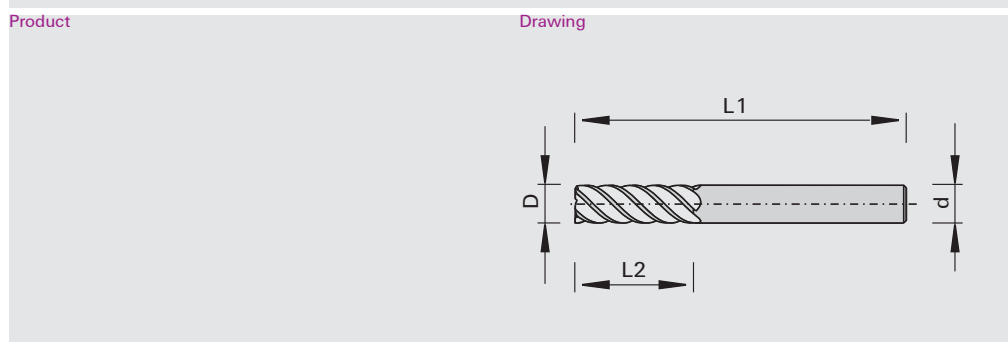
MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in plastics traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral high-polish spiral grooves wear-resistant micrograin carbide HL Board 10 	<ul style="list-style-type: none"> optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral 	<ul style="list-style-type: none"> negative spiral on request clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Helical direction	Ident-No.
3.0	12	3,0	50	1	positive	184715
4.0	15	4,0	50	1	positive	184716
5.0	17	5,0	50	1	positive	184717
6.0	22	6,0	60	1	positive	184718
8.0	22	8,0	70	1	positive	184719
8.0	32	8,0	70	1	positive	184720
10	32	10	70	1	positive	184721
12	32	12	80	1	positive	184722
[mm]	[mm]	[mm]	[mm]			

129460

Polishing Shank-Type Cutter VHW for acrylic glass and PMMA - Z5



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for finishing of acrylics and PMMA with relatively clear surfaces attention: these tools are not suitable for sizing or dividing but only for polishing! 	<ul style="list-style-type: none"> positive spiral high-quality solid tungsten carbide (VHW) with 5 cutting edges 	<ul style="list-style-type: none"> reduced production times as postprocessing is no longer necessary produces relatively clear surfaces which are sufficient in many cases 	<ul style="list-style-type: none"> finish milling (removal of 0.05 - 0.1 mm) at a feedrate of approx. 0.5 - 1 m/min high RPM is recommended (18,000 - 24,000 min⁻¹ or higher) application against feed the good quality can only be reached in connection with a precision clamping element

Ø D	L2	Ø d	L1	Z	Helical direction	Ident-No.
6.0	22	6,0	60	5	positive	184704
8.0	25	8,0	70	5	positive	184705
[mm]	[mm]	[mm]	[mm]			

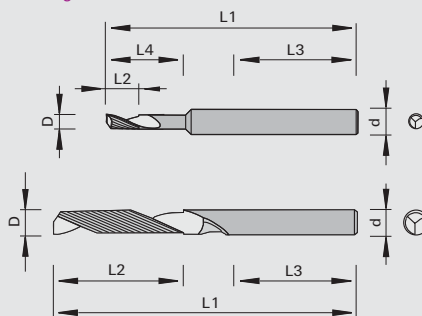
129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- l traveling plunge cut using Z and X or Y axis

Design

- l positive spiral
- l polished chip gullets

Advantages

- l optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes

- l negative spiral on request
- l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	L4	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	10	25	8,0	55	80	1	positive	184709
4.0	10	25	8,0	55	80	1	positive	184710
5.0	10	25	8,0	55	80	1	positive	184711
6.0	10	25	8,0	55	80	1	positive	184712
8.0	25	50	8,0	45	100	1	positive	184713
10	25	35	10	60	100	1	positive	184714
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

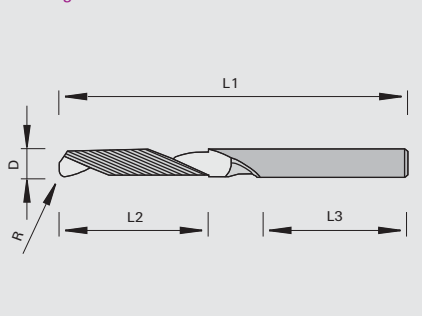
129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1 with radius

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- l especially for grooving in aluminum
- l traveling plunge cut using Z and X or Y axis

Design

- l positive spiral
- l polished chip gullets

Advantages

- l especially for aluminum with high silicium rate
- l optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral
- l reduced cutting pressure thanks to radius

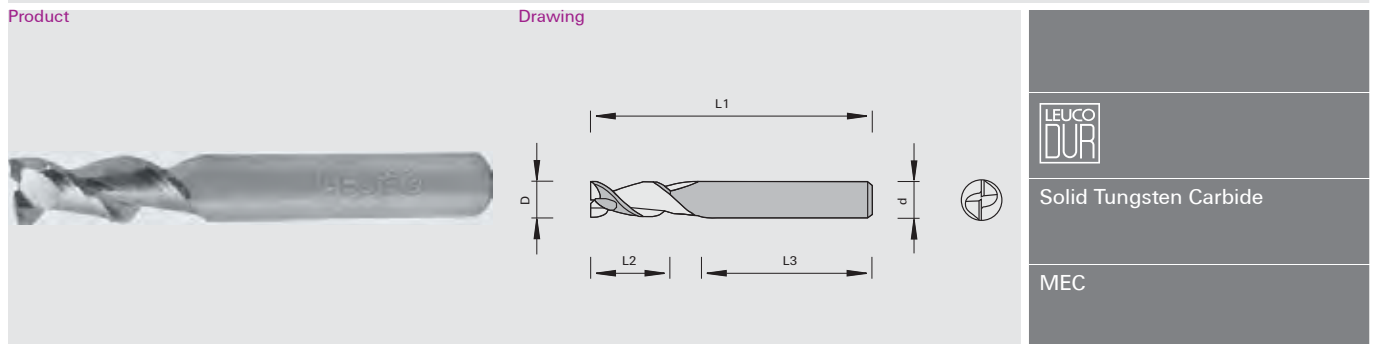
Notes

- l negative spiral or reinforced shank diameter on request
- l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	R	Ident-No.
5.0	20	6,0	40	70	1	positive	1,0	183972 o
6.0	20	8,0	45	80	1	positive	1,5	183973 o
8.0	22	10	45	90	1	positive	1,5	183974 o
10	25	10	50	100	1	positive	2,0	183975 o
12	30	12	60	120	1	positive	2,5	183976 o
[mm]	[mm]	[mm]	[mm]	[mm]			[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z2



Solid Tungsten Carbide

MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral polished chip gullets spiral angle 45° special grinding 	<ul style="list-style-type: none"> optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral 	<ul style="list-style-type: none"> negative spiral or reinforced shank diameter on request clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

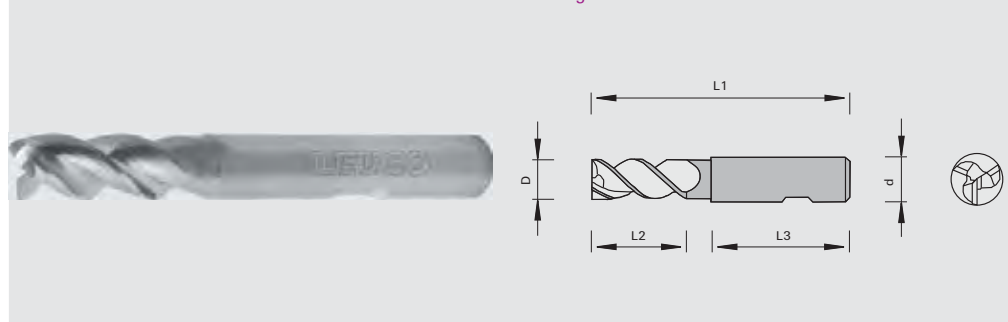
Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	8,0	6,0	36	57	2	positive	183977 s
4.0	11	6,0	36	57	2	positive	183978 s
5.0	13	6,0	36	57	2	positive	183979 s
6.0	13	6,0	36	57	2	positive	183980 o
8.0	19	8,0	36	63	2	positive	183981 o
10	22	10	40	72	2	positive	183982 o
12	26	12	45	83	2	positive	183983 o
16	32	16	48	92	2	positive	183984 o
20	38	20	50	104	2	positive	183985 o
[mm]	[mm]	[mm]	[mm]	[mm]			

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z3

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals
- l traveling plunge cut using Z and X or Y axis

Design

- l positive spiral
- l polished chip gullets
- l cutting edges with variable pitch
- l spiral angle 42° - 43°
- l special grinding

Advantages

- l optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral
- l smooth and low-noise running thanks to variable pitch

Notes

- l negative spiral or reinforced shank diameter on request
- l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

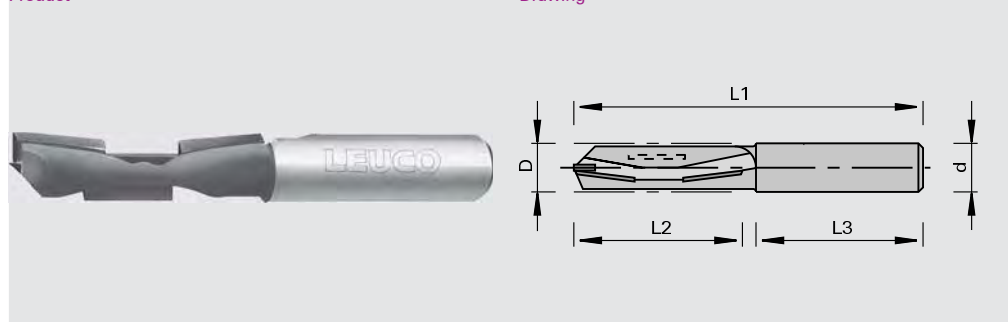
Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	8,0	6,0	45	57	3	positive	183986 o
4.0	11	6,0	39	57	3	positive	183987 o
5.0	13	6,0	39	57	3	positive	183988 o
6.0	13	6,0	39	57	3	positive	183989 o
8.0	21	8,0	38	63	3	positive	183990 o
10	22	10	42	72	3	positive	183991 o
12	26	12	47	83	3	positive	183992 o
16	36	16	50	92	3	positive	183993 o
20	41	20	52	104	3	positive	183994 o
[mm]	[mm]	[mm]	[mm]	[mm]			

129860

Router Bits for Sash Openings HW-tipped with shear angle

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- l stationary routers
- l CNC routers
- l for cutting of cut-outs in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- l with shear angle
- l n max = 16.000 min-1

Advantages

- l optimum cutting quality on veneered and plastic laminated parts

Notes

- l face cutting design allows plunge-cuts
- l clamping elements: draw-in collet chuck, centric clamping chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Roughing Plunge Cutters VHW - door manufacturing

Product	Drawing	
		Solid Tungsten Carbide
		MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for drilling of latchholes and keyholes 	<ul style="list-style-type: none"> positive spiral n max = 30,000 min-1 		<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	5.0	75	16	48	130	2	185831
20	5.0	75	20	50	135	3	185832
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Finishing Plunge Cutters VHW - door manufacturing

Product	Drawing	
		Solid Tungsten Carbide
		MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for drilling of peepholes and for through holes 	<ul style="list-style-type: none"> positive spiral n max = 30,000 min-1 		<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

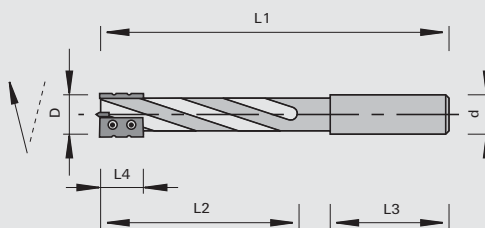
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	185826
12	10	70	12	50	130	2	185828
14	10	47	14	45	110	2	185829
16	11	52	16	60	130	2	185830
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

Product

Drawing

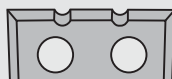
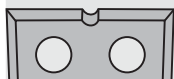


Tungsten Carbide [HW]

MEC

A

B



Machine / Application

| CNC machining centers
| for cutting of lock-cases and face-plates in doors

Design

| positive spiral
| high-tensile body (heavy metal)
| with HW-tipped (soldered) plunge tip
| knives with chip breaker form A and B
| n max = 18,000 min-1

Advantages

| optimum chip evacuation thanks to positive spiral
| high balance quality thanks to cutting edges with chip breakers
| constant diameter thanks to exchangeable knives

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
| for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	16	105	16	55	170	2	183750 o
16	16	105	20	55	170	2	183751 o
18	16	105	20	55	170	2	183752 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Type	Class-No.	PU	Ident-No.
	16	7.0	1.5	A	150525	10	183753
	16	7.0	1.5	B	150525	10	183754
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995 195	10	180449
Screwdrivers	T9x60	985 730	1	173796
	[mm]		[pc.]	

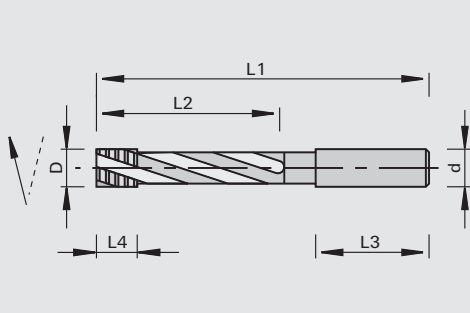
129460

Lock-Case Roughing Cutters VHW - door manufacturing

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

l CNC machining centers
l for cutting of lock-cases in doors

Design

l positive spiral
l roughing design

Advantages

l optimum chip evacuation thanks to positive spiral
l high smoothness of running

Notes

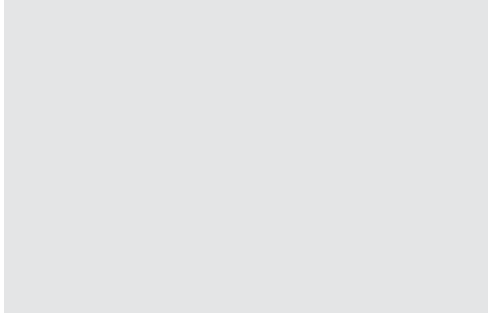
l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
l for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	185835
16	25	115	16	50	175	3	24000	185836
18	25	115	20	50	175	3	24000	185837
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

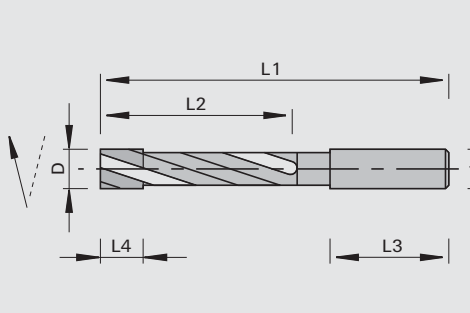
129460

Lock-Case Finishing Cutters VHW - door manufacturing

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

l CNC machining centers
l for cutting of lock-cases and face-plates in doors

Design

l positive spiral
l finishing design

Advantages

l optimum chip evacuation thanks to positive spiral
l high smoothness of running

Notes

l clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
l for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

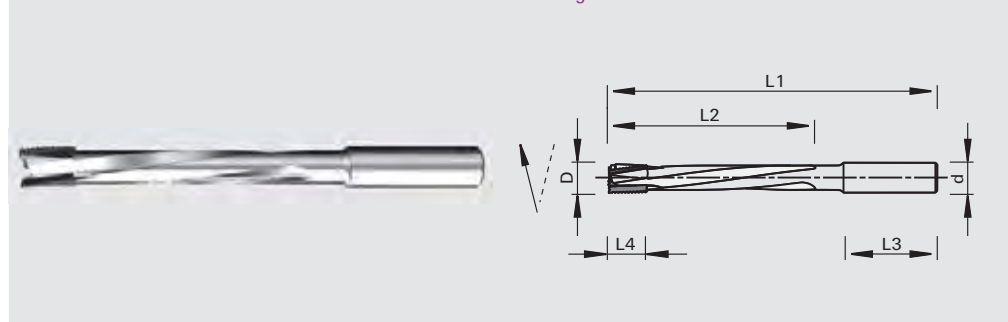
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	2	24000	185833
16	25	115	16	50	175	2	24000	185834
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129460

Lock-Case Roughing Cutters VHW - negative spiral - door manufacturing

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | High-performance door machining systems
- | CNC machining centers
- | Machines with lock-case units
- | For cutting lock-cases in doors
- | Also suitable for forend cutting

Design

- | Negative spiral
- | Fine roughing design
- | High-quality cutting material

Advantages

- | Very smooth running and therefore very gentle on the milling units
- | Lowest load even when changing the milling direction
- | Longer edge lives

Notes

- | Recommended for use in hydraulic expansion chucks or heat-shrinking chucks
- | For mounting in horizontal drilling-milling aggregate (Homag, Weeke), lateral clamping surfaces are required (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No. [L]
16	25	115	16	50	175	3	24000	186763
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

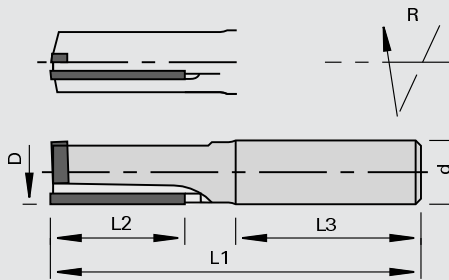
229222

DIAMAX Shank-Type Cutters DP

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

- polished face and high-finish clearance angle
- with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- straight cutter axis
- solid carbide body for $\varnothing 5$ mm - $\varnothing 10$ mm
- resharpening area $\varnothing 5 - \varnothing 10 = 0,5$ mm, $\varnothing 12 + \varnothing 16 = 1,2$ mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge
- increased stability thanks to special design of brazing area

Notes

- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- $\varnothing D=12$ and 16 mm with thread for length adjusting screw

$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	nmax	Ident-No. [L]	Ident-No. [R]
5.0	12	12	40	60	1	24000		183566
6.0	12	12	40	60	1	24000		183567
8.0	12	12	35	60	1	24000		178659
8.0	12	12	40	60	2	24000		183568
10	22	12	35	70	2	24000	186785	186784
12	25.4	12	35	70	1	24000		181102
16	25.4	16	45	85	1	24000		181104
16	35	16	45	95	1	24000		181106
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

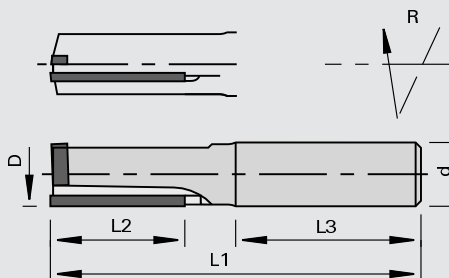
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing without overlap marks in solid woods and wood-based panels
- not suitable for dividing and deep grooves
- for light millwork only

Design

- polished face and high-finish clearance angle
- with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- straight cutter axis
- resharpening area 1.5 mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge

Notes

- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- with thread for length adjusting screw

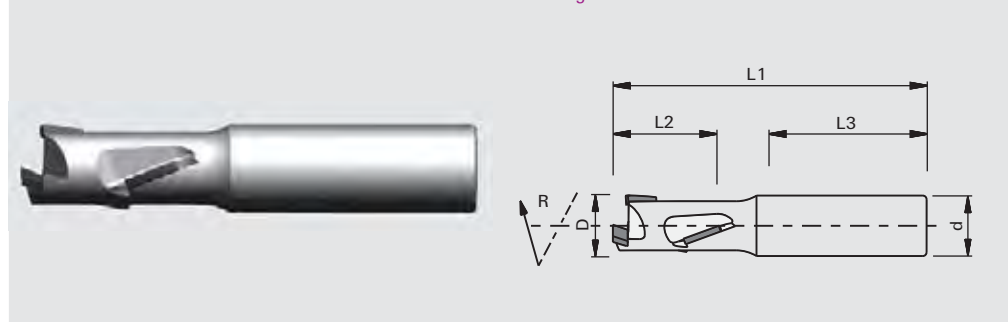
$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	nmax	Ident-No. [R]
8.0	22	12	35	65	1	24000	182664
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
 | for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with DP plunge tip for diagonal plunge-cutting
 | with shear angle
 | resharpenable several times
 | n max = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
 | smooth running thanks to spiral cut configuration
 | very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

| feed rates up to 12 m/min
 | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
 | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharping area	Ident-No. [L]	Ident-No. [R]
10	22	12	40	69	1+1	0.6		186789
12	22	12	40	69	1+1	0.8		186790
12	28	12	40	75	1+1	0.8	186793	186792
16	22	16	45	78	1+1	1.0		186794
16	28	16	45	83	1+1	1.0		186795
16	35	16	45	90	1+1	1.0	186797	186796
18	28	16	45	85	1+1	1.0		186798
18	28	20	45	95	1+1	1.0	186799	186800
18	35	16	45	92	1+1	1.0	186801	186802
18	35	20	55	102	1+1	1.0	186804	186803
18	43	16	45	100	1+1	1.0	183806	186805
18	43	20	55	110	1+1	1.0	186808	186807
18	43	25	55	110	1+1	1.0	186913	186912
20	35	20	55	102	1+1	1.0		186809
20	52	25	55	120	1+1	1.0	186811	186810
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		
Ø D	L2	Ø d	L3	L1	Z	Resharping area	Ident-No.	
1/2"	1"	1/2"	1 3/8"	2 2/3"	1+1	1.0	186791	
[inch]	[inch]	[inch]	[inch]	[inch]		[mm]		

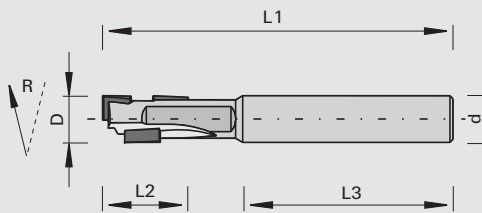
229040

Grooving Shank-Type Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- especially for grooving but also for jointing, and dividing in raw and laminated panels as well as for example in glued veneered woods (Multiplex)

Design

- extremely rigid VHW tool body
- with alternating shear angle
- with DP plunge tip
- polished face
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to special cutting edge configuration
- very long edge lives, less cutting forces and less noise thanks to optimized tool body
- clean ground of groove

Notes

- clamping elements: hydro expansion chuck ps-System or TRIBOS with precision reducing sleeves Ident-No. 183032 or 182305 or with heat shrink-fit chuck Ident-No. 80362923

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	14	8,0	36	60	1+1	R 185734
[mm]	[mm]	[mm]	[mm]	[mm]		

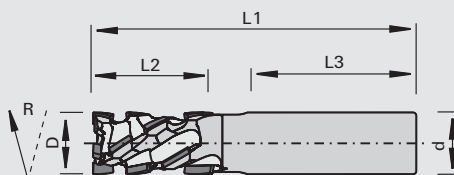
229122

DIAREX High-Performance Shank-Type Cutters DP - Z=2+2

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 1.2 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to 4-wing design of cutting edges
- very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

- feed rates up to 20 m/min
- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
16	28	16	45	80	2+2		186147
16	38	16	45	90	2+2	186149	186148
20	28	20	55	95	2+2		186150
20	28	25	55	95	2+2	186152	186151
20	38	20	55	105	2+2		186153
20	38	25	55	105	2+2	186155	186154
20	48	20	55	115	2+2		186156
20	48	25	55	115	2+2	186158	186157
25	65	25	55	130	2+2	186160	186159
[mm]	[mm]	[mm]	[mm]	[mm]			

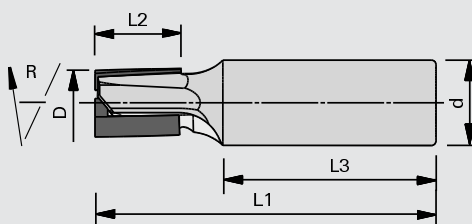
229342

High-Performance Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for jointing and sizing without overlap marks in solid woods and wood-based panels
- | especially suited for the machining of plastic solid core panels (e.g. Trespa, Corian, Varicor, LG-HiMacs, etc.)

Design

- | high-performance tool for pre- and finish-milling
- | with face shear angles
- | with DP plunging tip
- | face cutting for diagonal plunge-cutting
- | polished face
- | n max = 24.000 min-1

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpening area	Ident-No.
12	15	16	45	75	2+1	1.0	R 186436
12	15	16	45	75	3+1	1.0	R 186305
12	22	16	45	75	2+1	1.0	R 186437
14	28	16	45	80	2+1	1.5	R 186438
16	20	20	50	80	2+1	2.8	R 186439
16	20	20	50	80	3+1	1.6	R 186431
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

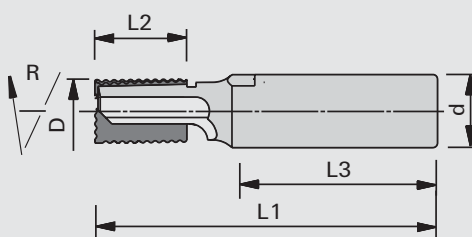
229021

High-Performance Roughing Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for pre-sizing in roughing quality in wood-based panels, solid wood and plastic
- | especially suited for the machining of plastic solid core panels (e.g. Trespa, Corian, Varicor, LG-HiMacs, etc.)

Design

- | high-performance tool for rough and finish milling
- | with alternating shear angle
- | with DP plunging tip
- | face cutting for diagonal plunge-cutting
- | n max = 24,000 min-1

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpening area	Ident-No.
14	20	16	45	75	2+1	1.5	R 186579
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

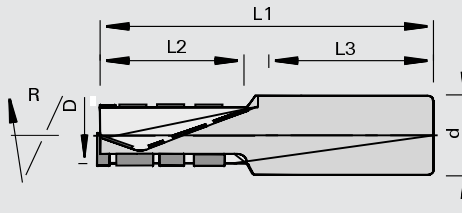
229022

High-Performance Shank-Type Cutters DP - Z=2+1+2

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- high-performance tool for rough and finish milling
- Z=1 in middle layer and Z=2 in covering layer
- face cutting for diagonal plunge-cutting
- with shear angle
- resharpening area 3.0 mm
- n max = 24,000 min-1

Advantages

- good cutting quality on top and bottom edge thanks to opposing shear angle
- reduced vibrations thanks to variable pitch
- optimum good chip disposal thanks to open arrangement of cutting edges

Notes

- feed speed up to 20 m/min when jointing
- feed speed up to 12 m/min when sizing
- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
20	28	25	60	100	2+1+2	12-25		181481 s
25	35	25	60	110	2+1+2	18-32		181483 s
25	42	25	60	120	2+1+2	25-40		181485 s
25	48	25	62	120	2+1+2	32-45	181486	181487 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

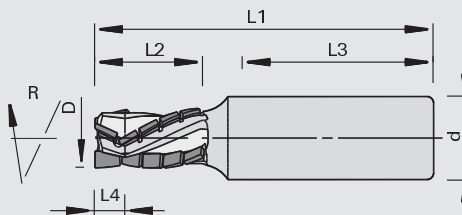
229322

High-Performance Shank-Type Cutters DP - Z=3+3

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for pre- and finish-milling

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 3.0 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to spiral cut configuration

Notes

- feed rates up to 30 m/min
- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	28	7	25	55	95	3+3	186665 s	186118
20	38	7	20	55	105	3+3	186666 s	186119
25	28	7	25	55	95	3+3	186121	186120
25	38	7	25	55	105	3+3	186123 s	186122
25	48	7	25	55	115	3+3	186125	186124
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

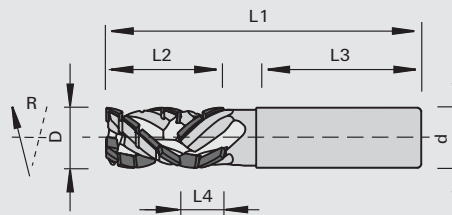
229022

High-Performance Shank-Type Cutters CM DP - Z=3+3

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for rough and finish milling

Design

- | with DP plunge tip for diagonal plunge-cutting
- | with shear angle
- | resharpening area approx. 3 mm
- | n max = 24,000 min-1

Advantages

- | optimum cutting quality thanks to shear angle, alternating top and bottom
- | smooth running thanks to spiral cut configuration
- | optimum chip removal thanks to topward spiral and ChipMeister version

Notes

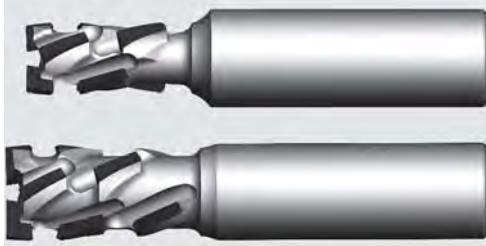
- | feed rates up to 30 m/min
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	28	12	25	55	95	3+3	186127	186126
25	28	12	25	55	95	3+3		186130
20	38	15	20	55	105	3+3	186129	186128
25	38	15	25	55	105	3+3	186132 s	186131
25	52	16.5	25	55	120	3+3	186134	186133
25	65	18	25	55	133	3+3	186136 s	186135
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

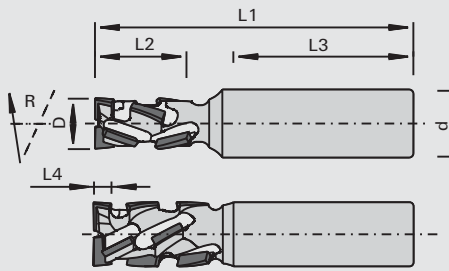
229022

High-Performance Shank-Type Cutters CM DP Nesting - Z=2+2

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for panel sizing with Nesting Technology
- | for jointing, rabbeting and *grooving (*negative design)
- | particularly for processing MDF panels and Multiplex

Design

- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | Ø D=12 mm with highly stiff tool body
- | resharpening area 1.6 mm
- | n max = 24,000 min⁻¹

Advantages

- | high cutting quality and high-quality cutting edges on both sides thanks to specially adapted arrangement of cutting edges
- | positive spiral: optimum upward chip evacuation towards the dust extraction
- | negative spiral: downward chip evacuation and cutting pressure
- | negative spiral especially suitable for smaller or narrow workpieces and for grooving
- | Z=2+2 = bigger gullets for better chip removal (MDF) and for reducing heat generation, particularly when processing Multiplex

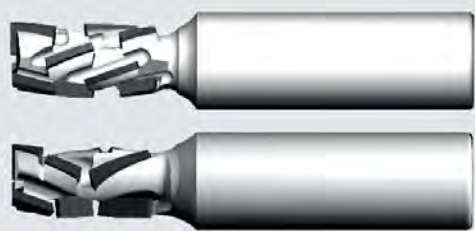
Notes

- | clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- | with thread for length adjusting screw
- | in case of higher feed rates and thicker boards choose the higher diameter
- | adapt the cutting length to the panel thickness (H)
- | * indicate "H" in case of Nesting with protection board

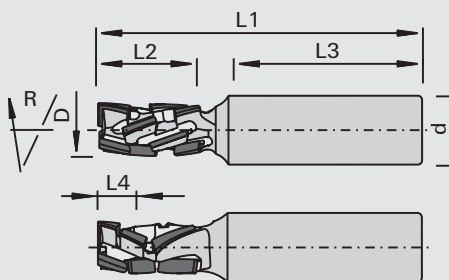
Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical direction	Ident-No. [R]
12	22		16	45	75	2+2	16-19 *	positive	186112
12	22	4.5	16	45	75	2+2	-19	negative	186113
16	28	4.5	16	45	80	2+2	-25	negative	186114
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3

Product



Drawing



229022

Machine / Application

- l CNC routers
- l for panel sizing with Nesting-Technology
- l for jointing, rabbeting and *grooving (*negative version) in raw and laminated panels

Design

- l with DP plunge tip
- l face cutting for diagonal plunge-cutting
- l Ø D=12 mm with highly stiff tool body
- l feed rates up to 25 m/min
- l resharpening area 1.6 mm
- l n max = 24,000 min⁻¹

Advantages

- l high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- l positive spiral: optimum upward chip evacuation towards the exhaustion
- l negative spiral: downward chip evacuation and cutting pressure
- l negative spiral especially for smaller or narrow workpieces and for grooving

Notes

- l clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- l with thread for length adjusting screw
- l in case of higher feed rates and thicker boards choose the higher diameter
- l adapt the cutting length to the panel thickness (H)
- l * indicate "H" in case of Nesting with protection board

Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical direction	Ident-No. [R]
12	22		16	45	75	3+3	16-19 *	positive	186571
12	28		16	45	80	3+3	22-25 *	positive	186572
16	22		16	45	75	3+3	16-19 *	positive	186573
16	28		16	45	80	3+3	22-25 *	positive	186574
12	23	7.2	16	45	75	3+3	-19	negative	185518
14	33	7.2	16	45	85	3+3	-30	negative	185799
16	28	7.2	16	45	80	3+3	-25	negative	185519
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

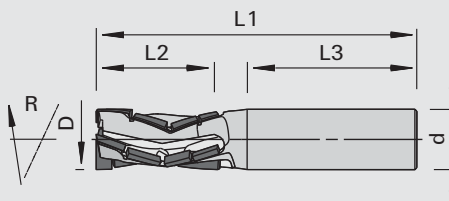
229022

High-Performance Shank-Type Cutters CM DP - Z=4+4

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- l high-performance tool for rough and finish milling

Design

- l with DP plunge tip for diagonal plunge-cutting
- l with alternating shear angle
- l resharpening area approx. 1.6 mm
- l n max = 24,000 min⁻¹

Advantages

- l optimum cutting quality thanks to shear angle, alternating top and bottom
- l high hogging volume
- l optimized chip removal

Notes

- l clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, hydro expansion chuck ps-System, heat shrink-fit chuck)

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
16	32	16	45	85	4+4	185499
[mm]	[mm]	[mm]	[mm]	[mm]		

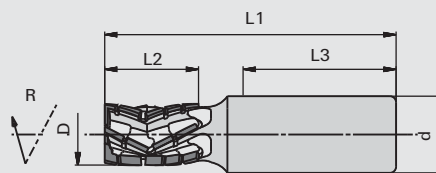
229322

High-Performance Shank-Type Cutters DP - Z=5+5

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for rough and finish milling

Design

- | arrow-shaped toothing
- | with DP plunge tip for diagonal plunge-cutting
- | with shear angle
- | resharping area approx. 2 mm
- | n max = 24,000 min-1

Advantages

- | optimum cutting quality thanks to shear angle, alternating top and bottom
- | very long edge lives and continuous high cutting quality
- | smooth running thanks to spiral cut configuration

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
25	30	25	55	95	5+5	186 137
25	45	25	55	115	5+5	186 138 s
[mm]	[mm]	[mm]	[mm]	[mm]		

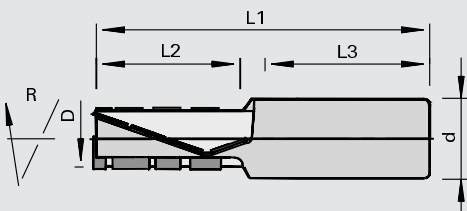
229022

High-Performance Shank-Type Cutters with solid carbide body DP - Z=3

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | solid carbide design of tool body
- | high-performance tool for rough and finish milling, as well as panel sizing with Nesting-Technology
- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | feed rates up to 25 m/min
- | resharping area 2.0 mm
- | n max = 24,000 min-1

Advantages

- | high cutting quality and smooth running thanks to spiral design of cutting edges
- | optimum good chip disposal thanks to open arrangement of cutting edges
- | optimum cutting lengths suitable for most popular panel thicknesses

Notes

- | clamping elements: ps-System, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No.
12	21	16	45	73	3	16-19	181935
12	28	16	45	80	3	22-25	181936
12	30	16	45	82	3	28	181937
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

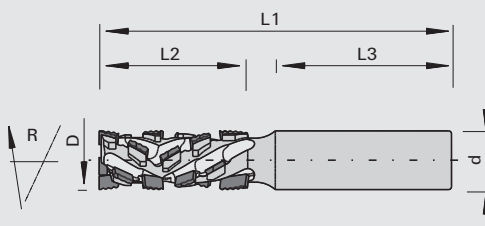
229041

Shank-Type Roughing Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing in roughing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | with alternating shear angle
- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | resharpening area ≥ 2.0 mm
- | n max = 24,000 min⁻¹

Advantages

- | for long edge lives also in abrasive materials
- | chip-free cutting edges on both sides
- | high hogging volume

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
20	35	20	60	105	2+2	185026
20	50	20	60	120	2+2	185027
[mm]	[mm]	[mm]	[mm]	[mm]		

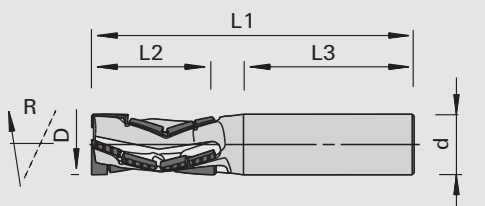
229021

Shank-Type Roughing-Finishing Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing in almost finishing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | with alternating shear angle
- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | resharpening area ≥ 1.6 mm
- | n max = 30,000 min⁻¹

Advantages

- | for long edge lives also in abrasive materials
- | chip-free cutting edges on both sides
- | high hogging volume

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
16	32	16	45	85	4 (2+2)	185498
[mm]	[mm]	[mm]	[mm]	[mm]		

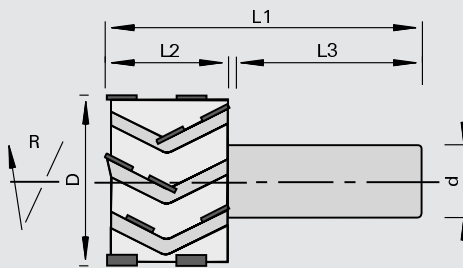
229320

High-Performance Trimming Router Bits DP - Z=4+2+4

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | high-performance tool for finish cuts
- | with shear angle
- | resharpening area 3.0 mm

Advantages

- | high feed rates (up to 35 m/min) and good edge quality thanks to 4 cutting edges working in top layer
- | minimized formation of dust thanks to 2 cutting edges working in core of board
- | very good surface thanks to large cutting circle diameter
- | good cutting quality on top and bottom edge thanks to opposing shear angle

Notes

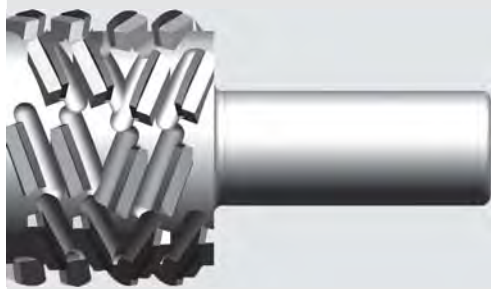
- | preferably for finish-cut operations on pre-sized workpieces
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
48	22	25	62	85	4+2+4	16-19	186139 s	186140
48	28	25	62	91	4+2+4	22-25	186141 s	186142
48	35	25	62	98	4+2+4	28-32	186143 s	186144
48	48	25	55	110	4+2+4	35-45	186146	186145
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

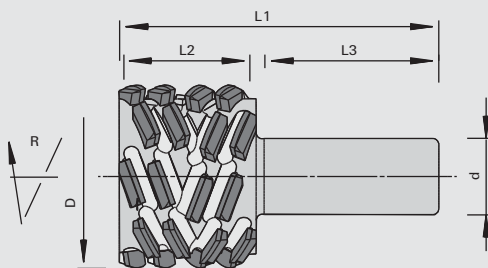
229324

p-System High-Performance Jointing Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing of solid woods (free of knots) along and across the grain
- | for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical and asymmetrical design
- | non-convex design
- | extremely scoring cut
- | resharpening area 4 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | with thread for length adjusting screw
- | recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- | crowned design on request
- | clamping element: precision clamping element e.g. ps-System, TRIBOS
- | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear∠	Ident-No. [R]
48	28,2	25	62.2	100	3+3	70	184081
48	38	25	57.4	105	3+3	70	184082
60	38	25	57.4	105	3+3	70	184083 s
60	38	25	57.4	105	4+4	70	184084
60	42,9	25	57.5	110	3+3	70	185821
60	47,8	25	57.6	115	3+3	70	185819 s
60	57,6	25	57.8	125	3+3	70	185820 s
60	67,4	25	56.8	135	3+3	70	184080 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

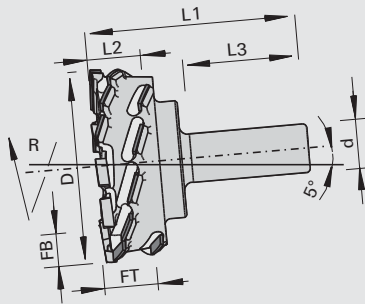
229324

p-System High-Performance Rabbeting Shank-Type Cutter CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | 5-axis machining centers
- | for chip-free high-performance rabbeting of solid woods (free of knots) along and across the grain
- | for high-performance rabbeting of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | tool to be used on spindle tilted by 5°
- | resharpening area front 2.5 mm, peripheral side 3 mm

Advantages

- | maximum cutting quality on both rabbeting sides and maximum edge lives
- | chip-free cuts even on the exit side

Notes

- | recommended feed rate per tooth: wood-based panels 0.5 - 0.8 mm, solid wood 0.25 - 0.4 mm
- | clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

∅ D	L2	∅ d	L3	L1	Z	FB	FT	Shear∠	Ident-No. [R]
100	18,6	25	65	99	3+3	10	15	70	184731
100	28,3	25	65	110	3+3	16	25	70	184732 s
100	43	25	65	120	3+3	16	38	70	184733 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	

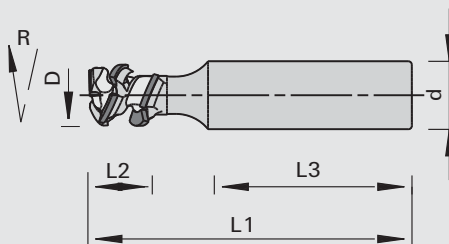
229344

p-System High-Performance Grooving Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for grooves, cut outs, pockets and as forend cutter
- | for chip-free high-performance grooving of solid woods (free of knots) along and across the grain
- | for high-performance grooving of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut

Advantages

- | maximum cutting quality and edge lives
- | chip-free cuts even on the exit side

Notes

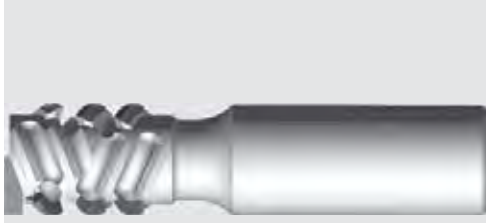
- | minimal grooving depth 0.5 mm
- | as from 25 mm Z=2 is possible, bottom cutting edge is Z=1 always
- | convex bottom cutting edge for better bottom quality of rabbet, however corner of rabbet not absolutely sharp
- | for ramping or circular plunging only
- | clamping element: precision clamping element e.g. ps-System, TRIBOS, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear∠	Resharpening area	Ident-No. [R]
8.0	3,3	10	50	65	1+1	70	0.4	186095
10	4,8	12	45	65	1+1	70	0.9	186096 s
10	10,4	12	45	70	1+1	70	0.9	186097
12	21,4	12	50	90	1+1	70	1.4	185506 s
12	10,2	16	45	80	1+1	70	1.4	185505
12	21,4	16	45	90	1+1	70	1.4	185507
16	14	16	45	85	1+1	70	1.9	185508
16	24,4	16	45	90	1+1	70	1.9	185509 s
16	32,2	16	45	90	1+1	70	1.9	186098
18	19	16	55	95	1+1	70	2.4	185612
18	7,0	20	55	90	1+1	70	2.4	185613
18	19	20	55	95	1+1	70	2.4	185614
25	9,4	25	50	95	1+1	70	2.4	185615 s
25	18	25	50	100	1+1	70	2.4	185616 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

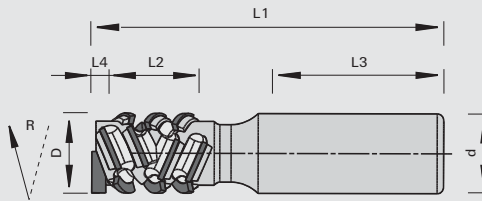
229324

p-System High-Performance Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | DP plunge tip

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | adjust the tool to run centrally to the workpiece
- | Tools with plunge tip (L4) must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, TRIBOS
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L4	L2	Ø d	L3	L1	Z	H	Shear∠	Resharpening area	Ident-No. [R]
12	3.1	13,5	16	45	85	1+1	10,5	70	1.5	185500 s
12	3.1	21,5	16	45	90	1+1	18,5	70	1.5	185501
14	3.4	27	16	45	100	1+1	24	70	1.8	185502
16	3.4	20,9	16	45	90	1+1	17,9	70	2.0	185503
16	3.4	26,1	16	45	100	1+1	23,1	70	2.0	185504
20	3.8	25,9	25	55	105	1+1	22,9	70	2.5	184379
20	3.8	29,5	25	55	110	1+1	26,5	70	2.5	184380
20	3.8	33,1	25	55	115	1+1	30,1	70	2.5	184381
25	3.8	26,5	25	55	105	2+2	23,5	70	2.5	184382
25	3.8	30,8	25	55	110	2+2	27,8	70	2.5	184383
25	3.8	48	25	55	130	2+2	45	70	2.5	184384
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[mm]	

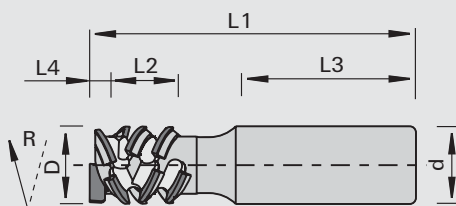
229324

p-System High-Performance Shank-Type Cutters CM DP - Weeke BHX 050/055

Product



Drawing



LEUCO
topline

LEUCO
p-system

Polycrystalline diamond [DP]

MEC

Machine / Application

- | WEEKE BHX 050 and BHX 055 with delivery date as from Sept. 01, 2015
- | BHX 50/055 machines with CNC controlled clamping devices (servo) and with delivery date as from 01.01.2014 only can be updated by the manufacturer (Note: Service charges will occur)
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | asymmetrical design
- | DP plunge tip

Advantages

- | maximum cutting quality and edge lives
- | chip-free cuts even on the exit side
- | increased contact pressure than conventional shank-type cutters

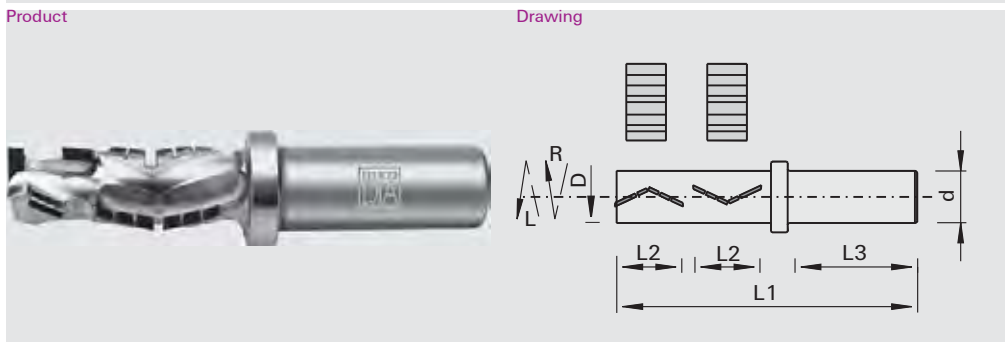
Notes

- | Tools with plunge tip (L4) must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, TRIBOS
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L4	L2	Ø d	L3	L1	Z	Shear◁	Resharpening area	Ident-No. [R]
20	4.0	25,1	25	51	105	1+1	70	2.5	185664
25	4.0	25,7	25	53	105	2+2+1	70	2.5	185663
25	4.0	30	25	53	110	2+2+1	70	2.5	185823 s
25	4.0	47,2	25	53	125	2+2+1	70	2.5	185824
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[mm]	

229020

Combination Shank-Type Router Bits RH-LH DP - Z=3/1



LEUCO DIA

Polycrystalline diamond [DP]

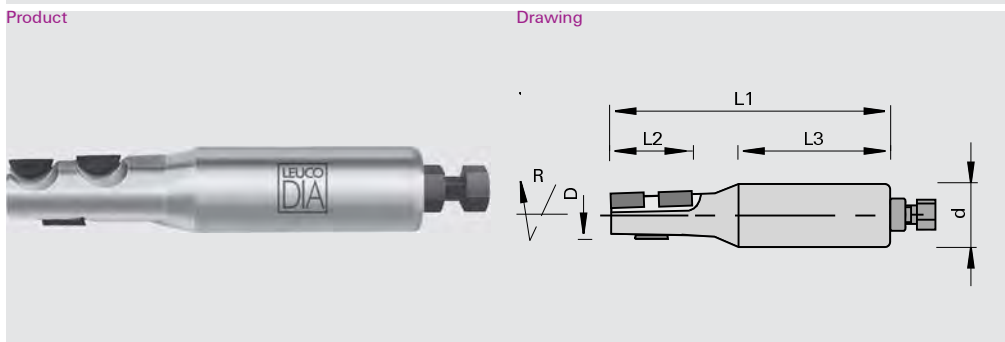
MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels high-performance tool for pre- and finish-milling 	<ul style="list-style-type: none"> Z=3 on right hand cutting section for highest feed rates Z=1 on left hand cutting section resharpenable area 3.2 mm 	<ul style="list-style-type: none"> lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle 	<ul style="list-style-type: none"> L2 eff. = L2 eff. = real cutting length; this tool has Z=3 the difference to L2 is Z=2; this allows the machining of all current panel boards workpiece secured on clamping blocks Clamping elements: ps-System, TRIBOS, draw-in collet chuck with thread for length adjusting screw

Ø D	L2		Ø d	L3	L1	Z	Ident-No.
25	2x22	L2 eff. 19.5 mm	25	62	129	3/1	179497 s
25	2x26	L2 eff. 23.3 mm	25	62	137	3/1	179498 s
25	2x30	L2 eff. 27 mm	25	62	145	3/1	179499
25	2x34	L2 eff. 31 mm	25	62	153	3/1	179500 s
[mm]	[mm]		[mm]	[mm]	[mm]		

229020

Conical Shank-Type Cutters DP - Z=1+1



LEUCO DIA

Polycrystalline diamond [DP]

MEC

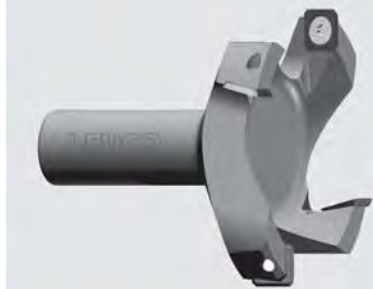
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> counter edge banding machines CNC routers for dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels 	<ul style="list-style-type: none"> max. feed speed 30m/min resharpenable area 2.2 mm n max = 18,000 min-1 	<ul style="list-style-type: none"> high feed speed possible 	<ul style="list-style-type: none"> the finishing of the contour requires further operations Clamping elements: ps-System, TRIBOS, draw-in collet chuck with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Tmax	Ident-No. [L]	Ident-No. [R]
18	36	25	65	120	1+1	32	182111 s	179024 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

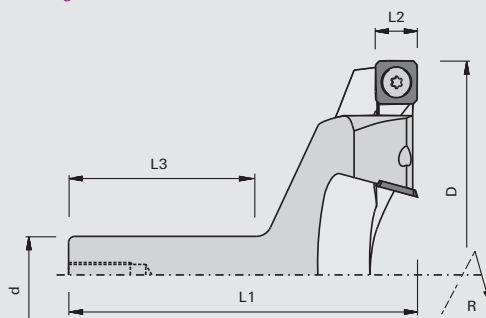
128200

Planing Shank-Type Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for planing and panel raising in wood-based materials
- l not suitable for rabbeting

Design

- l cutting material: HL Solid 20

Advantages

- l high milling performance when dressing the workbench boards, e.g. with Nesting technology
- l smooth surface thanks to special cutting edge geometry

Notes

- l with thread for length adjusting screw
- l sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
100	14	20	45	96	4	15200	182619 s
100	14	25	55	96	4	15200	182620
150	14	25	55	113	4	10100	182621 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives

B

H

S

Class-No.

PU

Ident-No.

14

14

2.0

150557

10

182441

[mm]

[mm]

[mm]

[pc.]

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws

M5x6 T20

995125

10

176199

Screwdrivers

T20x100

985730

1

166092

[mm]

[pc.]

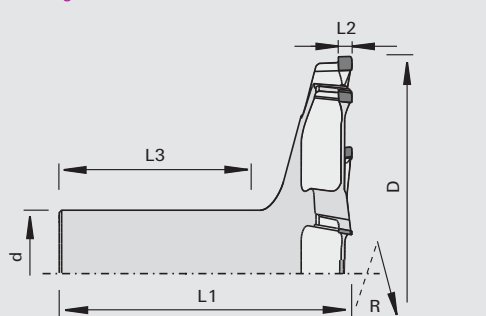
229020

Planing and Rabbeting Cutters DP

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC routers
- l for planing, rabbeting and panel raising in wood-based panels

Design

- l resharpening area 3.5 mm

Advantages

- l high milling performance when dressing the workbench boards, e.g. with Nesting technology
- l smooth surface thanks to special cutting edge geometry

Notes

- l with thread for length adjusting screw
- l sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
80	5,6	20	61.3	90	6	24000	182660 s
80	5,6	25	62	90	6	24000	182659 s
100	5,6	20	58.6	90	8	18000	182658
100	5,6	25	59.3	90	8	18000	182657 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

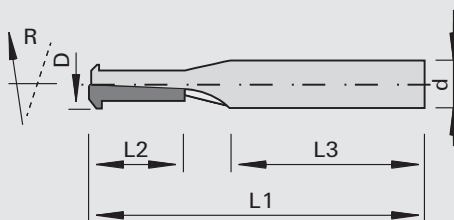
129610

Profile Grooving Shank-Type Cutters HW - for Lamello Clamex P®

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

5-axis CNC machines
for the milling of Lamello Clamex P® profile grooves
particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of bore type tool for Lamello Clamex P®

Design

HW-tipped
disposable tool

Advantages

problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with $D\varnothing 100,4$ mm)

Notes

depending on the type of workpiece a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

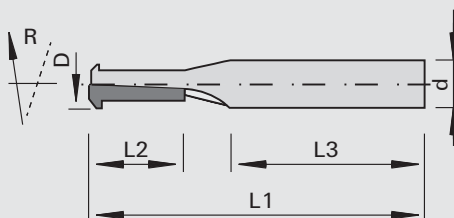
$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No.
10	20	10	40	70	1	185368
[mm]	[mm]	[mm]	[mm]	[mm]		

129660

Profile Grooving Shank-Type Cutters VHW - for Lamello Clamex P®

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

5-axis CNC machines
for the milling of Lamello Clamex P® profile grooves
particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of bore type tool for Lamello Clamex P®

Design

Massive solid tungsten carbide
Spiral design Z=2
TC 104 topcoat coating
Disposable tool
Not resharpenable

Advantages

High rigidity = low vibration even with difficult materials
Low cutting pressure and good cutting quality thanks to spiral design
Hard coating and additionally low coefficient of friction for longer edge life

Notes

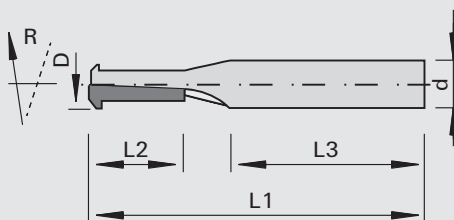
$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No.
9.8	23	12	36	80	2	186879
[mm]	[mm]	[mm]	[mm]	[mm]		

229268

Profile Grooving Shank-Type Cutters DP - for Lamello Clamex P®

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

- DP-tipped
- disposable tool

Advantages

- problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with DØ100,4 mm)

Notes

- depending on the type of workpiece a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

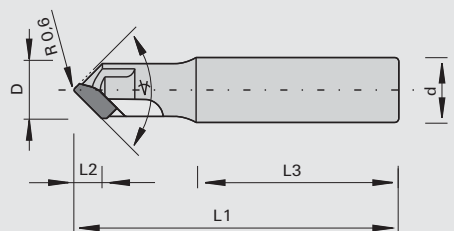
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	12	40	70	1	185703
[mm]	[mm]	[mm]	[mm]	[mm]		

229060

Relief-Picture Shank-Type Cutter DP - 90°

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- CNC machines
- for grooving operations in relief-picture technique (i.e. Pic2Plate)

Design

- cutting material: DP
- topline design
- resharpening area 2 mm

Advantages

- very long edge lives particularly in hard panel materials
- optimal cutting quality thanks to specialized blade preparation

Notes

- the relief-picture technique is a computer-based method to transfer image information by milling onto board materials
- clamping systems : precision clamping element e.g. TRIBOS or heat shrink-fit chuck

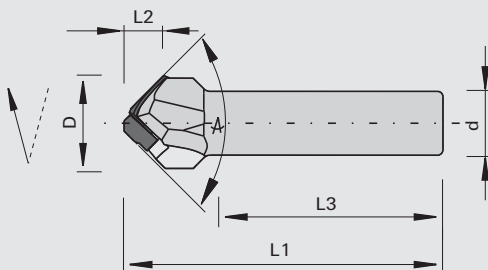
Ø D	L2	L3	Ø d	L1	Z	∠	Ident-No.
14	7,0	50	16	80	1	90	185156
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

229460

V-Groove Cutter DP for aluminum composite materials

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
| for V-grooves in aluminum composite materials (Alu-bond, Dibond, etc.)

Design

| cutting material: DP
| topline design
| resharpening area 2 mm

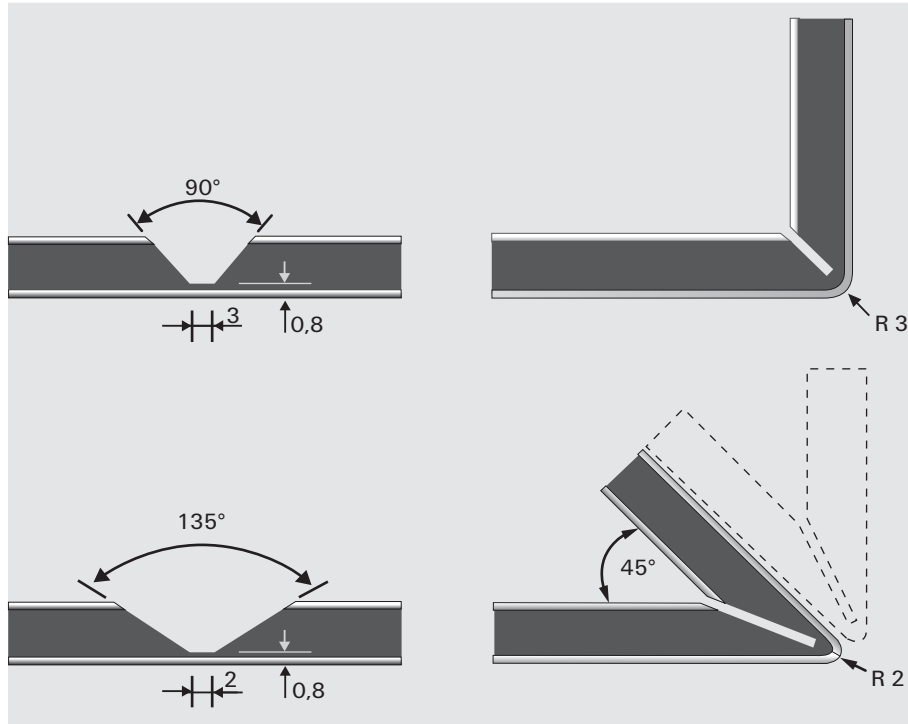
Advantages

| very long edge lives particularly in composite materials with mineral core
| optimal cutting quality thanks to polished face and special division of cut

Notes

| clamping elements: ideal use in precision clamping elements e.g. ps-System, TRIBOS or heat-shrinking chuck

∅ D	L2	L3	∅ d	L1	Z	∠	Ident-No.
18	7,5	40	12	60	1+1	90	186499
32	6,2	40	12	60	1+1	135	186500
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	



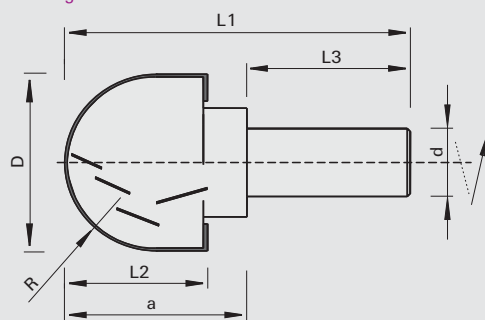
128660

Spherical Cutterhead HW

Product



Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC 5-axis routers
- l for milling shapes and contours in solid wood and wood-based panels
- l ideal for forms

Design

- l with shank
- l n max = 15,000 min-1

Advantages

- l high volume to be removed
- l simple tool change

Notes

- l ideal for the basic equipment of a 5-axis machine
- l clamping elements: ps-System, TRIBOS, heat-shrinking chuck, draw-in collet chucks

R	Ø D	L2	Ø d	L3	L1	Z	a	Ident-No.
32,5	65	52	25	60	127	2+2	67	185082
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives

B	H	S	R	Class-No.	PU	Ident-No.
20	12	1.5		150515	10	003082
20	11.5	1.5	30,7	151521	10	185083
[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts

Dimension

Class-No. PU Ident-No.

Screwdrivers	T15x80	985730	1	171188
Screwdrivers	SW3x100	985730	1	166090
	[mm]		[pc.]	

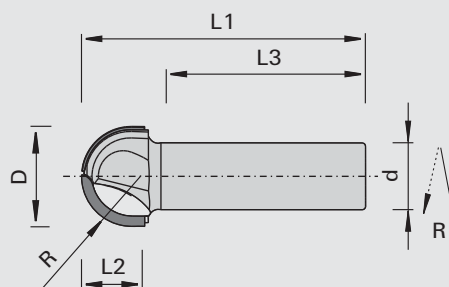
229560

DIAMAX Spherical Shank-Type Cutters DP

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC machines
- l for contour milling and template copying
- l for 3D-milling work, 3D-models, relief-milling work

Design

- l TOPLINE design
- l resharping area 1.5 mm
- l n max = 24,000 min-1

Advantages

- l long edge lives
- l high quality of cut thanks to polished cutting edges and ultra-fine eroding of back of the tooth

Notes

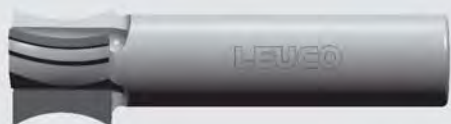
- l clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

R	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	14	20	55	85	2	185240
15	30	19	20	55	85	2	185241
20	40	24	20	55	85	2	185242
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

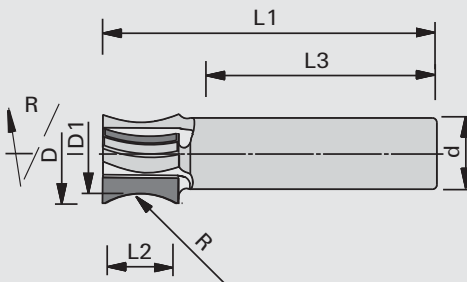
229360

High-Performance Radius Shank-Type Cutters DP - for the machining of solid core panels

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for slight rounding of wood-based panels, solid wood and plastic
- | especially suited for the machining of plastic solid core panels (e.g. Trespa, Corian, Varicor, LG-HiMacs, etc.)
- | for panel thickness up to 14 mm

Design

- | high-performance tool for finish milling, Z=3
- | with alternating shear angle
- | without plunge tip
- | polished face
- | radius R=16
- | n max = 24,000 min⁻¹

Advantages

Notes

- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | with thread for length adjusting screw

R	Ø D	Ø D1	L2	Ø d	L3	L1	Z	Resharpener area	Ident-No.
16	22.3	18	14	16	55	75	3	1.5	R 186578
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

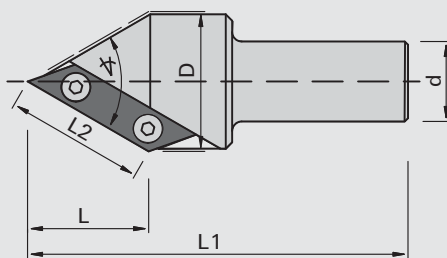
128410

Folding Chamfering Cutterheads HW - Z=1

Product



Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC 5-axis routers
 | for picking of internal corners and for chamfering, for the cutting of ornamental grooves and folding cuts in solid wood and wood-based panels

Design

| with shank
 | n max = 18,000 min-1

Advantages

| Angle of attack for corner scribing: 45°

Notes

| please order adapters separately
 | clamping elements: ps-System, TRIBOS, heat-shrinking chuck, draw-in collet chucks

Wedge<	Ø D	L2	L	Ø d	L1	Z	Ident-No.
60	41.5	41,3	35.5	20	118	1	185459
60	41.5	41,3	35.5	25	118	1	185138
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

B	H	S	Class-No.	PU	Ident-No.
50	12	1.5	150515	10	185140
[mm]	[mm]	[mm]		[pc.]	

Spare parts

Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3,5x4 T15	995195	10 168893
Screwdrivers	T15	985730	1 163161
	[mm]		[pc.]

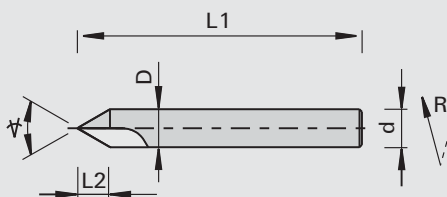
129310

Folding Chamfering Shank-Type Cutters VHW - Z=2

Product



Drawing



LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC 5-axis routers
 | for picking of internal corners especially in small, narrow cut-outs
 | for chamfering, for ornamental grooves and folding cuts in solid wood and wood-based panels

Design

| throughout cylindrical solid carbide body
 | for mechanical feed
 | righthand rotation
 | n max = 20,000 min-1

Advantages

| Angle of attack for corner scribing: 45°

Notes

| clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", TRIBOS or heat shrink-fit chucks

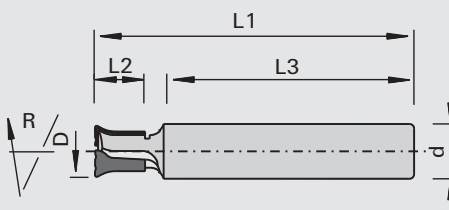
Wedge<	Ø D	L2	Ø d	L1	Z	Ident-No. [L]	Ident-No. [R]
60	16	14	16	120	2	185793	185794
[°]	[mm]	[mm]	[mm]	[mm]			

229262

Shank-Type Cutters DP for fischer® undercut anchors

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC machining centers
- | for production of undercut bore holes for the fischer® undercut anchor type FZP II- (T) M6 (fischer Zykon panel anchors)
- | for facade materials made of mineral based materials, high-pressure laminate (HPL) or fiber cement boards (FC)

Design

- | high-strength tool body
- | special cutting edge geometry
- | cutting material: DP
- | LEUCO topline version
- | not resharpenable
- | n max = 24,000 min-1

Advantages

- | very long edgelifetime and thus considerably lower costs per hole compared to conventional solid carbide cutters
- | reduced coefficient of friction for lowest possible heat generation
- | high stiffness for excellent stability
- | optimum cutting quality thanks to special tooth geometry

Notes

- | Information regarding the application conditions (e.g. of floating milling aggregates), inspection and measuring tools, test instructions regarding the drilling holes and the safe fit of the anchors are available from ACT@fischer.de upon request
- | if the cutter is not used in a floating trimming unit but in a main spindle, the use of highly precise clamping devices such as the hydro expansion chuck "ps-System", the Power Shrink Chuck TRIBOS or the a heat-shrinking chuck is recommended

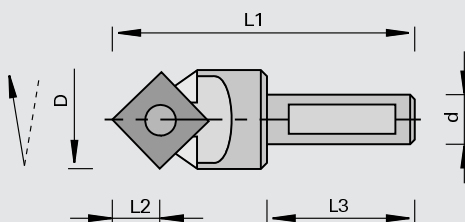
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
11.2	11	12	53	70	2	R 185869
[mm]	[mm]	[mm]	[mm]	[mm]		

128415

Ornamental Groove Cutters with HW turnover knives

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for cutting of ornamental grooves, inscriptions and engravings in solid woods and wood-based panels

Design

- | with negative shear angle

Advantages

- | combination with other shank-type tools allows 2 processes on one spindle
- | chip-free cutting of laminated panels thanks to negative shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, draw-in collet chuck for combination with cutterheads as tool set
- | included in delivery: Ident-No. 186880 SP16 cutter assembly with TOK Ident-No. 003080 or set Ident-No. 171217 see profile drawings

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No.
17	8,3	10	40	67	1	SP 16	186880
[mm]	[mm]	[mm]	[mm]	[mm]		Set	171217 &
						[Foil]	

Turnover Knives	B	H	S	Drawing/Foil	Class-No.	PU	Ident-No.
	12	12	1.5	SP 16	150515	10	003080
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Head Cap Screws	M3,5x6,5 T15	995115	10	163223
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

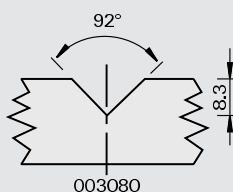
150514 / 151521

Profile Knives HW for ornamental groove cutterheads

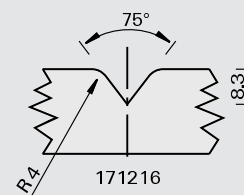
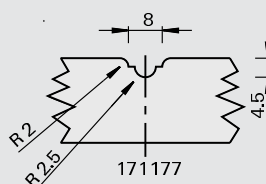
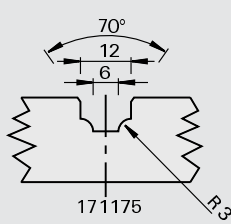
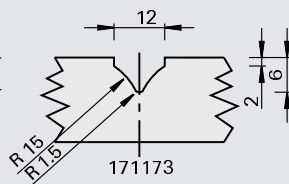
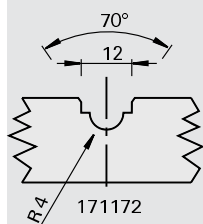
Product



Drawing



Tungsten Carbide [HW]



Machine / Application

Design

Advantages

Notes

included in delivery of set
 Ident-No.171217: 1 piece
 ornamental groove cutter with
 shank (Ident-No.171169)
 / 1 piece turnover knife
 12x12x1.5 (Ident-
 No.003080) / 2 pieces each
 double-sided profile knives
 Class-No. 151521 (Ident- No.
 and drawing as shown)

B	H	S	Drawing	Ident-No.
12	12	1.5	SP 16	003080
11	12	1.5		171172
11	12	1.5		171173
11	12	1.5		171175
12	12	1.5		171177
12	12	1.5		171216
[mm]	[mm]	[mm]	[Foil]	

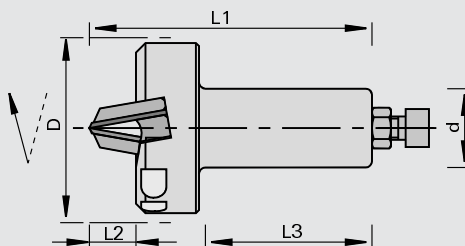
128612

Ornamental Groove Shank-Type Cutterheads SuperProfiler HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for cutting of ornamental grooves in solid woods and wood-based panels

Design

- l with positive shear angle
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l n max = 18,000 min-1

Advantages

- l cutterhead for mounting of several profile knives

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- l included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No. unprofiled
59	13	25	62	97	2	SP 17	173268
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 17	152526	10	179114
SP blanks	30,6	25.5	HL Solid 60	SP 17	152529	10	177369
support plates	30	18		SP 17	925402	2	178017
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=24	925300	2	173276
Set Screws	M6x10 DIN EN ISO 4028	995161	10	180002
Screwdrivers	SW3x100	985730	1	166090
	[mm]		[pc.]	

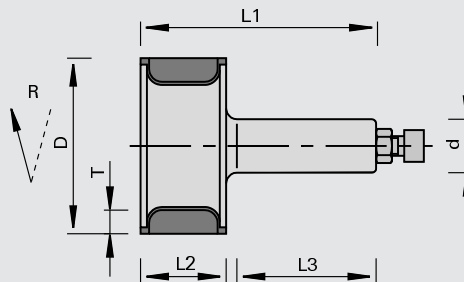
128612

SuperProfiler Shank-Type Cutterheads HW

Product



Drawing



**SUPER
PROFILER**

Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood materials

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled according to customer specifications
- Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
82	40	20	55	110	11	2	12000	SP 19		167479 s
82	40	25	55	110	11	2	18000	SP 19	167835 s	167834
82	40	MK 2	55	127	11	2	18000	SP 19		167483 s
86	60	25	55	130	13	2	10000	SP 31		176241
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 19	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 19	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 31	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 31	152529	10	177368
support plates	40	26.5		SP 19	925402	2	178007
support plates	60	28.5		SP 31	925402	2	178008
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167835	925300	2	166736
Pressure Bars	36x12x8	167479, 167483, 167834	925300	2	166737
Pressure Bars	58x12x8	176241	925300	2	166738
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

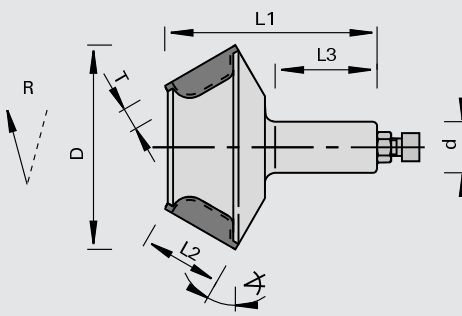
128612

SuperProfiler Shank-Type Cutterheads HW - cranked

Product



Drawing



**SUPER
PROFILER**

Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for profiling of solid woods and wood materials

Design

- l cranked body
- l cutting edges parallel to cutter axis
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l Ø 100 mm and 110 mm: n max = 12,000 min-1
- l Ø 125 mm: n max = 8,000 min-1

Advantages

- l for deep profiles

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- l included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	Drawing	Ident-No. unprofiled
100	40	25	55	119	11	2	SP 18	168184 s
110	40	25	55	120	11	2	SP 27	176235 s
125	60	25	55	140	13	2	SP 28	176237 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 18 / 27	152526	10	179112
SP blanks	40,6	28.2	HL Solid 60	SP 18 / 27	152529	10	177367
SP blanks	60,8	30.2	HL Board 06	SP 28	152526	10	179113
SP blanks	60,8	30.2	HL Solid 60	SP 28	152529	10	177368
support plates	40	26.5		SP 18 / 27	925402	2	178007
support plates	60	28.5		SP 28	925402	2	178008
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	168184, 176235	925300	2	166737
Pressure Bars	58x12x8	176237	925300	2	166738
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422
Screwdrivers	SW4x100	For all	985730	1	166091
	[mm]			[pc.]	

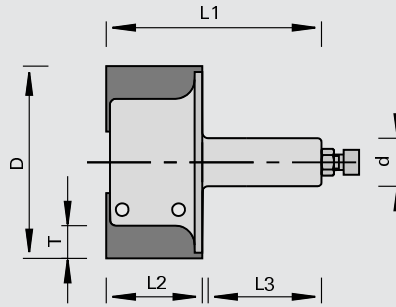
128612

SuperProfiler Shank-Type Cutterheads HW - open on one side

Product



Drawing


**SUPER
PROFILER**

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for profiling of solid woods and wood materials

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | for profiles requiring a cutter body which is open on one side
- | profile knife can be profiled according to customer specifications
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [R] unprofiled
60	30	16	43	89.6	11	2	12000	SP 23	171033 s
100	50	25	55	112	16	2	9500	SP 21	171143
120	50	25	55	109	22	2	6500	SP 20	173271 s
120	60	25	55	118	22	2	6000	SP 22	173270 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 23	152526	10	179114
SP blanks	30,6	25.5	HL Solid 60	SP 23	152529	10	177369
SP blanks	49,3	33.7	HL Board 06	SP 21	152526	10	180199
SP blanks	49,4	44.5	HL Board 06	SP 20	152526	10	180218
SP blanks	60,6	45.6	HL Board 06	SP 22	152526	10	179999
SP blanks	60,6	45.6	HL Solid 60	SP 22	152529	10	178845
support plates	30	23.8		SP 23	925402	2	178016
support plates	48	33		SP 21	925402	2	178015
support plates	47	43		SP 20	925402	2	178014
support plates	56	43		SP 22	925402	2	178010
	[mm]	[mm]					[pc.]

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	28x10x7	171033	925300	2	171035
Pressure Bars	48x12x8	171143	925300	2	171147
Pressure Bars	47x14x8	173271	925300	2	171140 s
Pressure Bars	56x12x8	173270	925300	2	167055
Set Screws	M6x10 DIN EN ISO 4028	171033	995161	10	180002
Set Screws	M8x16 DIN EN ISO 4028	171143, 173270, 173271	995161	10	164422
Screwdrivers	SW3x100	171033	985730	1	166090
Screwdrivers	SW4x100	171143, 173270, 173271	985730	1	166091
	[mm]				[pc.]

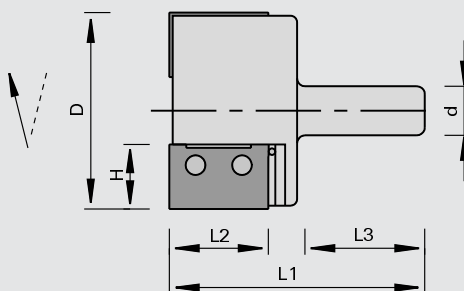
128613

EcoPro-Shank-Type Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
62	30	25	25	60	107	2	18000	EP 375	178594 s	178375 s
75	30	30	25	60	107	2	16000	EP 376	178597 s	178376 s
62	40	20	25	60	117	2	18000	EP 377	178592 s	178377 s
75	40	30	25	60	117	2	14000	EP 378	178598 s	178378 s
62	50	20	25	60	127	2	16000	EP 379	178593 s	178379 s
75	50	33	25	60	127	2	12000	EP 380	178600 s	178380 s
85	50	33	25	60	127	2	12000	EP 386	178603 s	178386 s
75	40	32.5	25	60	118	2	12300	EP 478	180332 s	180328 s
85	60	34	25	60	137	2	10000	EP 405	181247 s	181246 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

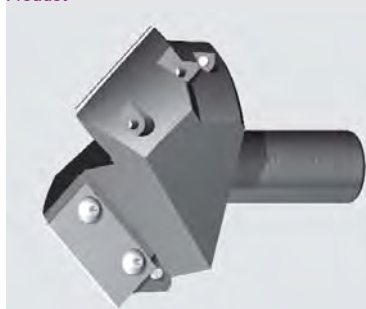
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
178375, 178594	30,2	25.5	HL Board 06	152586	10		178527
178375, 178594	30,2	25.5	HL Solid 60	152589	10		179527
178376, 178597	30,2	30.4	HL Board 06	152586	10		178528
178376, 178597	30,2	30.4	HL Solid 60	152589	10		179528
178377, 178592	40,1	20.9	HL Board 06	152586	10		178533
178377, 178592	40,1	20.9	HL Solid 60	152589	10		179533
180328, 180332	41	32.5	HL Board 06	152536	10		180197
178378, 178598	40,1	30.4	HL Board 06	152586	10		178534
178378, 178598	40,1	30.4	HL Solid 60	152589	10		179534
178379, 178593	49,9	20.9	HL Board 06	152586	10		178539
178379, 178593	49,9	20.9	HL Solid 60	152589	10		179539
178380, 178386, 178600, 178603	49,9	33	HL Board 06	152586	10		178540
178380, 178386, 178600, 178603	49,9	33	HL Solid 60	152589	10		179540
181246, 181247	61	34	HL Board 06	152536	10		180198
178375, 178594	30,2	25.5	HL Board 06 topline	152786	10	179583 &	179584 &
178375, 178594	30,2	25.5	HL Solid 60 topline	152789	10	179657 &	179658 &
178376, 178597	30,2	30.4	HL Board 06 topline	152786	10	179585 &	179586 &
178376, 178597	30,2	30.4	HL Solid 60 topline	152789	10	179659 &	179660 &
178377, 178592	40,1	20.9	HL Board 06 topline	152786	10	179595 &	179596 &
178377, 178592	40,1	20.9	HL Solid 60 topline	152789	10	179669 &	179670 &
178378, 178598	40,1	30.4	HL Board 06 topline	152786	10	179597 &	179598 &
178378, 178598	40,1	30.4	HL Solid 60 topline	152789	10	179671 &	179672 &
178379, 178593	49,9	20.9	HL Board 06 topline	152786	10	179607 &	179608 &
178379, 178593	49,9	20.9	HL Solid 60 topline	152789	10	179681 &	179682 &
178380, 178386, 178600, 178603	49,9	33	HL Board 06 topline	152786	10	179609 &	179610 &
	[mm]	[mm]				[pc.]	

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
178380, 178386, 178600, 178603	49,9	33	HL Solid 60 topline	152789	10	179683 &	179684 &
181246, 181247	61	34	HL Board 06 topline	152736	10	181259	181258
	[mm]	[mm]				[pc.]	
Spare parts			Dimension	Class-No.	PU	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	10	178239	
Screwdrivers			T15x80	985730	1	171188	
			[mm]			[pc.]	

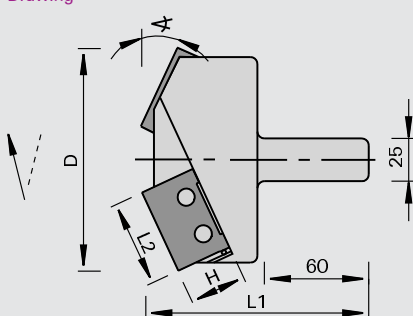
128663


EcoPro-Shank-Type Cutterheads HW - cranked

Product



Drawing





Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- with shear angle
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Crank- α	$\varnothing D$	L2	H	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
60	100	30	25	104	2	11000	EP 387	178604 s	178387 s
60	100	30	30	107	2	9500	EP 388	178606 s	178388 s
60	100	40	20	110	2	13000	EP 389	178605 s	178389 s
60	100	50	20	119	2	11000	EP 391	178607 s	178391 s
60	125	50	33	127	2	7500	EP 392	178609 s	178392 s
45	100	30	25	104	2	10000	EP 393	178610 s	178393 s
45	100	30	30	107	2	9000	EP 394	178611 s	178394 s
45	100	40	20	110	2	13000	EP 395	178612 s	178395 s
45	125	50	20	114	2	10000	EP 397	178614 s	178397 s
45	125	50	33	121	2	7500	EP 398	178615 s	178398 s
45	125	40	32.5	115	2	11000	EP 496	180335 s	180331 s
25	140	60	34	137	2	10000	EP 410	181249 s	181248 s
45	145	60	34	132	2	10000	EP 408	181251 s	181250 s
60	145	60	34	137	2	10000	EP 407	181253 s	181252 s
75	125	60	34	133	2	10000	EP 406	181255 s	181254 s
[°]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
178387, 178393, 178604, 178610	30,2	25.5	HL Board 06	152586	10		178527
178387, 178393, 178604, 178610	30,2	25.5	HL Solid 60	152589	10		179527
178388, 178394, 178606, 178611	30,2	30.4	HL Board 06	152586	10		178528
178388, 178394, 178606, 178611	30,2	30.4	HL Solid 60	152589	10		179528
	[mm]	[mm]					[pc.]

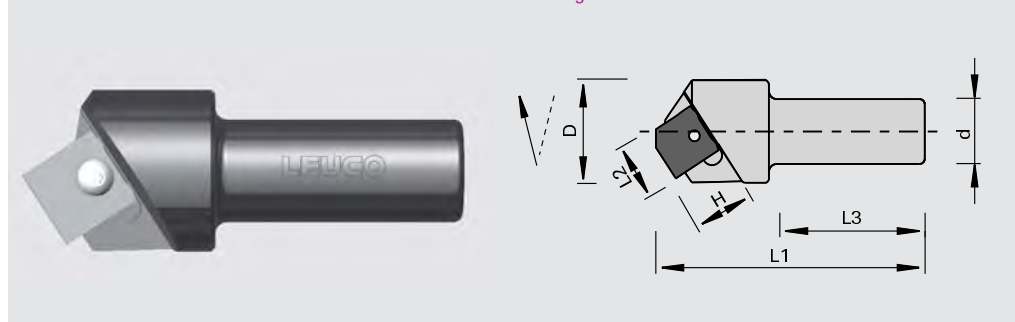
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
178389, 178395, 178605, 178612	40,1	20,9	HL Board 06	152586	10		178533
178389, 178395, 178605, 178612	40,1	20,9	HL Solid 60	152589	10		179533
180331, 180335	41	32,5	HL Board 06	152536	10		180197
178391, 178397, 178607, 178614	49,9	20,9	HL Board 06	152586	10		178539
178391, 178397, 178607, 178614	49,9	20,9	HL Solid 60	152589	10		179539
178392, 178398, 178609, 178615	49,9	33	HL Board 06	152586	10		178540
178392, 178398, 178609, 178615	49,9	33	HL Solid 60	152589	10		179540
181248, 181249, 181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06	152536	10		180198
178387, 178393, 178604, 178610	30,2	25,5	HL Board 06 topline	152786	10	179583 &	179584 &
178387, 178393, 178604, 178610	30,2	25,5	HL Solid 60 topline	152789	10	179657 &	179658 &
178388, 178394, 178606, 178611	30,2	30,4	HL Board 06 topline	152786	10	179585 &	179586 &
178388, 178394, 178606, 178611	30,2	30,4	HL Solid 60 topline	152789	10	179659 &	179660 &
178389, 178395, 178605, 178612	40,1	20,9	HL Board 06 topline	152786	10	179595 &	179596 &
178389, 178395, 178605, 178612	40,1	20,9	HL Solid 60 topline	152789	10	179669 &	179670 &
178391, 178397, 178607, 178614	49,9	20,9	HL Board 06 topline	152786	10	179607 &	179608 &
178391, 178397, 178607, 178614	49,9	20,9	HL Solid 60 topline	152789	10	179681 &	179682 &
178392, 178398, 178609, 178615	49,9	33	HL Board 06 topline	152786	10	179609 &	179610 &
178392, 178398, 178609, 178615	49,9	33	HL Solid 60 topline	152789	10	179683 &	179684 &
181248, 181249, 181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06 topline	152736	10	181259	181258
	[mm]	[mm]			[pc.]		
Spare parts			Dimension	Class-No.	PU	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	10	178239	
Screwdrivers			T15x80	985730	1	171188	
			[mm]			[pc.]	

128663

EcoPro-Shank-Type Cutterheads HW for ornamental grooves - Z1

Product

Drawing



LEUCO DUR
Tungsten Carbide [HW]
MEC

Machine / Application

| CNC routers
| for cutting of ornamental grooves in solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
| cutting material: HW HL Solid 60 for soft woods
| shank with internal thread M8 for attachment screw
| with shear angle

Advantages

| optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
| cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
| cutterhead body can be used only for one profile
| please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [R] unprofiled
35	20	20	25	60	98.5	1	24000	EP 400	180539 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
For all	20,3	20,5	HL Board 06	152586	10		178517
For all	20,3	20,5	HL Solid 60	152589	10		179517
For all	20,3	20,5	HL Board 06 topline	152786	10	179563 &	179564 &
For all	20,3	20,5	HL Solid 60 topline	152789	10	179637 &	179638 &
	[mm]	[mm]					[pc.]

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

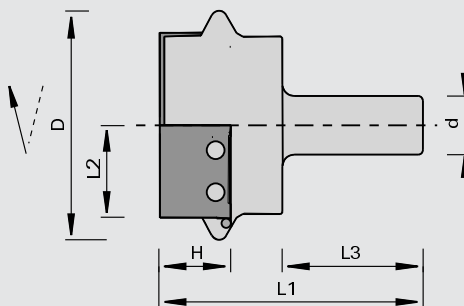
128663

EcoPro-Shank-Type Cutterheads HW for large ornamental grooves - Z2

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for cutting of big ornamental grooves in solid woods and wood-based panels

Design

- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l shank with internal thread M8 for attachment screw
- l with shear angle

Advantages

- l optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- l cutterhead body and knives will be profiled according to customer specifications

Notes

- l profile knives can be profiled according to customer specifications
- l cutterhead body can be used only for one profile
- l please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
76	30	25	25	60	101	2	18000	EP 401	180298 s	180299 s
76	30	30	25	60	109	2	18000	EP 403	180296 s	180297 s
100	40	30	25	60	112	2	14000	EP 402	178401 s	178402 s
120	50	33	25	60	122	2	9000	EP 404	178403 s	178404 s
143	60	34	25	60	122	2	12000	EP 409	181257 s	181256 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
180298, 180299	30,2	25,5	HL Board 06	152586	10		178527
180298, 180299	30,2	25,5	HL Solid 60	152589	10		179527
180296, 180297	30,2	30,4	HL Solid 60	152589	10		179528
180296, 180297	30,2	30,4	HL Board 06	152586	10		178528
178401, 178402	40,1	30,4	HL Board 06	152586	10		178534
178401, 178402	40,1	30,4	HL Solid 60	152589	10		179534
178403, 178404	49,9	33	HL Board 06	152586	10		178540
178403, 178404	49,9	33	HL Solid 60	152589	10		179540
181256, 181257	61	34	HL Board 06	152536	10		180198
180298, 180299	30,2	25,5	HL Board 06 topline	152786	10	179583 &	179584 &
180298, 180299	30,2	25,5	HL Solid 60 topline	152789	10	179657 &	179658 &
180296, 180297	30,2	30,4	HL Board 06 topline	152786	10	179585 &	179586 &
180296, 180297	30,2	30,4	HL Solid 60 topline	152789	10	179659 &	179660 &
178401, 178402	40,1	30,4	HL Board 06 topline	152786	10	179597 &	179598 &
178401, 178402	40,1	30,4	HL Solid 60 topline	152789	10	179671 &	179672 &
178403, 178404	49,9	33	HL Board 06 topline	152786	10	179609 &	179610 &
178403, 178404	49,9	33	HL Solid 60 topline	152789	10	179683 &	179684 &
181256, 181257	61	34	HL Board 06 topline	152736	10	181259	181258
	[mm]	[mm]			[pc.]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

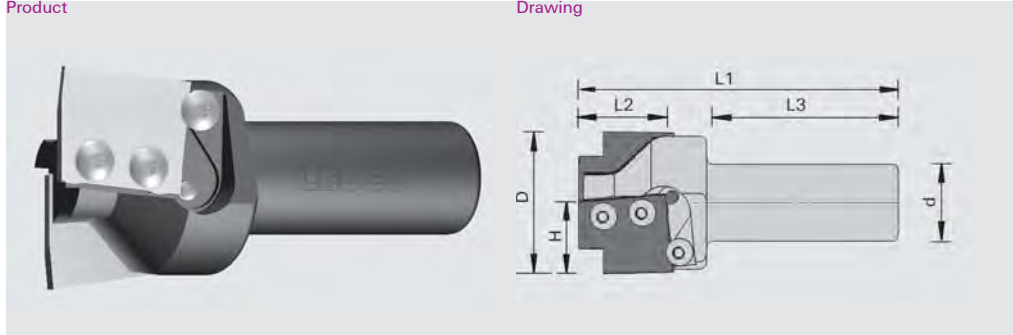
Screws	M4,5x4,6x9 T15	995195	10	178239
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

128663

EcoPro-Shank-Type Cutterheads HW - Z2

Product

Drawing



LEUCODUR
Tungsten Carbide [HW]
MEC

Machine / Application

| CNC routers
| for cutting of ornamental grooves in solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
| cutting material: HW HL Solid 60 for soft woods
| shank with internal thread M8 for attachment screw

Advantages

| cutterhead body and knives will be profiled according to customer specifications
| inserts cutting beyond center

Notes

| profile knives can be profiled according to customer specifications
| cutterhead body can be used only for one profile
| please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
44 [mm]	28 [mm]	25 [mm]	25 [mm]	60 [mm]	103.5 [mm]	2	24000 [min-1]	EP 399 [Foil]	181839 s	181838 s

Blanks	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
For all	30,2	25.5	HL Board 06	152586	10		178527
For all	30,2	25.5	HL Solid 60	152589	10		179527
For all	30,2	25.5	HL Board 06 topline	152786	10	179583 &	179584 &
For all	30,2	25.5	HL Solid 60 topline	152789	10	179657 &	179658 &
	[mm]	[mm]			[pc.]		

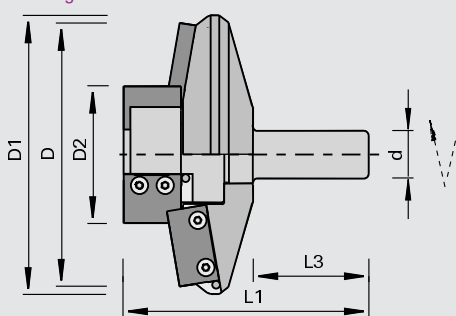
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

128913

EcoPro-Shank-Type Cutterheads HW for panel raising top side

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods
- for panel raising profiles
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
140	150	82	25	60	122	2+2	7600	EP 751 (EP 754+757)	179369 s	178751 s
137	145	71.6	25	60	122	2+2	11500	EP 752 (EP 755+758)	179370 s	178752 s
137	145	71.2	25	60	127	2+2	11500	EP 753 (EP 756+758)	179371 s	178753 s
142	144	82	25	60	123	2+2	10000	EP 849 (EP 754+855)	179372 s	178849 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
178753, 179371	30,2	25,5	HL Board 06	152586	10		178527
178753, 179371	30,2	25,5	HL Solid 60	152589	10		179527
178751, 178752, 178849, 179369, 179370	30,2	30,4	HL Board 06	152586	10		178528
178751, 178752, 178849, 179369, 179370	30,2	30,4	HL Solid 60	152589	10		179528
178752, 178753, 179370, 179371	40,1	20,9	HL Board 06	152586	10		178533
178752, 178753, 179370, 179371	40,1	20,9	HL Solid 60	152589	10		179533
178751, 179369	40,1	30,4	HL Board 06	152586	10		178534
178751, 179369	40,1	30,4	HL Solid 60	152589	10		179534
178849, 179372	49,9	20,9	HL Board 06	152586	10		178539
178849, 179372	49,9	20,9	HL Solid 60	152589	10		179539
178753	30,2	25,5	HL Board 06 topline	152786	10	179583 &	179584 &
178753	30,2	25,5	HL Solid 60 topline	152789	10	179657 &	179658 &
178751, 178752, 178849	30,2	30,4	HL Board 06 topline	152786	10	179585 &	179586 &
178751, 178752, 178849	30,2	30,4	HL Solid 60 topline	152789	10	179659 &	179660 &
178752, 178753	40,1	20,9	HL Board 06 topline	152786	10	179595 &	179596 &
178752, 178753	40,1	20,9	HL Solid 60 topline	152789	10	179669 &	179670 &
178751	40,1	30,4	HL Board 06 topline	152786	10	179597 &	179598 &
178751	40,1	30,4	HL Solid 60 topline	152789	10	179671 &	179672 &
178849, 179372	49,9	20,9	HL Board 06 topline	152786	10	179607 &	179608 &
178849, 179372	49,9	20,9	HL Solid 60 topline	152789	10	179681 &	179682 &
	[mm]	[mm]				[pc.]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

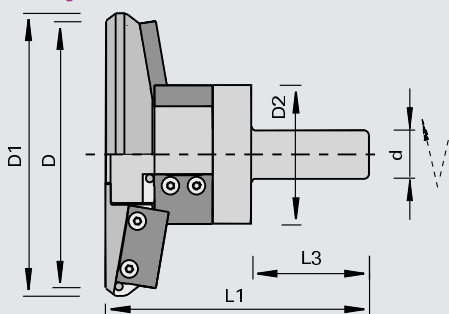
Screws	M4,5x4,6x9 T15	995195	10	178239
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

128913

EcoPro-Shank-Type Cutterheads HW for panel raising bottom side

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

CNC routers
for profiling of solid woods and wood-based panels

Design

cutting material: HW HL Board 06 for hard woods and wood-based panels
cutting material: HW HL Solid 60 for soft woods
shank with internal thread M8 for attachment screw

Advantages

optimum cutting quality even when cutting across the grain of solid woods
for panel raising profiles
cutterhead body and knives will be profiled according to customer specifications

Notes

profile knives can be profiled according to customer specifications
cutterhead body can be used only for one profile
please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
142	144	82	25	60	143	2+2	10000	EP 853 (EP 854+855)	178853 s	179373 s
150	140	82	25	60	143	2+2	7600	EP 848 (EP 854+757)	178848 s	179374 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
For all	30,2	30,4	HL Board 06	152586	10		178528
For all	30,2	30,4	HL Solid 60	152589	10		179528
178848, 179374	40,1	30,4	HL Board 06	152586	10		178534
178848, 179374	40,1	30,4	HL Solid 60	152589	10		179534
178853, 179373	49,9	20,9	HL Board 06	152586	10		178539
178853, 179373	49,9	20,9	HL Solid 60	152589	10		179539
For all	30,2	30,4	HL Board 06 topline	152786	10	179585 &	179586 &
For all	30,2	30,4	HL Solid 60 topline	152789	10	179659 &	179660 &
178848, 179374	40,1	30,4	HL Board 06 topline	152786	10	179597 &	179598 &
178848, 179374	40,1	30,4	HL Solid 60 topline	152789	10	179671 &	179672 &
178853, 179373	49,9	20,9	HL Board 06 topline	152786	10	179607 &	179608 &
178853, 179373	49,9	20,9	HL Solid 60 topline	152789	10	179681 &	179682 &
	[mm]	[mm]			[pc.]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M4,5x4,6x9 T15	995195	10	178239
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

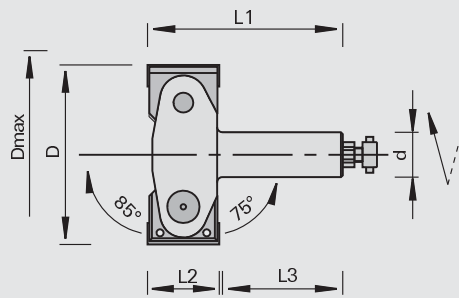
128715

Chamfering Cutterheads HW - pivoting from 0-85 degrees

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | CNC routers
- | routers
- | for jointing, chamfering and panel raising in solid woods and wood-based panels
- | for rabbeting with turnover knife Ident-No. 171149

Design

- | cutting edges parallel to cutter axis
- | chamfer angle progressively adjustable from 0-85 degrees on high-precision scale
- | n max = 12,000 min-1

Advantages

- | universal application

Notes

- | for manual feed
- | clamping elements: ps-System, TRIBOS, draw-in collet chuck

Ø D	Ø Dmax	L2	Ø d	L3	L1	Z	Ident-No.
100	117	40	25	55	110	2	172271
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	40	12	1.5	150515	10	164078
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	38x10,5x6	925300	2	172272
Set Screws	M6x12 DIN EN ISO 4028	995161	10	180214
Screwdrivers	SW3x100	985730	1	166090
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	1	009677 s
Retaining Bolts	M8x25	995190	10	172828
	[mm]		[pc.]	

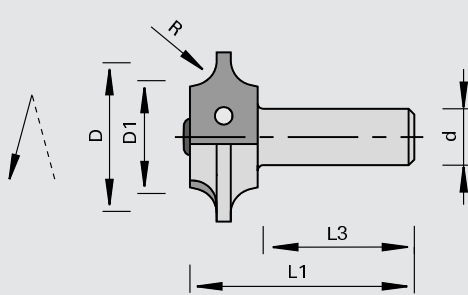
128310

Rounding Cutterheads HW - HOLZ-HER

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

| edgebanders HOLZ-HER
 | for rounding and chamfering of
 solid wood, veneer and plastic
 edge bands

Design

| cutting edges parallel to cutter
 axis
 | cutting material: HW HL Board
 05
 | n max = 30,000 min⁻¹

Advantages

| same cutter head body for
 radius 1 - 5 mm and chamfer

Notes

| clamping elements: draw-in
 collet chuck

R	Ø D	Ø D1	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
2,0	30.8	18,85	8,0	22	43	2	170315	170316
3,0	30.8	18,85	8,0	22	43	2	170317 &	170318 &
4,0	30.8	18,85	8,0	22	43	2		170320 &
5,0	30.8	18,85	8,0	22	43	2		170322 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	Chamfer <	R	B	H	S	Class-No.	PU	Ident-No.
Chamfering Knives	45		16	17.5	2.0	151545	10	170329
Radius Knives		1,0	16	17.5	2.0	151545	10	186745
Radius Knives		2,0	16	17.5	2.0	151545	10	163489
Radius Knives		3,0	16	17.5	2.0	151545	10	163490
Radius Knives		4,0	16	17.5	2.0	151545	10	163491
Radius Knives		5,0	16	17.5	2.0	151545	10	163492
	[°]	[mm]	[mm]	[mm]	[mm]		[pc.]	

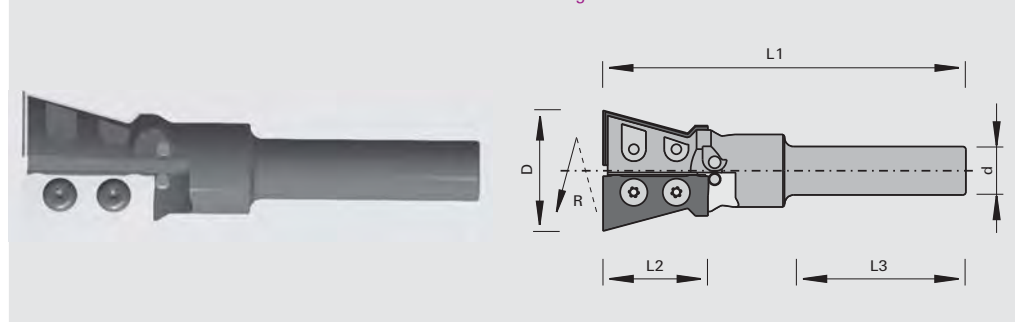
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

128610

Dove-tail Cutterheads with HW Knives

Product

Drawing



LEUCO DUR
Tungsten Carbide [HW]
MEC

Machine / Application

| joinery machines Weinmann
 | for joining of construction
 timber and for machining of
 solid wood

Design

| cutting edges parallel to cutter
 axis
 | cutting material: HW HL Solid
 20
 | n max = 17,800 min-1

Advantages

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]
40	34,7	16	56	120	2	185617
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
without serration	34,9	18.6	2.0	151557	3	185363
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

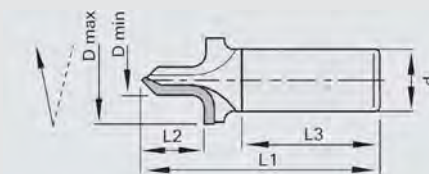
229063 / 229363

LEUCODIA Profiler

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	25	12	45	85	1	18000	DP1A
35	12	25	16	45	85	1	24000	DP1A
35	12	25	20	45	95	1	24000	DP1A
35	12	25	25	55	95	1	24000	DP1A
26	10	25	12	35	75	1	24000	DP1AK
26	10	25	16	45	85	1	24000	DP1AK
26	10	25	20	45	85	1	24000	DP1AK
26	10	25	25	55	95	1	24000	DP1AK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	12.5	25	55	90	1	24000	DP1M
35	12	12.5	20	45	90	1	24000	DP1M
35	12	12.5	16	45	80	1	24000	DP1M
35	12	12.5	12	45	70	1	24000	DP1M
26	10	12.5	25	55	90	1	24000	DP1MK
26	10	12.5	20	45	80	1	24000	DP1MK
26	10	12.5	16	45	80	1	24000	DP1MK
26	10	12.5	12	35	70	1	24000	DP1MK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

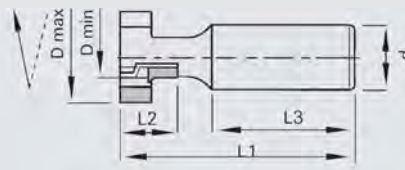
229063 / 229363

LEUCODIA Profiler - T-groove profiles

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0 mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	10	22	25	55	90	2+1	24000	DP1B
35	10	22	20	45	80	2+1	24000	DP1B
35	10	22	16	45	80	2+1	24000	DP1B
35	10	22	12	35	70	2+1	15700	DP1B
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

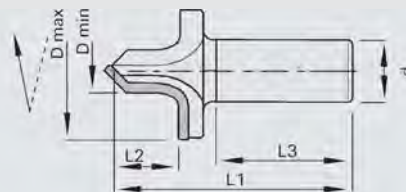
229063 / 229363

LEUCODIA Profiler - large profile depth

Product



Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0 mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, topline with ultra fine eroded cutting edge

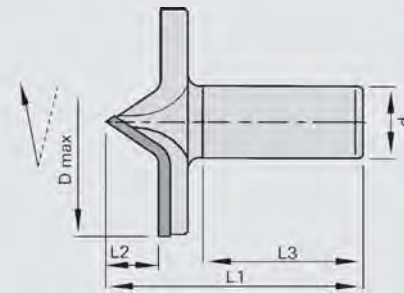
Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	16	15	25	55	100	1	24000	DP1CK
55	16	15	20	45	90	1	24000	DP1CK
55	16	15	16	45	90	1	24000	DP1CK
75	18	30	25	55	120	1	24000	DP1D
75	18	30	20	45	110	1	20500	DP1D
75	18	30	16	45	110	1	11200	DP1D
75	18	15	25	55	100	1	17000	DP1DK
75	18	15	20	45	90	1	12900	DP1DK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

229063 / 229363

LEUCODIA Profiler - panel raising profiles

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for profiling of raw and laminated panels

Design

| resharpenable area 2.0 mm
| with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
| optimum cutting quality in MDF thanks to polished cutting edge face
| optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
| further options are possible at a surcharge: opposing shear angle version ($Z = 1+1$), $Z = 2$ version, different shank length, topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	18	25	25	55	110	1	24000	DP1F
55	18	25	20	45	100	1	22000	DP1F
55	18	25	16	45	100	1	12000	DP1F
79		18	25	55	88	1	22000	DP1G
79		18	20	45	78	1	22000	DP1G
79		18	16	45	78	1	15000	DP1G
99		13	25	55	98	1	18000	DP1H
99		13	20	45	88	1	16300	DP1H
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

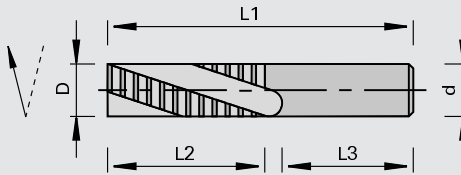
129460

Roughing Cutters VHW - ECO-disposable

Product



Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- portable routers
- for cutting of cut-outs in countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- positive spiral

Advantages

- optimum chip evacuation thanks to positive spiral
- high hogging volume thanks to rough cutting

Notes

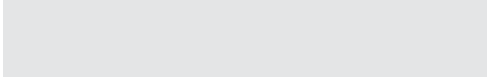
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	45	12	35	90	2	178325 o
[mm]	[mm]	[mm]	[mm]	[mm]		

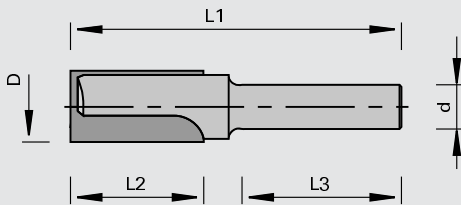
129415

Grooving Cutters HW-tipped - Z=2

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods

Design

- cutting edges parallel to cutter axis
- HW-tipped

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

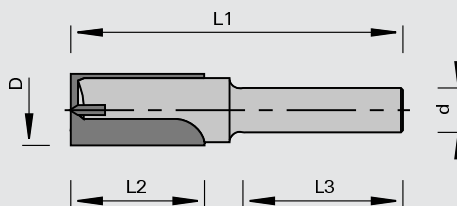
Ø D	L2	Ø d	L1	Z	Ident-No.
3.0	6,0	6,0	39	2	172430 o
4.0	8,0	6,0	40	2	164193 o
4.0	8,0	8,0	40	2	172431 o
5.0	12	6,0	42	2	164194 o
5.0	12	8,0	42	2	172432
6.0	14	6,0	49	2	160364
6.0	16	8,0	46	2	167521
8.0	20	6,0	50	2	160365 o
8.0	20	8,0	48	2	167522
10	20	6,0	50	2	160366 o
10	20	8,0	48	2	167523
12	20	8,0	48	2	167524
14	20	6,0	48	2	160368 o
14	20	8,0	48	2	167525 o
16	20	8,0	48	2	167526
18	20	8,0	48	2	167527 o
20	20	8,0	48	2	167528
[mm]	[mm]	[mm]	[mm]		

129415

Grooving Cutters HW-tipped - Z=2 with plunge tip

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods

Design

- brazed VHW cutting edge for $\varnothing D < 8 \text{ mm}$
- cutting edges parallel to cutter axis
- HW-tipped

Advantages

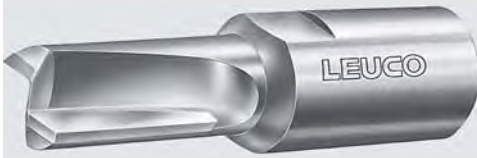
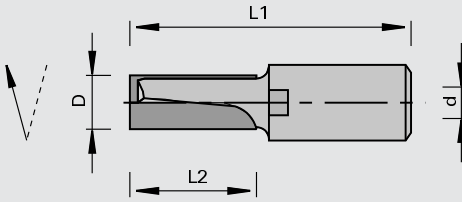

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

$\varnothing D$	L2	$\varnothing d$	L1	Z	Ident-No.
3.0	8,0	8,0	55	2	167529
4.0	10	8,0	55	2	167530
5.0	12	8,0	55	2	167531
6.0	14	8,0	55	2	167532
8.0	20	8,0	55	2	167533
8.0	30	8,0	90	2	180823
9.0	20	8,0	55	2	167534 o
10	20	8,0	60	2	167535
10	40	10	97	2	167552
12	20	8,0	60	2	167536
12	40	10	97	2	167553
14	20	8,0	60	2	167537 o
14	40	10	97	2	167554 o
16	20	8,0	70	2	167538 o
16	45	10	97	2	167555 o
18	20	8,0	70	2	167539
18	45	10	97	2	167556 o
20	45	10	97	2	167557 o
22	16	8,0	70	2	167540 o
22	25	10	70	2	172433 o
24	16	8,0	70	2	172434 o
25	16	8,0	70	2	172435 o
26	16	8,0	70	2	172436 o
28	16	8,0	70	2	172437 o
30	16	8,0	70	2	172438 o
[mm]	[mm]	[mm]	[mm]		

129425

Grooving Cutters HW-tipped - Z=2 with internal thread


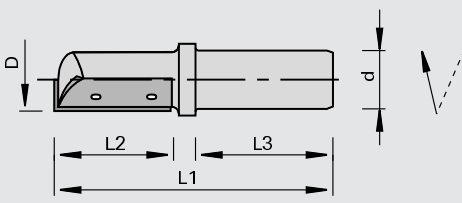

Product	Drawing	
		 Tungsten Carbide [HW] MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis internal thread allows direct attachment on the machine spindle 	<ul style="list-style-type: none"> face cutting design allows plunge-cuts 	

Ø D	L2	Ø d	L1	Z		Ident-No.
18	60	M12x1	92	2	ELU, Striffler	178968
[mm]	[mm]	[mm]	[mm]			

128415

Grooving Cutters with HW Turnover Knives - Z=1

Product	Drawing	
		 Tungsten Carbide [HW] MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis 	<ul style="list-style-type: none"> face cutting design allows plunge-cuts to Ø 12.7 mm clamping elements: draw-in collet chuck 	


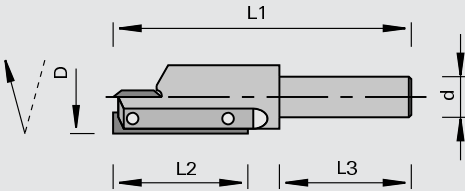

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8.0	20	8,0	30	60	1	175673
10	20	8,0	30	60	1	175674 o
12	20	8,0	30	60	1	175675 o
14	30	8,0	30	70	1	175676 o
10	25	10	40	75	1	175678
12	30	10	40	80	1	175679
12.7	30	12,7	40	80	1	175672 o
14	30	10	40	80	1	175680 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	10	173480
for Ø D = 10+12	20	5.5	1.1	150535	10	173481
for Ø D = 10	25	5.5	1.1	150535	10	173793
for Ø D = 12+12,7+14	30	5.5	1.1	150535	10	173482
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=20	175673	925500	2	175722 o
Clamping Wedges	B=20	175674	925500	2	175723 o
Clamping Wedges	B=25	175678	925500	2	175724 o
Clamping Wedges	B=20	175675	925500	2	175725 o
Clamping Wedges	B=30	175672	925500	2	175727 o
Clamping Wedges	B=30	175679	925500	2	175726 o
Clamping Wedges	B=30	175676, 175680	925500	2	175728 o
Head Cap Screws	M2,5x3 T8	175673	995115	10	168237
Head Cap Screws	M2,5x4 T8	175674, 175678	995115	10	168238
Head Cap Screws	M3x5,5 T8	175672, 175675, 175676, 175679, 175680	995115	10	168239
Screwdriver with flag	T8	For all	985730	1	166499
	[mm]			[pc.]	

128415

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip

Product	Drawing	
		 Tungsten Carbide [HW] MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis 		<ul style="list-style-type: none"> face cutting design allows plunge-cuts clamping elements: draw-in collet chuck

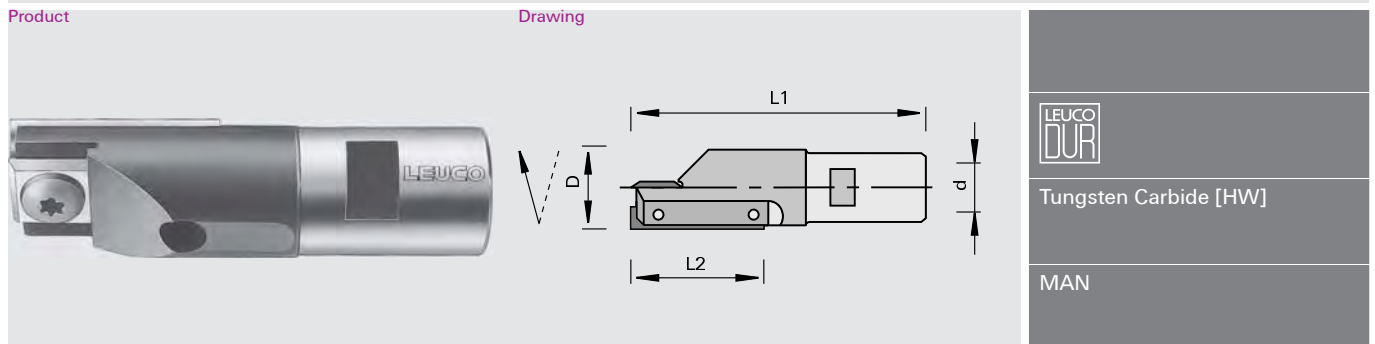
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	8,0	30	71	1+1	175689 o
18	30	8,0	30	71	1+1	175690 o
20	30	8,0	30	71	1+1	175691 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080
Mini Turnover Knives	30	5.5	1.1	150535	10	173482
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175689	925500	2	169280 o
Clamping Wedges	B=30	175691	925500	2	169282 o
Clamping Wedges	B=30	175690	925500	2	169281 o
Head Cap Screws	M3,5x6,5 T15	175691	995115	10	163223
Head Cap Screws	M3,5x5,5 T15	175689, 175690	995115	10	168236
Round Head Screws	M4x5,9 T15	For all	995195	10	167966
Screwdrivers	T15	For all	985730	1	163161
	[mm]			[pc.]	

128425

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip and internal thread



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis internal thread allows direct attachment on the machine spindle 	<ul style="list-style-type: none"> face cutting design allows plunge-cuts 	<p>LEUCO DUR</p> <p>Tungsten Carbide [HW]</p> <p>MAN</p>

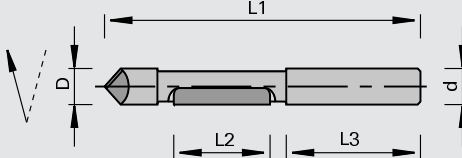

Ø D	L2	Ø d	L1	Z	Ident-No.
16	30	M10	65	1+1	175697 o
18	30	M10	65	1+1	175698 o
20	30	M10	65	1+1	175699 o
22	30	M10	65	1+1	175700 o
16	30	M12x1	65	1+1	175701 o
18	30	M12x1	65	1+1	175702 o
20	30	M12x1	65	1+1	175703
22	30	M12x1	65	1+1	175704 o
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	150515	10	003080
Mini Turnover Knives	30	5.5	1.1	150535	10	173482
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Wedges	B=30	175697, 175701	925500	2	169280 o
Clamping Wedges	B=30	175698, 175702	925500	2	169281 o
Clamping Wedges	B=30	175699, 175703	925500	2	169282 o
Clamping Wedges	B=30	175700, 175704	925500	2	169283 o
Head Cap Screws	M3,5x5,5 T15	175697, 175698, 175701, 175702	995115	10	168236
Head Cap Screws	M3,5x6,5 T15	175699, 175700, 175703, 175704	995115	10	163223
Round Head Screws	M4x5,9 T15	For all	995195	10	167966
Screwdrivers	T15	For all	985730	1	163161
	[mm]				[pc.]

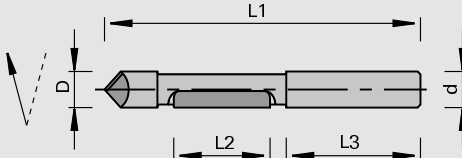
129417

Plunge Cutters HW-tipped

Product		Drawing						 Tungsten Carbide [HW]	
Machine / Application		Design		Advantages		Notes			
portable routers for cutting of cut-outs in solid woods		cutting edges parallel to cutter axis				face cutting design allows plunge-cuts clamping elements: draw-in collet chuck			
Ø D	L2	Ø d	L3	L1	Z	Ident-No.			
6.0	19	6,0	25	65	1+1	006453			
6.35	20	6,35	25	63	1+1	167661 o			
[mm]	[mm]	[mm]	[mm]	[mm]					

329417

Plunge Cutters HS-tipped

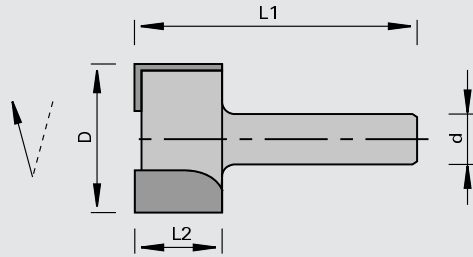
Product		Drawing						High Speed Steel [HS]	
Machine / Application		Design		Advantages		Notes			
portable routers for cutting of cut-outs in solid woods		cutting edges parallel to cutter axis				face cutting design allows plunge-cuts clamping elements: draw-in collet chuck			
Ø D	L2	Ø d	L3	L1	Z	Ident-No.			
6.4	15	6,0	25	56	1+1	170757			
6.4	15	6,0	25	70	1+1	170758			
[mm]	[mm]	[mm]	[mm]	[mm]					

129215

Edge Trimming Cutters HW-tipped

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

portable routers
for jointing and rabbeting in solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
face cutting and peripheral cutting

Advantages

Notes

clamping elements: draw-in collet chuck

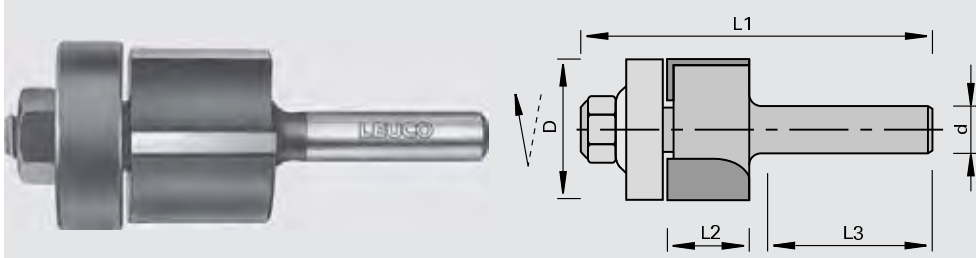
Ø D	L2	Ø d	L1	Z	Ident-No.
18	12	6,0	37	2	164307 o
20	16	6,0	41	2	006146 o
24	16	6,0	41	2	167573 o
31	16	6,0	41	2	167574 o
18	12	8,0	37	2	164308 o
20	16	8,0	41	2	160357 o
24	16	8,0	41	2	167575 o
31	16	8,0	41	2	167576 o
24	16	10	41	2	167577 o
31	16	10	41	2	167578 o
24	16	12	41	2	167579 o
31	16	12	41	2	167580 o
[mm]	[mm]	[mm]	[mm]		

129216

Edge Trimming Cutters HW-tipped with thrust ring

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

portable routers
for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
flush-cutting with ball-bearing mounted rub collar

Advantages

Notes


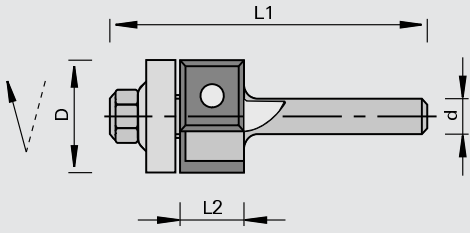

template copying
clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12.7	25	8,0	25	58	2	180822
22	16	6,0	25	58	2	006152 o
22	16	6,35	25	58	2	167585 o
22	16	8,0	25	58	2	164215 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	12,7x5x4,76	997500	1	164920
Ball Bearings	22x7,5x6,35	997500	1	164228
Ball Bearings	22x7,5x8	997500	1	180838
Hexagon Nuts	M4 DIN EN ISO 4032	995210	1	009631
Hexagon Nuts	M6 DIN EN ISO 4032	995210	1	009633
	[mm]		[pc.]	

128216

Edge Trimming Cutters with HW Turnover Knives with thrust ring

Product	Drawing	
		
		Tungsten Carbide [HW]
		MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis flush-cutting with ball-bearing mounted rub collar 		<ul style="list-style-type: none"> template copying clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
19	12	8,0	56	2	164916
19	30	8,0	74	2	183398
19	50	12	112	2	183399
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	12	12	1.5	150515	10	003080
	30	12	1.5	150515	10	003083
	50	12	1.5	150515	10	003085
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	19x6x6	997500	1	164922
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

129315

Edge Chamfering Cutters HW-tipped

Product		Drawing						
					Tungsten Carbide [HW]		MAN	
Machine / Application		Design		Advantages		Notes		
<ul style="list-style-type: none"> portable routers for chamfering in solid woods and wood-based panels 		<ul style="list-style-type: none"> cutting edges parallel to cutter axis 				<ul style="list-style-type: none"> clamping elements: draw-in collet chuck 		
Chamfer	Ø D	L2	Ø d	Z	Ident-No.			
15	24	12	6,0	2	006160 o			
15	24	12	8,0	2	164220 o			
22	24	12	6,35	2	167587 o			
30	24	12	6,0	2	006161 o			
30	24	12	8,0	2	164221 o			
[°]	[mm]	[mm]	[mm]					

129315

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, changeable shank design

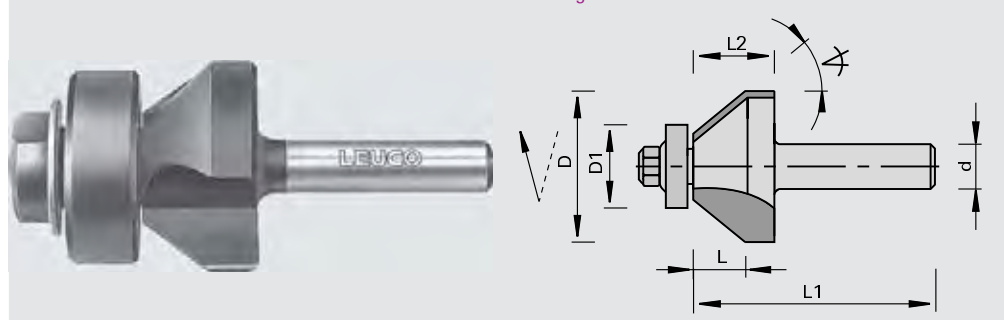
Product		Drawing						
					Tungsten Carbide [HW]		MAN	
Machine / Application		Design		Advantages		Notes		
<ul style="list-style-type: none"> portable routers for chamfering in solid woods and wood-based panels 		<ul style="list-style-type: none"> cutting edges parallel to cutter axis changeable shank design 				<ul style="list-style-type: none"> clamping elements: draw-in collet chuck 		
Chamfer	Ø D	L2	L	Ø d	Z	Ident-No.		
45	31	15	10	6,0	2	167589 o		
45	31	15	10	8,0	2	167591 o		
45	31	15	10	10	2	167592 o		
45	31	15	10	12	2	167593 o		
[°]	[mm]	[mm]	[mm]	[mm]				

129316

Edge Chamfering Cutters HW-tipped with thrust ring

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying with chamfer
- clamping elements: draw-in collet chuck

Chamfer	Ø D	Ø D1	L2	L	Ø d	L1	Z	Ident-No.
45	25	15,9	12	6,0	6,0	37	2	160361
45	25	15,9	12	6,0	8,0	37	2	167597
30	26	15,9	12	12	6,0	37	2	160360 o
30	26	15,9	12	12	8,0	37	2	167596 o
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Ball Bearings

15,9x5x6,35

997500

1

164921

Hexagon Nuts

M6 DIN EN ISO 4032

995210

1

009633 s

[mm]

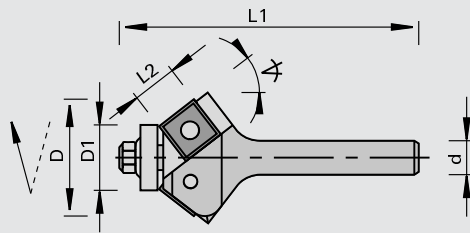
[pc.]

128316

Edge Chamfering Cutters with HW Turnover Knives with thrust ring

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable routers
- | for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | flush-cutting with ball-bearing mounted rub collar

Advantages
Notes

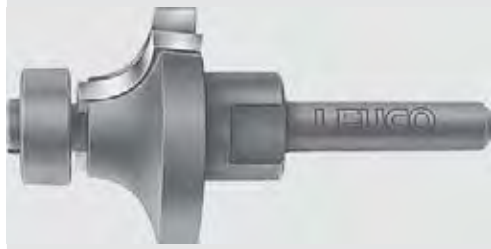
- | template copying
- | clamping elements: draw-in collet chuck

Chamfer	$\varnothing D$	$\varnothing D1$	L2	$\varnothing d$	L1	Z	Ident-No.		
45 [°]	29 [mm]	12,7 [mm]	12 [mm]	8,0 [mm]	64 [mm]	2	185493		
Turnover Knives				B	H	S	Class-No.	PU	Ident-No.
				12 [mm]	12 [mm]	1.5 [mm]	150515	10 [pc.]	003080
Spare parts				Dimension			Class-No.	PU	Ident-No.
Ball Bearings				13x5x4			997500	1	185494
Round Head Screws				M4x5,9 T15			995195	10	167966
Screwdrivers				T15 [mm]			985730	1 [pc.]	163161

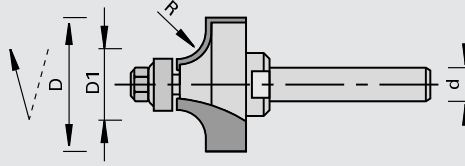
129616

Rounding Cutters HW-tipped with thrust ring

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- portable routers
- for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- rounding with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	Z		Ident-No.
2,0	16	12	8,0	2		180824
2,0	18	12	6,0	2	EBM	816995
3,0	18	12	6,0	2		167598
3,0	18	12	6,35	2		167599 o
3,0	18	12	8,0	2		167600
3,0	20	12	6,0	2	EBM	816994 o
4,0	20	12	6,0	2		167601 o
4,0	20	12	6,35	2		167602 o
4,0	20	12	8,0	2		167603
5,0	22	12	6,0	2		167604 o
5,0	22	12	6,35	2		167605 o
5,0	22	12	8,0	2		167606
6,3	24	12	6,35	2		167608 o
6,3	24.6	12	6,0	2		167607 o
6,3	24.6	12	8,0	2		167609
8,0	30	14	6,0	2		167610 o
8,0	30	14	6,35	2		167611 o
8,0	30	14	8,0	2		167612
9,5	33	14	6,0	2		167613 o
9,5	33	14	6,35	2		167614 o
9,5	33	14	8,0	2		167615
12,7	39.4	14	6,0	2		167616 o
12,7	39.4	14	6,35	2		167617 o
12,7	39.4	14	8,0	2		167618
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

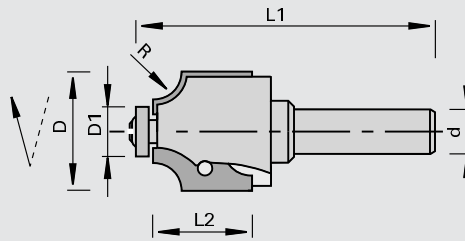
Ball Bearings	Ø12	997500	1	167923
Ball Bearings	Ø14	997500	1	169314
	[mm]		[pc.]	

128616

Rounding and Quarter Round Cutterheads HW

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable routers
- | for rounding and quarter round cutting in solid woods and wood-based panels

Design

- | with ball-bearing spacer ring
- | profiled turnover knives
- | face cutting and peripheral cutting

Advantages
Notes

- | included in delivery: 2 ball bearing sets (see D1)
- | included in delivery Ident-No. 180947: 1 ball bearing set
- | exchangeable ball bearing sets: 1. with big spacer set / 2. with small spacer set/ 3. without spacer set

R	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
2,0	26	22	19,5	8,0	70	2	180947 o
3,0	26	20/18	19,5	8,0	70	2	180948 o
4,0	26	18/14	19,5	8,0	70	2	180949 o
5,0	26	16/12	19,5	8,0	70	2	180950 o
6,0	32	20/16	26	8,0	76	2	180951 o
8,0	32	16/12	26	8,0	76	2	180952 o
10	36	16/12	30	8,0	80	2	180953 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	PU	Ident-No.
	2,0	19,5	9,0	1,5	151555	2	180991 o
	3,0	19,5	9,0	1,5	151555	2	180992 o
	4,0	19,5	9,0	1,5	151555	2	180993 o
	5,0	19,5	9,0	1,5	151555	2	180994 o
	6,0	26	12,5	1,5	151555	2	180995 o
	8,0	26	12,5	1,5	151555	2	180996 o
	10	30	14,5	1,5	151555	2	180997 o
	[mm]	[mm]	[mm]	[mm]		[pc.]	

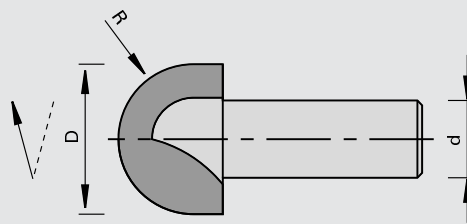
Spare parts	Dimension	Class-No.	PU	Ident-No.
Ball Bearings	Ø12	997500	1	167923
Ball Bearings	Ø14	997500	1	169314
Ball Bearings	Ø16	997500	1	180985 o
Ball Bearings	Ø18	997500	1	180986 o
Ball Bearings	Ø20	997500	1	180987 o
Ball Bearings	Ø22	997500	1	180988 o
Head Cap Screws	M4x6 T15	995195	10	180989 o
Round Head Screws	M4x5,9 T15	995195	10	167966
Cover Screws	M3,5	995192	10	180990 o
Screwdrivers	T15	985730	1	163161
	[mm]		[pc.]	

129615

Concave Cutters HW-tipped

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l portable routers
l for cutting of coves and semi-coves in solid woods and wood-based panels

Design

l 2 cutting edges parallel to cutter axis

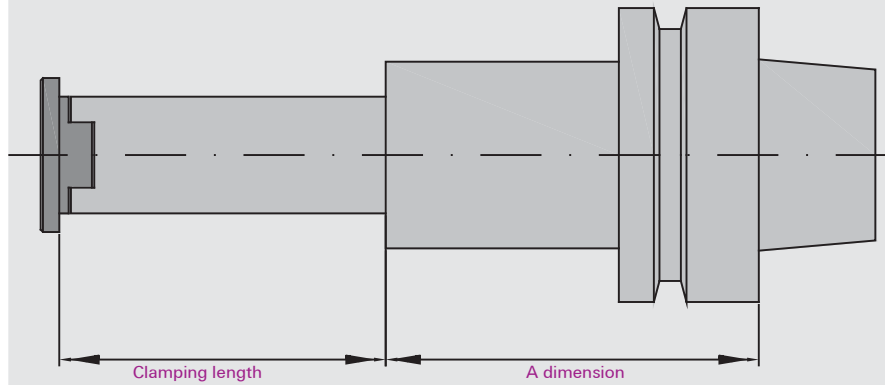
Advantages

Notes

l clamping elements: collet chuck

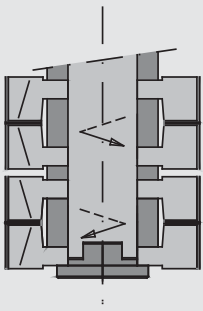
R	Ø D	Ø d	L1	Z	Ident-No.
4,75	9.5	8,0	60	2	167633 o
5,5	11	8,0	60	2	167634 o
6,35 [mm]	12.7 [mm]	8,0 [mm]	60 [mm]	2	167635

Modula Order Data

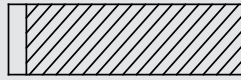


- | The Modula-system is a modern tool-system for CNC-machines
- | Thanks to its modular structure many profile variations can be made up
- | On the following pages please find the most important standard combinations, the individual cutterheads and the holder shanks
- | Note: all combinations do not include drive arbors. Please order separately and indicate dimension "A" and clamping length required
- | Sets include spacers; tool-cards not included
- | the Modula cutterheads are supplied without adjustment gauges and wrenches; please order separately (mounting set Ident-No. 9210474)
- | For custom combinations please contact your LEUCO representative
- | Tool identification card Ident-No. 171407 EUR 28.30

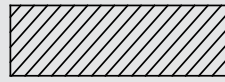
Modula Jointing Sets Application



Section cut lefthand

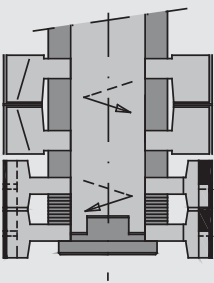


Modula Jointing Cutter with TOK for chamfering on lefthand

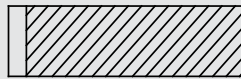


In combination with Modula jointing cutter for finish cutting righthand

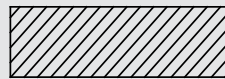
Finish cut righthand



Section cut lefthand

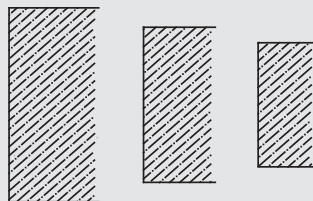
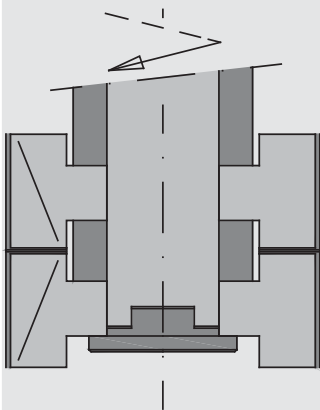


Modula Jointing Cutter with TOK for chamfering on lefthand and for veneer overhangs



In combination with LEUCODIA jointing cutter for finish cutting righthand

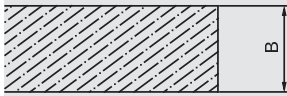
Finish cut righthand



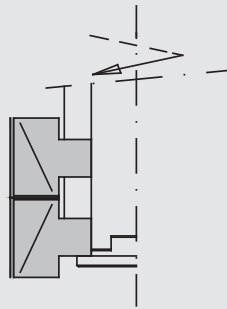
128660

Modula Jointing Sets HW

Product



Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing in laminated panels

Design

- | opposing shear cut
- | tool set 2 parts
- | basis number of wings Z=2
- | n max = 14,500 min-1

Advantages

Notes

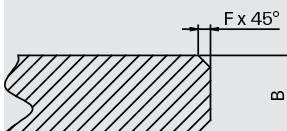
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No.9210474
- | please order shank-tool holder separately

Ø D	B	Ø d	Z		Ident-No.
70	28	25	2	O-1, O-2	199377
70	38	25	2	C-1, C-2	199380
70	58	25	2	H-1, H-2	199382
70	78	25	2	J-1, J-2	199383
[mm]	[mm]	[mm]			

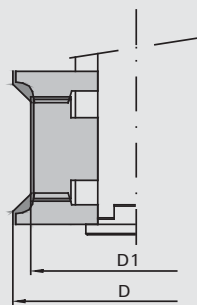
128660

Modula Chamfering Sets HW

Product



Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | jointing cutterheads up to B = 40 mm with shear angle
- | unchanging zero-point
- | n max = 14,500 min-1

Advantages

- | simple adjustment by means of rings
- | high flexibility thanks to modular design

Notes

- | expandable by concave or radius cutterheads
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No.9210474
- | please order shank-tool holder separately

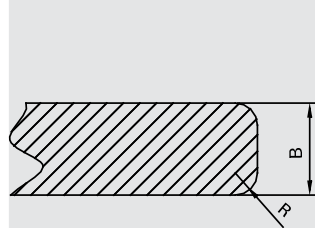
Chamfer	Ø D	Ø D1	B	Ø d	Z		Ident-No.
3x45	78	70	8,0-23	25	2	B, C-1, B	199335
3x45	78	70	14-33	25	2	B, H-1, B	199338
3x45	78	70	24-43	25	2	B, J-1, B	199341
3x45	78	70	34-63	25	2	B, S-1, B	199753
3x45	78	70	54-75	25	2	B, M-1, B	199754
[°]	[mm]	[mm]	[mm]	[mm]			

Chamfer \angle	$\varnothing D$	$\varnothing D1$	B	$\varnothing d$	Z		Ident-No.
5x45	82	70	18-28	25	2	F-1, C-1, F-2	199344
5x45	82	70	23-38	25	2	F-1, H-1, F-2	199348
5x45	82	70	33-48	25	2	F-1, J-1, F-2	199352
5x45	82	70	38-68	25	2	F-1, S, F-2	199765
5x45	82	70	58-74	25	2	F-1, M, F-2	199766
10x45	90	70	22-38	25	2	U-1, C-1, U-2	199356
10x45	90	70	22-48	25	2	U-1, H-1, U-2	199359
10x45	90	70	29-58	25	2	U-1, J-1, U-2	199362
10x45	90	70	38-72	25	2	U-1, S, U-2	199767
10x45	90	70	58-74	25	2	U-1, M, U-2	199768
[°]	[mm]	[mm]	[mm]	[mm]			

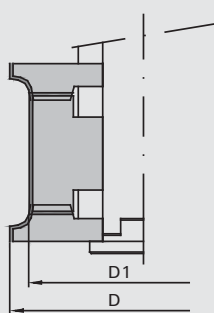
128660

Modula Rounding Sets HW

Product



Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing and rounding in solid woods and wood-based panels

Design

- | jointing cutterheads up to B = 40 mm with shear angle
- | radius cutterheads from R 4 with shear angle
- | unchanging zero-point
- | n max = 14,500 min-1

Advantages

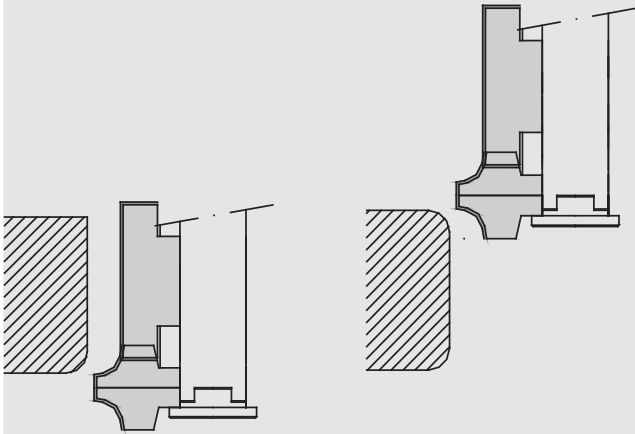
- | simple adjustment by means of rings
- | high flexibility thanks to modular design

Notes

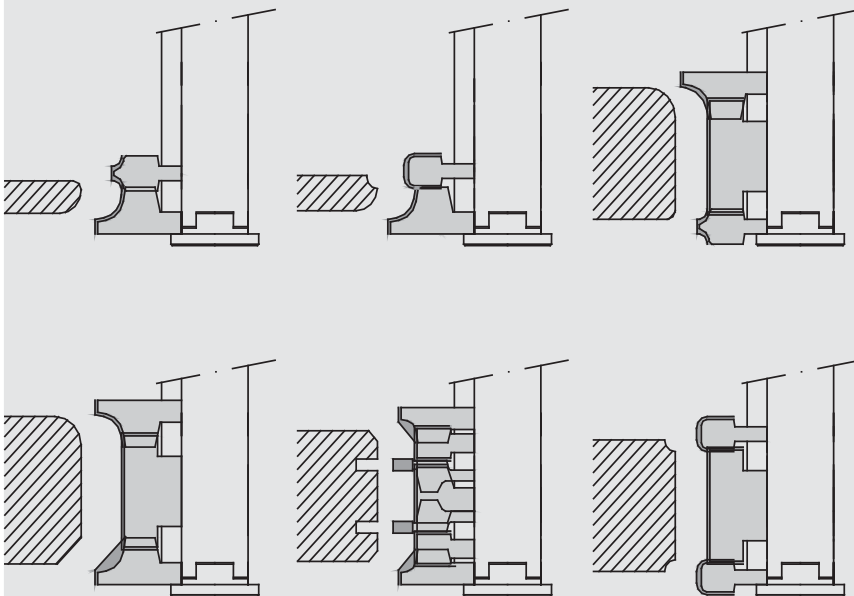
- | expandable by concave or chamfering cutterheads
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No.9210474
- | please order shank-tool holder separately

R	$\varnothing D$	$\varnothing D1$	B	$\varnothing d$	Z		Ident-No.
2, 3	78	70	8,0-21	25	2	B, C-1, B	199336
2, 3	78	70	14-31	25	2	B, H-1, B	199339
2, 3	78	70	24-41	25	2	B, J-1, B	199342
2, 3	78	70	34-62	25	2	B, S, B	199749
2, 3	78	70	54-75	25	2	B, M, B	199750
4, 5, 6	82	70	16-26	25	2	F-1, C-1, F-2	199345
4, 5, 6	82	70	20-36	25	2	F-1, H-1, F-2	199349
4, 5, 6	82	70	30-46	25	2	F-1, J-1, F-2	199353
4, 5, 6	82	70	40-66	25	2	F-1, S, F-2	199755
4, 5, 6	82	70	60-74	25	2	F-1, M, F-2	199756
8, 10	90	70	22-34	25	2	U-1, C-1, U-2	199357
8, 10	90	70	22-44	25	2	U-1, H-1, U-2	199360
8, 10	90	70	29-54	25	2	U-1, J-1, U-2	199363
8, 10	90	70	38-72	25	2	U-1, S, U-2	199761
8, 10	90	70	58-74	25	2	U-1, M, U-2	199762
[mm]	[mm]	[mm]	[mm]	[mm]			

Modula Application Examples



Other combinations



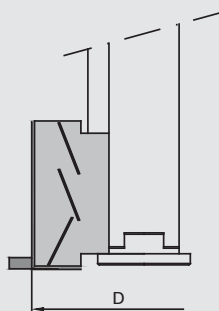
- | If material thicknesses vary considerably, both cutterheads are mounted on the bottom
- | The material-thicknesses are entered into the program and the milling is done in two passes

128660

Modula Jointing / Rabbeting Cutterheads HW

Product

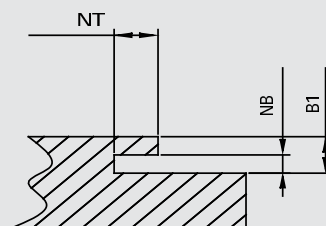
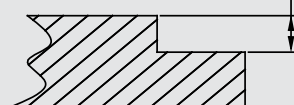
Drawing



LEUCO
GNC

Tungsten Carbide [HW]

MEC



Machine / Application

- | CNC routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | aluminum body
- | with alternating shear angle
- | spiral cutting edges
- | basis number of wings Z=2
- | n max = 15,000 min-1

Advantages

- | high performance with low cutting pressure

Notes

- | optionally grooving knives can be used
- | wrenches are not included in delivery
- | mounting-set Ident-No.9210474
- | please order shank-tool holder separately

Ø D	B	B1	Ø d	Z	Ident-No.
80	71	20-70	25	2+2+2	9203782
80	91	20-90	25	2+2+2	9206050
80	127	20-126	25	2+2+2	9206515
120	100		25	4	9209449
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
turnover knives up to the year 2006	16	12	1.5	150515	10	876623
Turnover Knives	18	12	1.5	150515	10	9206316
Turnover Knives	20	12	1.5	150515	10	9215959
Turnover Knives	100	12	1.5	150515	10	9209451
	[mm]	[mm]	[mm]		[pc.]	

Options additional grooving knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	8,0	150512	10	879869
	5,0	8,0	150512	10	888748
	[mm]	[mm]		[pc.]	

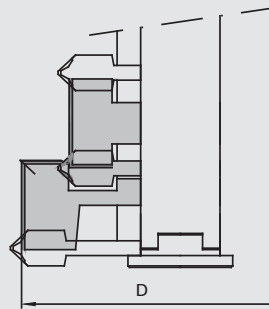
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	100x11x10	9209449	925300	1	9209452
Set Screws	M6x20	9209449	995161	2	9204674
Pressure Bars	18x10x10,8	9203782, 9206050, 9206515	925300	2	872689
Pressure Bars	21,3x10x10,8	9203782, 9206050, 9206515	925300	2	9203785
Set Screws	M6x16 SW3	9203782, 9206050, 9206515	995161	10	001617
Countersunk Screws	for spur M5x7 T15	9203782, 9206050, 9206515	995125	10	900512
Countersunk Screws	M5x11 T20	9203782, 9206050, 9206515	995125	10	879871
Screwdrivers	SW3x100	For all	985730	1	166090
Screwdrivers	T15x80	9203782, 9206050, 9206515	985730	1	171188
Screwdrivers	T20x100	9203782, 9206050, 9206515	985730	1	166092
Magnetic Stops	1,0	9203782, 9206050, 9206515	997800	1	166094
	[mm]				

128660

Modula Door Rabbeting Sets HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
| for the production of door rabbets

Design

| with shear angle
| basis number of wings Z=2
| Ø 100 mm: n max = 14,500 min-1
| unchanging zero-point

Advantages

| high flexibility thanks to modular design
| simple adjustment by means of rings

Notes

| when running variable door production the single rabbet edge is done with bottom cutter in a second pass
| expandable by chamfering, concave or radius cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No.9210474
| please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax	Z	Ident-No.
96	15-28	14-18	25	13	2	199722
96	15-28	24-38	25	13	2	199723
96	22-38	24-38	25	13	2	199724
100	15-28	14-28	25	15	2	199725
100	15-28	24-38	25	15	2	199726
100	22-38	24-38	25	15	2	199727
[mm]	[mm]	[mm]	[mm]	[mm]		

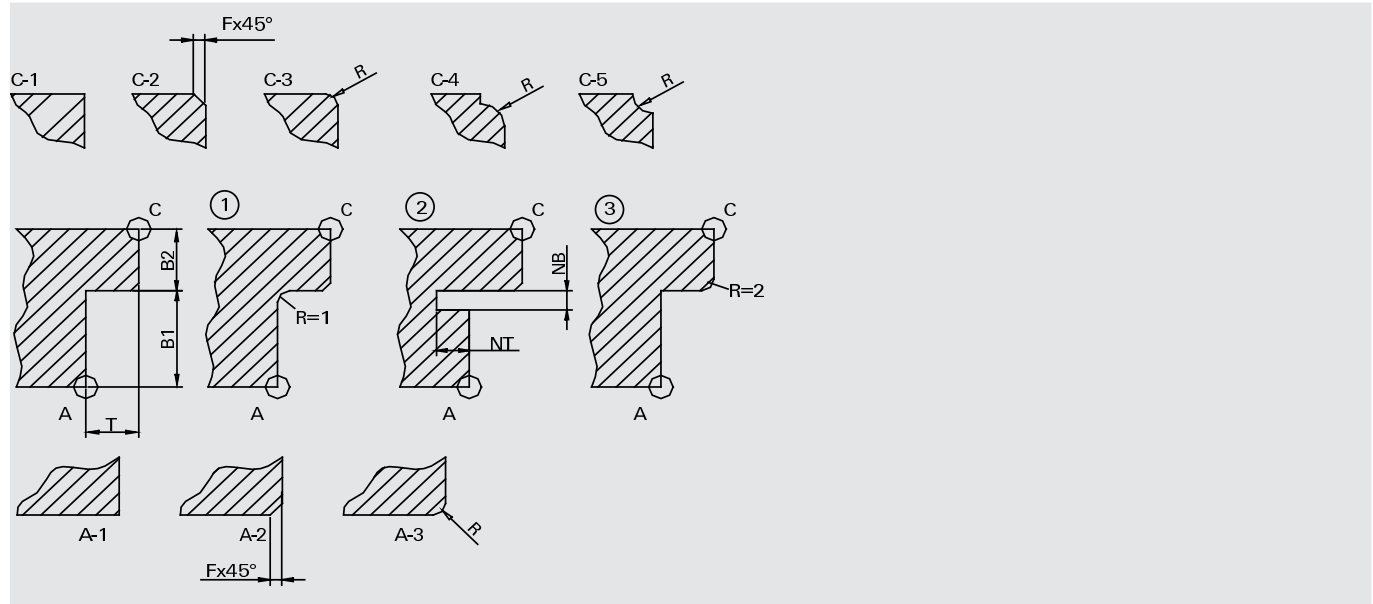
Options 1	R	B	H	S	Class-No.	PU	Ident-No.
Radius Spurs	1,0	13	15	2.0	150552	10	888476
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Grooving Knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	8,0	150512	10	879869
	5,0	8,0	150512	10	888747
	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	for grooving knife	M5x11 T20	995125	10	879871
		[mm]		[pc.]	

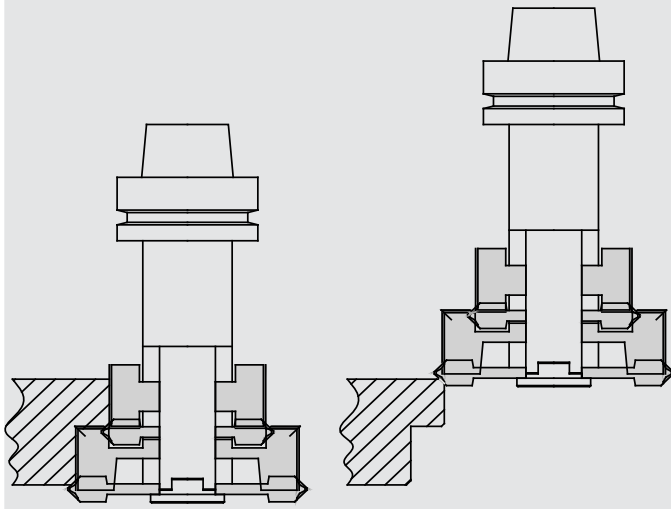
Options 2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
A-2		45	13	E	120610	888737
A-3	2,0		13	E	120610	888738
A-3	3,0		13	E	120610	888739
A-2		45	15	A	120610	879845
A-3	2,0		15	A	120660	881168
A-3	3,0		15	A	120660	881169
C-2		45		B	120610	879830
C-3	2,0			B	120610	881166
C-3/4	3,0			B	120610	881167
C-3	4,0			F-1	120610	879984
C-3	5,0			F-1	120610	881170
C-3/4	6,0			F-1	120610	881171
C-3	8,0			U-1	120610	881880
	[mm]	[°]	[mm]			

Options2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
C-3/4	10			U-1	120610	881881
C-5	3,0			N	120610	879859
C-5	4,0			N	120610	881164
C-5	5,0			K	120610	879858
C-5	6,0			K	120610	881165
	[mm]	[°]	[mm]			



Modula Door Set Application

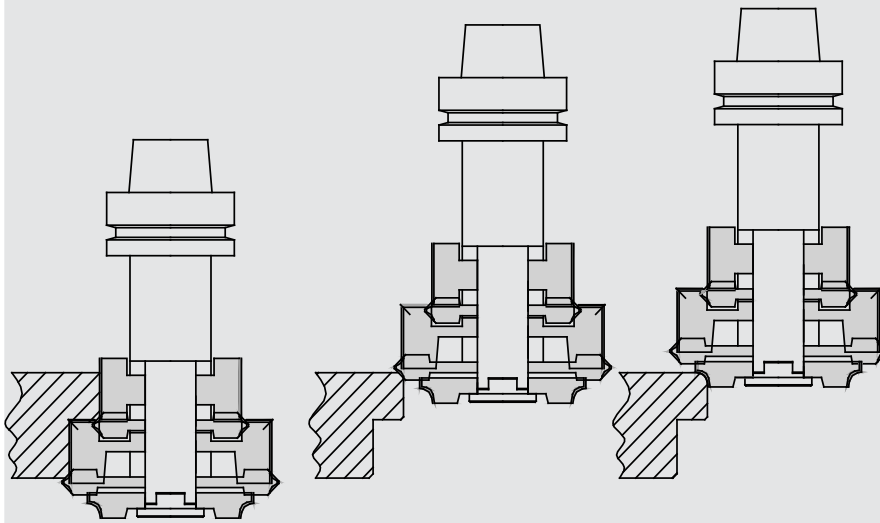
application example for different door thicknesses
profile is done in two passes



1 nd Operation

2 nd Operation

Application example with add-on cutterheads for individual doors



1 nd Operation

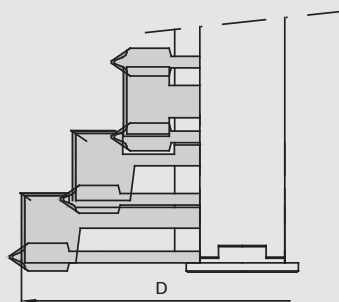
2. 2. Pass chamfer, rounding or top of rodshape can be controlled via the program

128660

Modula Double Rabbeting Sets HW

Product

Drawing

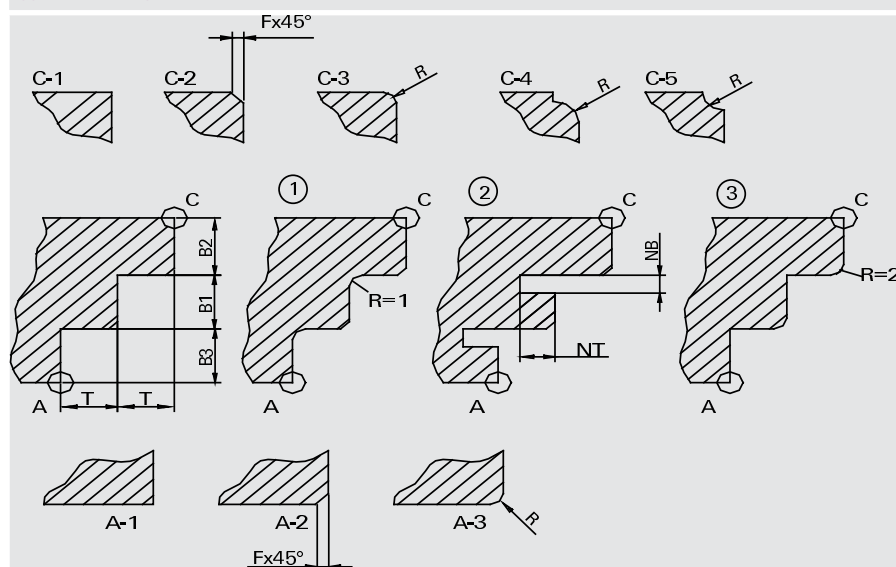


LEUCO
CNC

Tungsten Carbide [HW]

MEC

Application example



Machine / Application

- CNC routers
- for the production of door rabbets

Design

- with shear angle
- basis number of wings Z=2
- unchanging zero-point
- n max = 11,500 min-1

Advantages

- high flexibility thanks to modular design
- simple adjustment by means of rings

Notes

- expandable by chamfering, concave or radius cutterheads
- standard sets: edges A and C are angular
- wrenches are not included in delivery
- mounting-set Ident-No.9210474
- please order shank-tool holder separately

Ø D	B1	B2	B3	Ø d	Tmax		Ident-No.
130	15-28	15-28	14-28	25	15	H-1, B, T-3, A, T-5	199781
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Options 1	R	B	H	S	Class-No.	PU	Ident-No.
Radius Spurs	1,0	13	15	2.0	150552	10	888476
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Options 2	B	Tmax	Class-No.	PU	Ident-No.
Grooving Knives	4,0	8,0	150512	10	879869
Grooving Knives	5,0	8,0	150512	10	888747
	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	for grooving knife	M5x11 T20	995125	10	879871
		[mm]		[pc.]	

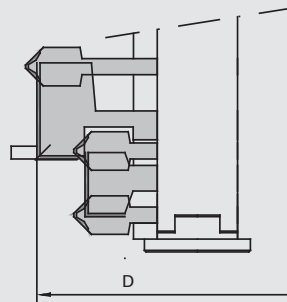
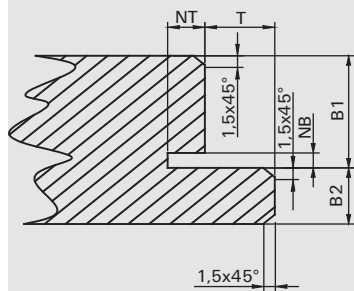
Options	R	Chamfer∠	Cutterhead	Class-No.	PU	Ident-No.
A-2		45	Y	120610	1	880580
A-3	2,0		Y	120660	1	880581
A-3	3,0		Y	120660	1	880582
C-2		45	B	120610	1	879830
C-3	2,0		B	120610	1	881166
C-3/4	3,0		B	120610	1	881167
C-3	4,0		F-1	120610	1	879984
C-3	5,0		F-1	120610	1	881170
C-3/4	6,0		F-1	120610	1	881171
C-3	8,0		U-1	120610	1	881880
C-3/4	10		U-1	120610	1	881881
C-5	3,0		N	120610	1	879859
C-5	4,0		N	120610	1	881164
C-5	5,0		K	120610	1	879858
C-5	6,0		K	120610	1	881165
	[mm]	[°]				

128660

Modula Door Frame Rabbeting Sets HW with chamfer

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

l CNC routers
l for the production of frame rabbets

Design

l set with chamfered edges and groove 4 x 8 mm
l with shear angle
l basis number of wings Z=2
l Ø 100 mm: n max = 14,500 min-1

Advantages

l high flexibility thanks to modular design
l simple adjustment by means of rings

Notes

l available also in counter-clockwise rotation or for rabbeting from below
l wrenches are not included in delivery
l mounting-set Ident-No.92 10474
l please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199747
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199746
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199745
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199748
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives

B

Tmax

Class-No.

PU

Ident-No.

4,0

8,0

150512

10

879869

5,0

8,0

150512

10

888747

[mm]

[mm]

[pc.]

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws

for grooving knife

M5x11 T20

995125

10

879871

[mm]

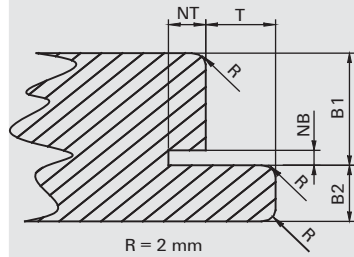
[pc.]

128660

Modula Door Frame Rabbeting Sets HW with radius

Product

Drawing



LEUCO
GNC

Tungsten Carbide [HW]

MEC

Machine / Application

l CNC routers
l for the production of frame rabbets

Design

l set with rounded edges and groove 4 x 8 mm
l with shear angle
l basis number of wings Z=2
l Ø 100 mm: n max = 14,500 min-1

Advantages

l high flexibility thanks to modular design
l simple adjustment by means of rings

Notes

l available also in counter-clockwise rotation or for rabbeting from below
l wrenches are not included in delivery
l mounting-set Ident-No.9210474
l please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199777
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199778
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199779
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199780
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	8,0	150512	10	879869
	5,0	8,0	150512	10	888747
	[mm]	[mm]		[pc.]	

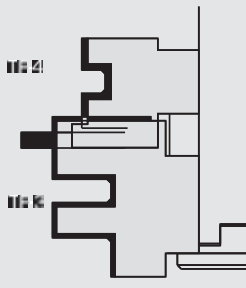
Spare parts	Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	for grooving knife	M5x11 T20	995125	10	879871
		[mm]		[pc.]	

128660

Modula Door Case Sets HW

Product

Drawing

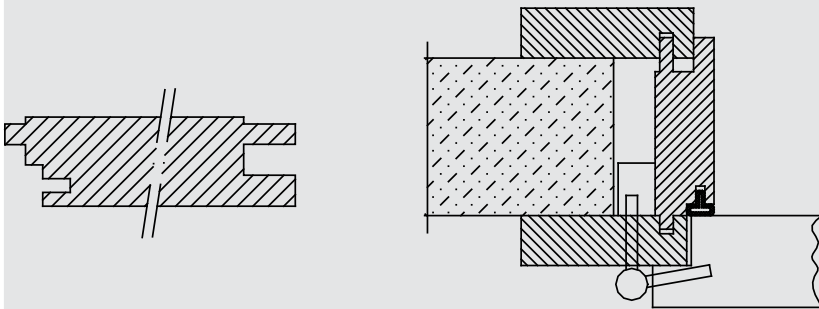


LEUCO
CNC

Tungsten Carbide [HW]

MEC

Application example



Machine / Application

- CNC routers
- for the production of door leaves made from solid wood and wood-based panels

Design

- basis number of wings Z=2
- n max = 14,500 min-1

Advantages

- high flexibility thanks to modular design
- simple adjustment by means of rings

Notes

- machining of both sides with same set
- cutter set for one-sided operation upon request
- wrenches are not included in delivery
- mounting-set Ident-No.9210474
- please order shank-tool holder separately

Ø D	B1	Ø d	Tmax		Ident-No.
100 [mm]	25-30 [mm]	25 [mm]	15 [mm]	TF-3, TF-4	9202895

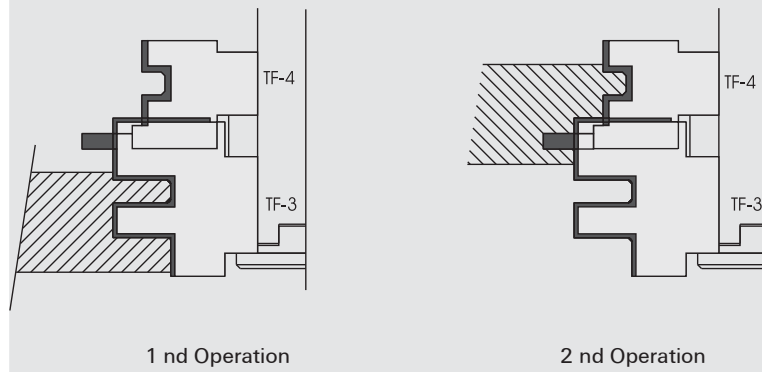
Turnover Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
Profile Turnover Knives	10	13.5	1.5	up to 2006	151556	10	888963
Profile Turnover Knives	22,3	18	2.0	TF-4	151556	10	885906
Profile Turnover Knives	41	28.2	2.0	TF-3	151556	10	9202581
	[mm]	[mm]	[mm]			[pc.]	

Grooving Knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	13	150512	10	881180
	[mm]	[mm]		[pc.]	

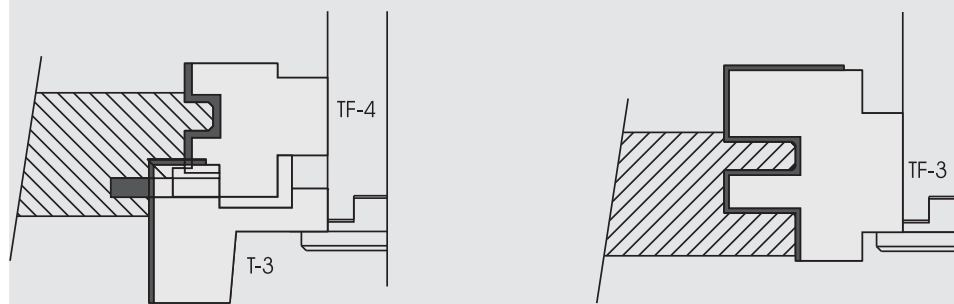
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x11 T20	995125	10	879871
	[mm]		[pc.]	

Modula Door Set Application

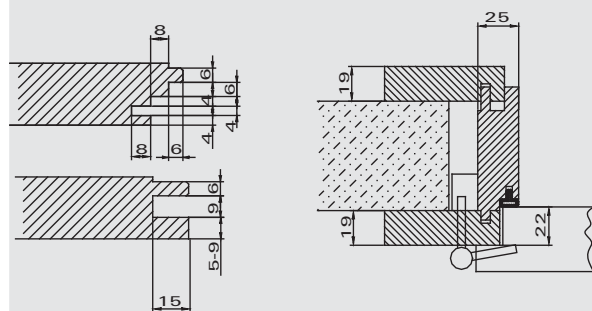
Application example with standard tool
Profile is done in two passes



application example if cutting height is too small for the standard solution
2 tools are used



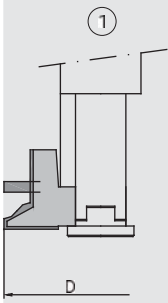
dimensions



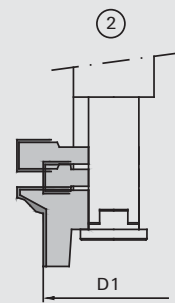
128660

Modula Counterprofile Sets HW - one-sided

Product



Drawing

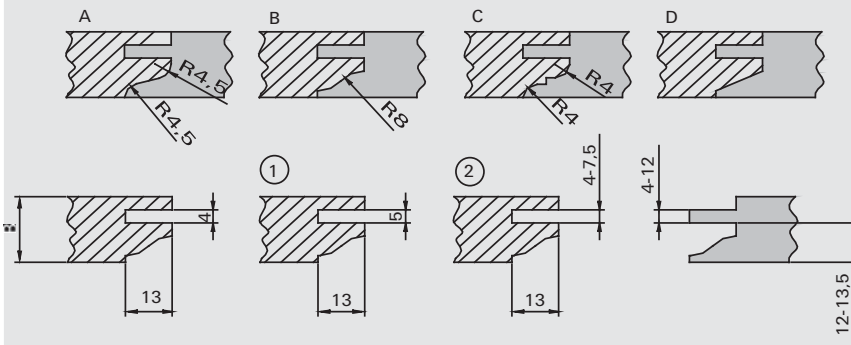


LEUCO
CNC

Tungsten Carbide [HW]

MEC

Application example



Machine / Application

- CNC routers
- for length- and counterprofiles on furniture parts, i.e. furniture doors and cassettes

Design

- basis number of wings Z=2
- Ø 100 mm: n max = 14,500 min-1

Advantages

- 4 profiles in the same body
- complete machining in one pass

Notes

- standard delivery with profile B, groove 4 x 13 mm
- optionally groove 5 x 13 mm or adjustable 4 - 7.5 x 13 mm
- available for clockwise and counter-clockwise rotation
- wrenches are not included in delivery
- mounting-set Ident-No.92 10474
- please order shank-tool holder separately

Ø D	Ø D1	B	Ø d	Type	Ident-No.
96	70	20-27	25	1 X-2, groove 4	199775
96	70	20-27	25	2 X-1, G, W	199776
[mm]	[mm]	[mm]	[mm]		

Options1	B	Tmax	Class-No.	PU	Ident-No.
Grooving Knives	5,0	13	150512	10	879870
	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	for grooving knife M5x11 T20	995125	10	879871
	[mm]		[pc.]	

Options2	B	Tmax	Class-No.	Ident-No.
cutter Q	4,0	13	120200	881153
	[mm]	[mm]		

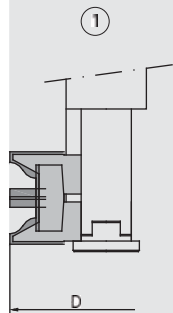
Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
profile A left	30	26	2.0	X-1	151521	10	882465
profile A right	30	26	2.0	X-2	151522	10	882466
profile B left	30	26	2.0	X-1	151521	10	882463
	[mm]	[mm]	[mm]			[pc.]	

Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
profile B right	30	26	2.0	X-2	151522	10	882464
profile C left	30	26	2.0	X-1	151521	10	882461
profile C right	30	26	2.0	X-2	151522	10	882462
profile D left	30	26	2.0	X-1	151521	10	882467
profile D right	30	26	2.0	X-2	151522	10	882468
	[mm]	[mm]	[mm]				[pc.]

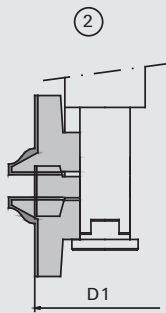
128660

Modula Counterprofile Sets HW - double-sided

Product



Drawing

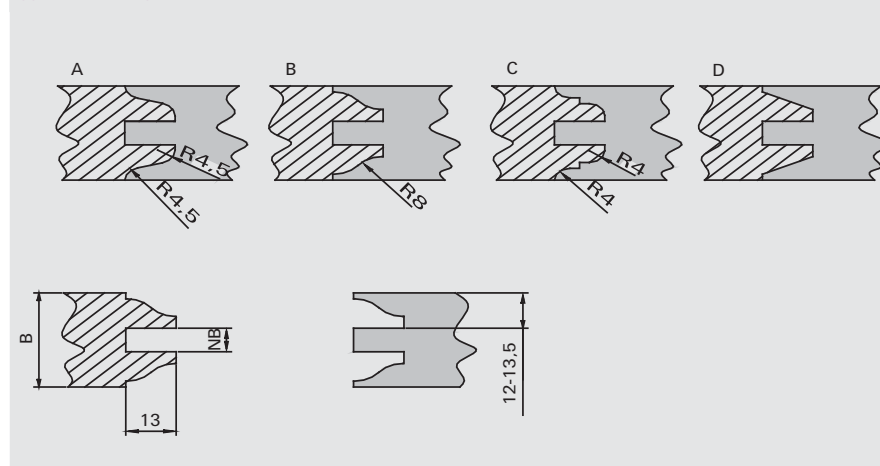


LEUCO
CNC

Tungsten Carbide [HW]

MEC

Application example



Machine / Application

- CNC routers
- for length- and counterprofiles on furniture parts, e.g. doors in solid woods and wood-based panels

Design

- basis number of wings Z=2
- Ø 100 mm: n max = 14,500 min-1

Advantages

- 4 profiles in the same body
- complete machining in one pass

Notes

- standard delivery with profile B, groove 8 - 15 x 13 mm
- optionally groove 5 - 9,5 x 13 mm possible
- available for clockwise and counter-clockwise rotation
- wrenches are not included in delivery
- mounting-set Ident-No.9210474
- please order shank-tool holder separately

Ø D	Ø D1	B	Ø d	Type		Ident-No.
96	70	34-42	25	1	X-1, X-2	199389
96	70	34-42	25	2	X-1, C-1, X-2	199390
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
Turnover Knives	20	12	1.5	C	150515	10	003082
	[mm]	[mm]	[mm]				[pc.]

Grooving Knives	B	Tmax	Cutterhead	Class-No.	PU	Ident-No.	
	8	13	X-1	150512	10	882483	
	8	13	X-2	150512	10	882460	
	5,0	13	X-1, X-2	150512	10	879870	
	[mm]	[mm]			[pc.]		
Spare parts			Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	for grooving knife		M5x11 T20	995125	10	879871	
			[mm]		[pc.]		
Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
profile A left	30	26	2.0	X-1	151521	10	882465
profile A right	30	26	2.0	X-2	151522	10	882466
profile B left	30	26	2.0	X-1	151521	10	882463
profile B right	30	26	2.0	X-2	151522	10	882464
profile C left	30	26	2.0	X-1	151521	10	882461
profile C right	30	26	2.0	X-2	151522	10	882462
profile D left	30	26	2.0	X-1	151521	10	882467
profile D right	30	26	2.0	X-2	151522	10	882468
	[mm]	[mm]	[mm]			[pc.]	

128660 Modula Panel Raising Cutterheads HW

Product	Drawing	
		<p>LEUCO CNC</p> <p>Tungsten Carbide [HW]</p> <p>MEC</p>

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for panel raising and profiling in solid woods and wood-based panels 	<ul style="list-style-type: none"> basis number of wings Z=2 Ø 140 mm: n max = 9,000 min-1 		<ul style="list-style-type: none"> further profiles are possible according to customer specifications wrenches are not included in delivery mounting-set Ident-No.9210474 please order shank-tool holder separately

R	Ø D	B	B1	Ø d	Ident-No.
20	140	55	30	25	888504
[mm]	[mm]	[mm]	[mm]	[mm]	

Knives for bottom cutting edge	B	H	S	Class-No.	PU	Ident-No.
	48	12	1.5	151521	10	888511 s
	[mm]	[mm]	[mm]		[pc.]	

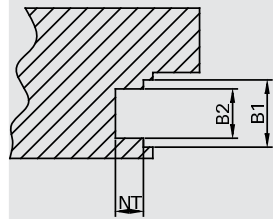
Knives for peripheral cutting edge	R	B	H	S	Class-No.	PU	Ident-No.
	20	30	25	1.5	151766	10	889076 s
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Support plate for peripheral cutting edge	R	B	H	Class-No.	PU	Ident-No.
	20	30	25	925300	2	889077
	[mm]	[mm]	[mm]			

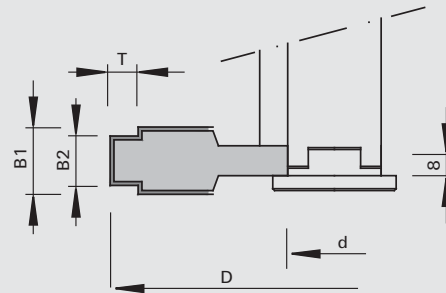
128660

Modula Step Grooving Cutterheads HW

Product



Drawing



LEUCO
GNC

Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for grooving of notches in solid woods and wood-based panels for safety-locks and fittings

Design

- l basis number of wings Z=2
- l n max = 12,000 min-1

Advantages

- l less chipping thanks to divided cut

Notes

- l application against feed
- l step groove for 18 and 20 mm possible with same cutter body by changing of profile knives
- l can be combined with other Modula cutterheads
- l wrenches are not included in delivery
- l Mounting Set Ident-No.9210474
- l please order shank tool holder separately

Ø D	B1	B2	Ø d	Tmax	Type	Ident-No.
120	18,1	13,2	25	7,5	R	879990
120	20,1	15,2	25	7,5	R	881190
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	B1	H	S	Class-No.	PU	Ident-No.
	18,1	13,2	20	2.0	150515	10	881106
	20,1	15,2	20	2.0	150515	10	881183
	[mm]	[mm]	[mm]	[mm]		[pc.]	

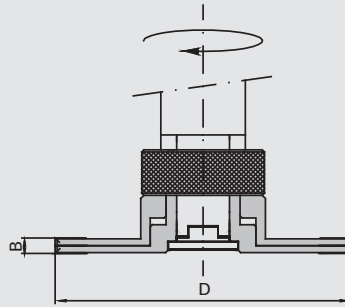
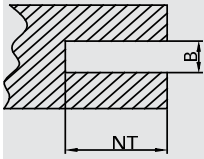
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M5x10	995161	10	881087
Pressure Bars	B=18	925300	2	881105
Magnetic Stops	1,0	997800	1	166094
	[mm]		[pc.]	

128660

Modula Grooving Cutterheads HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
| for grooving in solid woods and wood-based panels

Design

| basis number of wings Z=2
| n max = 11,000 min-1

Advantages

| unique adjusting unit with threaded bush

Notes

| play-free adjustment thanks to setting ring gauge
| fine-adjustment scale with 0,1 mm increments
| wrenches are not included in delivery
| mounting-set Ident-No.92 10474
| please order shank-tool holder separately

Ø D	B	Ø d	Tmax	Z		Ident-No.
140	4,0-7,5	25	40	4+4+4	with spurs	889645
140	7,5-11	25	40	4+2+4	with spurs	889876
150	10-18	25	45	2+2+4	with spurs	9201087
[mm]	[mm]	[mm]	[mm]			

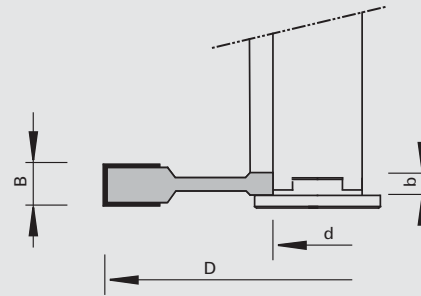
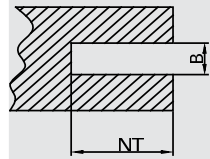
Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	9	12	1.5	889876	150515	10	167256
Turnover Knives	9,6	12	1.5	9201087	150515	10	171163
Turnover Knives	7,5	12	1.5	889645, 889876	150515	10	052543
Spurs	14	14	1.2	889645, 889876	150558	10	163701
Spurs	14	14	2.0	9201087	150558	10	003079
	[mm]	[mm]	[mm]			[pc.]	

128660

Modula Planet Cutterheads HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for grooving of notches in solid woods and wood-based panels for fittings and drop-down seals (Planet) on doors

Design

- l number of teeth $Z = 3 + 3$
- l $n_{max} = 10,100 \text{ min}^{-1}$

Advantages

- l reduced cutting pressure and less chipping thanks to division of cut

Notes

- l application with feed
- l mountable lefthand or righthand
- l can be combined with other Modula cutterheads
- l wrenches are not included in delivery
- l Mounting Set Ident-No.9210474
- l please order shank tool holder separately

$\emptyset D$	B	b	$\emptyset d$	Z	Type	Ident-No.
150	13,1	7,0	25	3+3	I	9206343
[mm]	[mm]	[mm]	[mm]			

Knives	B	H	S	Class-No.	PU	Ident-No.
	7,0	12	1,5	until 1999	150515	10 881453
	9	12	1,5	from 2000	150515	10 167256
	[mm]	[mm]	[mm]			[pc.]

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M5x10	995161	10	881087
Pressure Bars	B=7,2	925100	2	870829
Magnetic Stops	1,0	997800	1	166094
	[mm]			[pc.]

120210

Modula Single Jointing/Rabbeting Cutterheads HW - Z=2

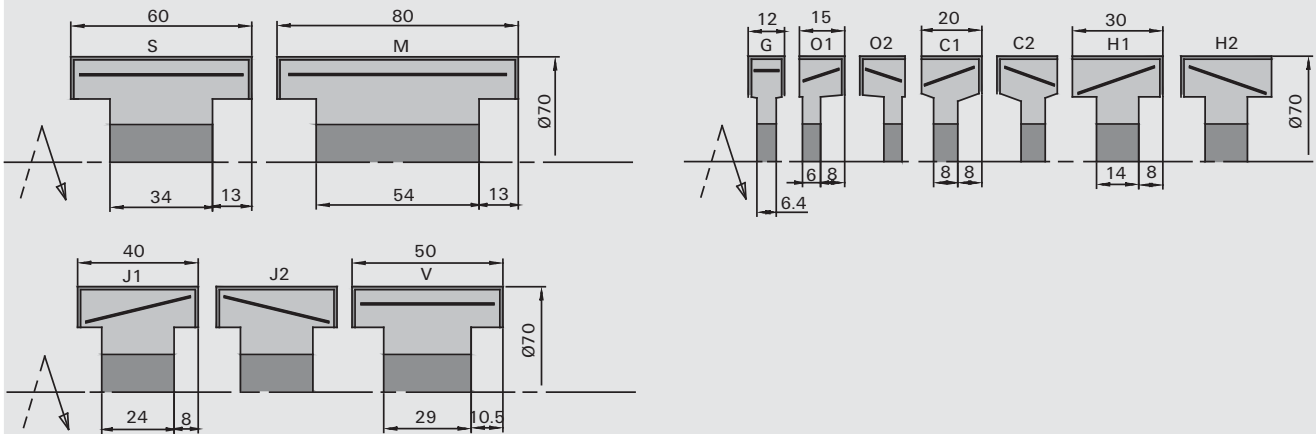
Product

Drawing

LEUCO
CNC

Tungsten Carbide [HW]

MEC



Machine / Application

- I** CNC routers
- I** for jointing and rabbeting in solid woods and wood-based panels

Design

- I** cutterheads with B = 15 mm to 40 mm with shear angle
- I** number of teeth Z = 2
- I** n max = 14,500 min⁻¹

Advantages

Notes

- I** to be used with corresponding shank adapters and in combination with other Modula cutterheads
- I** wrenches are not included in delivery
- I** mounting-set Ident-No.9210474

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	12	6.4	25	2	G	879829
70	15	6.0	25	2	O-1	879828
70	15	6.0	25	2	O-2	879833
70	20	8.0	25	2	C-1	879827
70	20	8.0	25	2	C-2	879832
70	30	14	25	2	H-1	879854
70	30	14	25	2	H-2	879855
70	40	24	25	2	J-1	882012
70	40	24	25	2	J-2	882013
70	50	29	25	2	V	9201908
70	60	34	25	2	S	888526
70	80	54	25	2	M	888527
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
Turnover Knives	12	12	1.5	G	150515	10	003080
Turnover Knives	15	12	1.5	O-1, O-2	150515	10	003081
Turnover Knives	20	12	1.5	C-1, C-2	150515	10	003082
Turnover Knives	30	12	1.5	H-1, H-2	150515	10	003083
Turnover Knives	40	12	1.5	J-1, J-2	150515	10	164078
Turnover Knives	50	12	1.5	V	150515	10	003085
	[mm]	[mm]	[mm]			[pc.]	

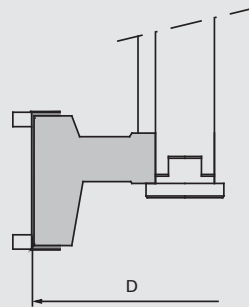
Turnover Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
Turnover Knives	60	12	1.5	S	150515	10	003086
Turnover Knives	80	12	1.5	M	150512	10	888545
	[mm]	[mm]	[mm]			[pc.]	
Spare parts	Dimension			Cutterhead	Class-No.	PU	Ident-No.
Set Screws	M5x10				995161	10	881087
Pressure Bars	B=10			G, O-1, O-2	925300	2	164526
Pressure Bars	B=18			C-1, C-2	925300	2	164076
Pressure Bars	B=30			H-1, H-2	925300	2	164185
Pressure Bars	B=40			J-1, J-2	925300	2	882014
Pressure Bars	B=50			V	925300	2	883382
Pressure Bars	B=60			S	925300	2	888543
Pressure Bars	B=80			M	925300	2	888544
Magnetic Stops	1,0				997800	1	166094
	[mm]					[pc.]	

120260

Modula Single Rabbeting Cutterheads HW - Z=3 + Z=4

Product

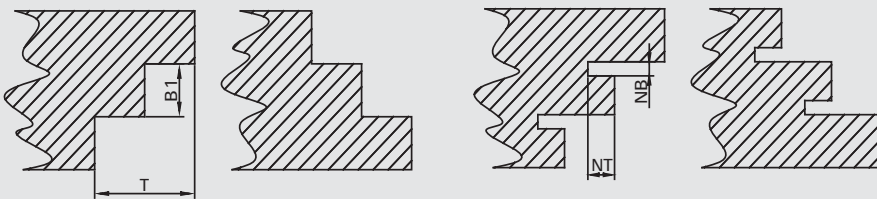
Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC



Machine / Application

- CNC routers
- for jointing and rabbeting in solid woods and wood-based panels

Design

- number of teeth Z=3 + Z=4
- with shear angle
- body made of aluminum
- n max = 10,700 min-1

Advantages

Notes

- to be used with corresponding shank adapters and in combination with other Modula cutterheads
- optionally grooving knives can be used
- wrenches are not included in delivery
- mounting-set Ident-No.92 10474

Ø D	B	b	Ø d	Tmax	Z	Ident-No.
140	38	25.6	25	47	3+6+6V	9205913
140	48	35.6	25	47	3+6+6V	9205912
140	60,4	30	25	47	4+4+8V	9208731
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Turnover Knives	39,2	12	1.5	150515	10	9203225
Turnover Knives	49,2	12	1.5	150515	10	9203226
Turnover Knives	60	12	1.5	150515	10	003086
Grooving Knives	4,0	8,0		150512	10	879869
Grooving Knives	4,0	13		150512	10	881180
Grooving Knives	5,0	8,0		150512	10	888747
Grooving Knives	5,0	8,0		150512	10	888748
Grooving Knives	5,0	13		150512	10	888749
Grooving Knives	5,0	13		150512	10	888750
	[mm]	[mm]	[mm]			[pc.]

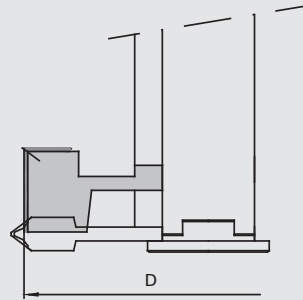
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws	for grooving knives	M5x11 T20	For all	995125	10 879871
Countersunk Screws	for spurs	M5x7 T15	For all	995125	10 900512
Set Screws		M6x20	For all	995161	2 9204674
Pressure Bars		B=38	9205913	925300	2 9205914
Pressure Bars		B=48	9205912	925300	2 9201835
Pressure Bars		B=58	9208731	925300	2 876809
	[mm]				[pc.]

120210

Modula Single Rabbeting Cutterheads HW - Z=2

Product

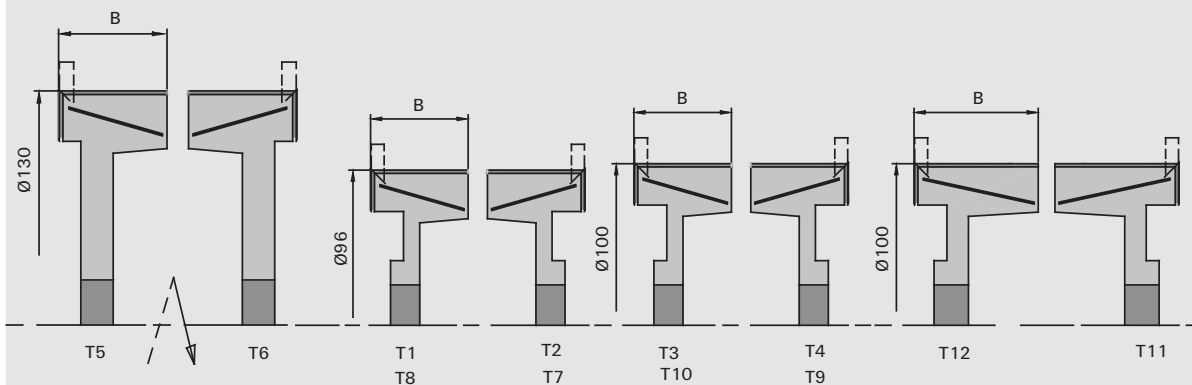
Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC



Machine / Application

- l CNC routers
- l for jointing and rabbeting in solid woods and wood-based panels

Design

- l number of teeth Z = 2
- l with shear angle
- l Ø 100 mm: n max = 14,500 min-1
- l Ø 130 mm: n max = 11,500 min-1

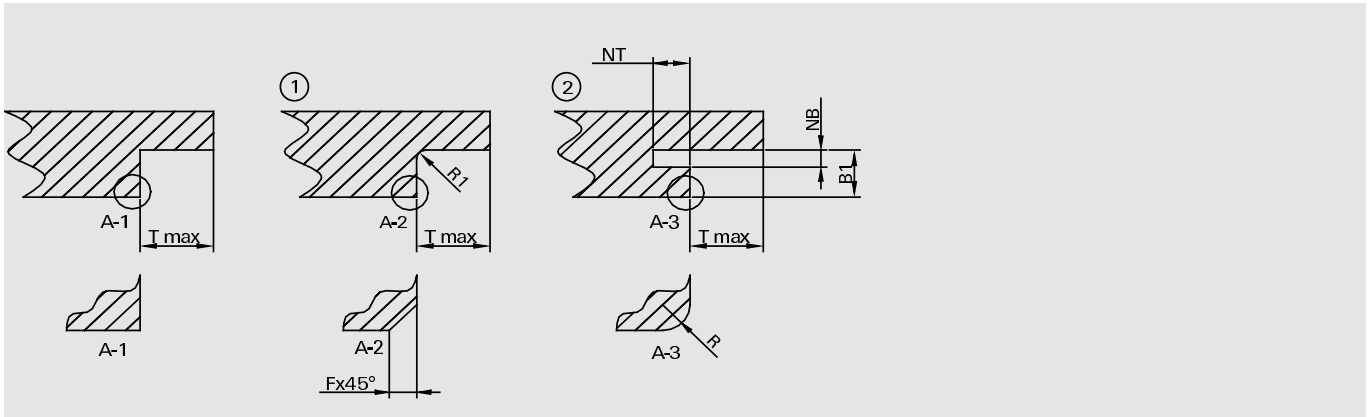
Advantages

- l high flexibility thanks to modular design

Notes

- l to be used with corresponding shank adapters and in combination with other Modula cutterheads
- l wrenches are not included in delivery
- l mounting-set Ident-No.9210474

Ø D	B	b	Ø d	Z	Type	Ident-No.
96	30	9.0	25	2+2V	T-1	888467
96	30	9.0	25	2+2V	T-2	888466
96	40	15.5	25	2+2V	T-8	889427
96	40	15.5	25	2+2V	T-7	889426
100	30	9.0	25	2+2V	T-3	888524
100	30	9.0	25	2+2V	T-4	888523
100	40	15.5	25	2+2V	T-10	889429
100	40	15.5	25	2+2V	T-9	889428
100	50	16	25	2+2V	T-12	9208892
100	50	16	25	2+2V	T-11	9208893
130	30	9.0	25	2+2V	T-5	888525
130	30	9.0	25	2+2V	T-6	888522
[mm]	[mm]	[mm]	[mm]			



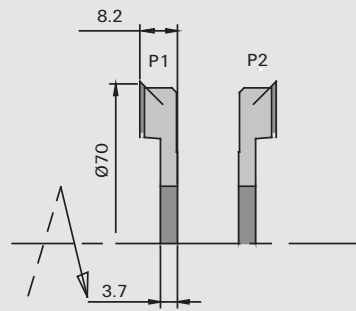
Turnover Knives	B	H	S	Cutterhead	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	T-1 to T-10	150558	10	003079
Radius Spurs	13	15	2.0		150552	10	888476
Turnover Knives	30	12	1.5	T-1 to T-6	150515	10	003083
Turnover Knives	40	12	1.5	T-7 to T-10	150515	10	164078
Turnover Knives	50	12	1.5	T-11, T-12	150515	10	003085
Grooving Knives	4,0	8,0			150512	10	879869
Grooving Knives	4,0	13		T-1 to T-10	150512	10	881180
Grooving Knives	5,0	8,0		T-1, T-3, T-5, T-8, T-10, T12	150512	10	888747
Grooving Knives	5,0	8,0		T-2, T-4, T-6, T-7, T-9, T11	150512	10	888748
Grooving Knives	5,0	13		T-1, T-3, T-5, T-8, T-10	150512	10	888749
Grooving Knives	5,0	13		T-2, T-4, T-6, T-7, T-9	150512	10	888750
	[mm]	[mm]	[mm]			[pc.]	
Spare parts			Dimension		Class-No.	PU	Ident-No.
Countersunk Screws	for grooving knife		M5x11 T20		995125	10	879871
Countersunk Screws	for spur		M5x7 T15		995125	10	900512
Set Screws			M5x10		995161	10	881087
Pressure Bars			B=30		925300	2	164185
Pressure Bars			B=40		925300	2	882014
Pressure Bars			B=50		925300	2	883382
Magnetic Stops	T-11, T-12		0,0		997800	1	016613
Magnetic Stops	T-1 to T-10		1,0		997800	1	166094
			[mm]			[pc.]	

120200

Modula Single Pre-Cut Cutterheads HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
| for scoring in solid woods and wood-based panels

Design

| number of teeth $Z = 2$
| $n_{max} = 14,500 \text{ min}^{-1}$

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No.9210474

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	8,2	3.7	25	2+2V	P-1	879831
70	8,2	3.7	25	2+2V	P-2	879834
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079
Radius Spurs	13	15	2.0	150552	10	888476
	[mm]	[mm]	[mm]		[pc.]	

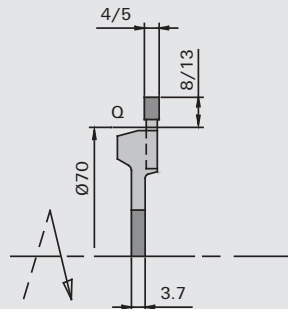
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x7 T15	995125	10	900512
	[mm]		[pc.]	

120200

Modula Single Grooving Cutterheads HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

Design

Advantages

Notes

| CNC routers
| for grooving in solid woods and wood-based panels

| number of teeth Z = 2
| n max = 14,500 min-1

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No.92 10474

Ø D	B	Ø d	Tmax	Z	Type	Ident-No.
70	4,0	25	8,0	2	Q	879835
70	4,0	25	13	2	Q	881153
70	5,0	25	8,0	2	Q	881154
70	5,0	25	13	2	Q	881155
[mm]	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	13	150512	10	881180
	4,0	8,0	150512	10	879869
	5,0	13	150512	10	879870
	5,0	8,0	150512	10	881179
	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	for grooving knife	M5x11 T20	995125	10	879871
		[mm]		[pc.]	

120610

Modula Single Chamfering Cutterheads HW

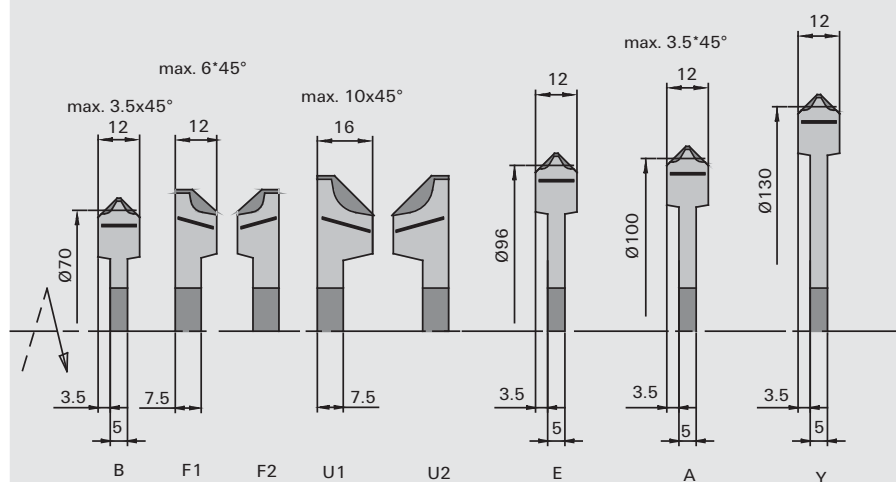
Product

Drawing



Tungsten Carbide [HW]

MEC



Machine / Application

| CNC routers
 | for chamfering in solid woods and wood-based panels

Design

| number of teeth Z = 2
 | Ø 108 mm: n max = 14,500 min-1
 | Ø 138 mm: n max = 11,500 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No.9210474

Chamfer	Ø D	B	Ø d	Z	Type	Ident-No.
45	78	12	25	2	B	879830
45	82	12	25	2	F-1	881879
45	82	12	25	2	F-2	881878
45	90	16	25	2	U-1	881882
45	90	16	25	2	U-2	881885
45	104	12	25	2	E	888737
45	108	12	25	2	A	879845
45	138	12	25	2	Y	880580
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer	B	S	Cutterhead	Class-No.	PU	Ident-No.
	45	12	1.5	A, B, E, Y	151545	10	180792
	45	12	2.0	F-1	151545	10	881855
	45	12	2.0	F-2	151545	10	881856
	45	16	2.0	U-1	151545	10	881874
	45	16	2.0	U-2	151545	10	881875
	[°]	[mm]	[mm]			[pc.]	

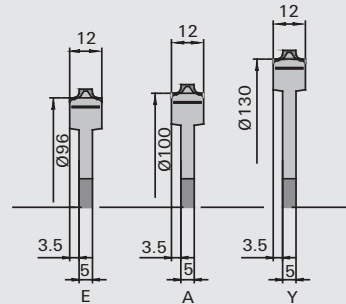
Spare parts	Dimension	Cutterhead	Class-No.	PU	Ident-No.
Set Screws	M5x10		995161	10	881087
Pressure Bars	B=12	A, B, E, Y	925100	2	881496
Pressure Bars	B=10	F-1, F-2	925300	2	164526
Pressure Bars	B=16	U-1	925300	2	881876
Pressure Bars	B=16	U-2	925300	2	881877
Magnetic Stops	0,0		997800	1	016613
	[mm]			[pc.]	

120210

Modula Single Rounding Cutterheads HW

Product

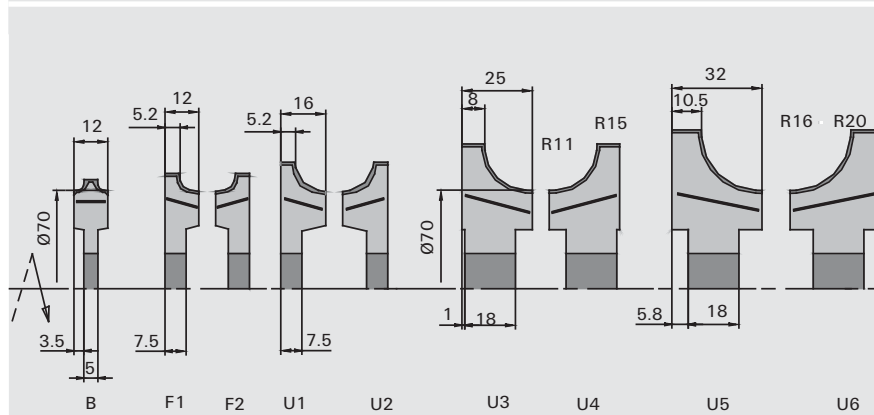
Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC



Machine / Application

- | CNC routers
- | for rounding of solid woods and wood-based panels

Design

- | number of teeth Z = 2
- | Ø 108 mm: n max = 14,500 min-1
- | Ø 138 mm: n max = 11,500 min-1

Advantages

Notes

- | to be used with corresponding shank adapters and in combination with other Modula cutterheads
- | wrenches are not included in delivery
- | mounting-set Ident-No.9210474

R	Ø D	B	Ø d	Z	Type	Ident-No.
2,0	78	12	25	2	B	881166
3,0	78	12	25	2	B	881167
4,0	82	12	25	2	F-1	879984
4,0	82	12	25	2	F-2	879985
5,0	82	12	25	2	F-1	881170
5,0	82	12	25	2	F-2	881172
6,0	82	12	25	2	F-1	881171
6,0	82	12	25	2	F-2	881173
8,0	90	16	25	2	U-1	881880
8,0	90	16	25	2	U-2	881883
10	90	16	25	2	U-1	881881
10	90	16	25	2	U-2	881884
2,0	104	12	25	2	E	888738
3,0	104	12	25	2	E	888739
[mm]	[mm]	[mm]	[mm]			

R	Ø D	B	Ø d	Z	Type	Ident-No.
2,0	108	12	25	2	A	881168
3,0	108	12	25	2	A	881169
2,0	138	12	25	2	Y	880581
3,0	138	12	25	2	Y	880582
11	103	25	25	2	U-3	9202138
11	103	25	25	2	U-4	9202139
12	103	25	25	2	U-3	9202140
12	103	25	25	2	U-4	9202141
13	103	25	25	2	U-3	9202142
13	103	25	25	2	U-4	9202143
14	103	25	25	2	U-3	9202144
14	103	25	25	2	U-4	9202145
15	103	25	25	2	U-3	9202146
15	103	25	25	2	U-4	9202147
16	113	32	25	2	U-5	9202128
16	113	32	25	2	U-6	9202129
17	113	32	25	2	U-5	9202130
17	113	32	25	2	U-6	9202131
18	113	32	25	2	U-5	9202132
18	113	32	25	2	U-6	9202133
19	113	32	25	2	U-5	9202134
19	113	32	25	2	U-6	9202135
20	113	32	25	2	U-5	9202136
20	113	32	25	2	U-6	9202137
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	PU	Ident-No.
	2,0	12	1.5	A, B, E, Y	151545	10	170340
	3,0	12	1.5	A, B, E, Y	151545	10	170341
	4,0	12	2.0	F-1	151545	10	881189
	4,0	12	2.0	F-2	151545	10	881188
	5,0	12	2.0	F-1	151545	10	881187
	5,0	12	2.0	F-2	151545	10	881186
	6,0	12	2.0	F-1	151545	10	879987
	6,0	12	2.0	F-2	151545	10	879988
	8,0	16	2.0	U-1	151545	10	881870
	8,0	16	2.0	U-2	151545	10	881871
	10	16	2.0	U-1	151545	10	881872
	10	16	2.0	U-2	151545	10	881873
	11	25	2.0	U-3	151545	10	9201953 o
	11	25	2.0	U-4	151545	10	9201954 o
	12	25	2.0	U-3	151545	10	9201951 o
	12	25	2.0	U-4	151545	10	9201952 o
	13	25	2.0	U-3	151545	10	9201949 o
	13	25	2.0	U-4	151545	10	9201950 o
	14	25	2.0	U-3	151545	10	9201947 o
	14	25	2.0	U-4	151545	10	9201948 o
	15	25	2.0	U-3	151545	10	9201913 o
	15	25	2.0	U-4	151545	10	9201914 o
	16	32	2.0	U-5	151545	10	9201961 o
	16	32	2.0	U-6	151545	10	9201962 o
	17	32	2.0	U-5	151545	10	9201959 o
	17	32	2.0	U-6	151545	10	9201960 o
	18	32	2.0	U-5	151545	10	9201957 o
	18	32	2.0	U-6	151545	10	9201958 o
	19	32	2.0	U-5	151545	10	9201955 o
	19	32	2.0	U-6	151545	10	9201956 o
	20	32	2.0	U-5	151545	10	9201936 o
	20	32	2.0	U-6	151545	10	9201937 o
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	Cutterhead	Class-No.	PU	Ident-No.
Set Screws	M5x10		995161	10	881087
Pressure Bars	B=12	A, B, E, Y, F-1, F-2	925100	2	881496
Pressure Bars	B=16	U-1	925300	2	881876
Pressure Bars	B=16	U-2	925300	2	881877
Pressure Bars	B=25	U-3	925300	2	9201887
Pressure Bars	B=25	U-4	925300	2	9201888
Pressure Bars	B=32	U-5	925300	2	9201883
Pressure Bars	B=32	U-6	925300	2	9201884
Magnetic Stops	0,0 [mm]		997800	1	016613

120610

Modula Single Chamfering Cutterheads HW - machining of aluminum

Product	Drawing	
		<p>LEUCO CNC</p> <p>Tungsten Carbide [HW]</p> <p>MEC</p>

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for chamfering in aluminum 	<ul style="list-style-type: none"> number of teeth Z = 2 Ø 111mm: n max = 14,500 min-1 Ø 141 mm: n max = 11,500 min-1 		<ul style="list-style-type: none"> to be used with corresponding shank adapters and in combination with other Modula cutterheads wrenches are not included in delivery mounting-set Ident-No.9210474

Chamfer	Ø D	B	Ø d	Z	Type	Ident-No.
45	107	16	25	2	D-2	888528
45	111	16	25	2	D-4	888529
45	141	16	25	2	D-6	888530
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer	B	S	Class-No.	PU	Ident-No.
	45	16	2.0	151545	10	170329
	[°]	[mm]	[mm]			[pc.]

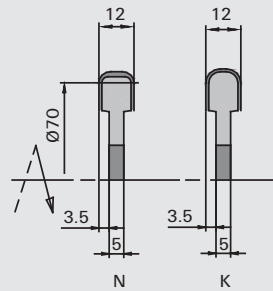
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M5x10	995161	10	881087
Pressure Bars	B=16	925300	2	888887
Magnetic Stops	0,0 [mm]	997800	1	016613

120610

Modula Single Concave Cutterheads HW

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

l CNC routers
l for coves in solid woods and wood-based panels

Design

l number of teeth Z = 2
l n max = 14,500 min-1

Advantages

Notes

l to be used with corresponding shank adapters and in combination with other Modula cutterheads
l wrenches are not included in delivery
l mounting-set Ident-No.9210474

R	Ø D	B	Ø d	Z	Type	Ident-No.
3,0	78	12	25	2	N	879859
4,0	78	12	25	2	N	881164
5,0	82	12	25	2	K	879858
6,0	82	12	25	2	K	881165
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	PU	Ident-No.
	3,0	12	2.0	N	151521	10	881185
	4,0	12	2.0	N	151521	10	881184
	5,0	12	2.0	K	151521	10	879861
	6,0	12	2.0	K	151521	10	879860
	[mm]	[mm]	[mm]			[pc.]	

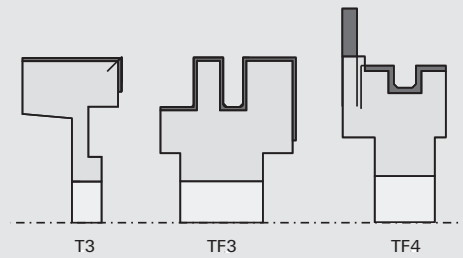
Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M5x10	995161	10	881087
Pressure Bars	B=12	925300	2	881488
Magnetic Stops	1,0	997800	1	166094
	[mm]		[pc.]	

120210

Modula Single Cutterheads HW - production of door casings

Product

Drawing



LEUCO
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC routers
| for door casings in solid woods and wood-based panels

Design

| number of teeth Z = 2
| n max = 14,500 min-1

Advantages

| machining of both sides with the same set

Notes

| for use with corresponding shank adapters and in combination with other Modula cutterheads
| wrenches are not included in delivery
| Mounting Set Ident-No.9210474
| tools for one-sided operation upon request

Ø D	B	b	Ø d	Z	Type	Ident-No.
100	22	16.3	25	2	TF-4	9202564
100	41	25	25	2	TF-3	9202563
100	30	9.0	25	2+2V	T-3	888524
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Profile Turnover Knives	22,3	18	2.0	TF-4	151556	10	885906
Profile Turnover Knives	41	28.2	2.0	TF-3	151556	10	9202581
Turnover Knives	30	12	1.5	T-1 to T-6	150515	10	003083
Spurs	14	14	2.0	T-3	150558	10	003079
Profile Turnover Knives	10	13.5	1.5	profile up to 2006	151556	10	888963
	[mm]	[mm]	[mm]			[pc.]	

Grooving Knives	B	Tmax	Class-No.	PU	Ident-No.
	4,0	13	150512	10	881180
	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Cutterhead	Class-No.	PU	Ident-No.
Countersunk Screws	M5x11 T20	for grooving knife	995125	10	879871
Pressure Bars	B=18		925300	2	164076
Pressure Bars	B=40		925300	2	882014
Pressure Bars	B=30		925300	2	164185
Set Screws	M5x10		995161	10	881087
	[mm]			[pc.]	

120210

Modula Single Counter Profile Cutterheads HW

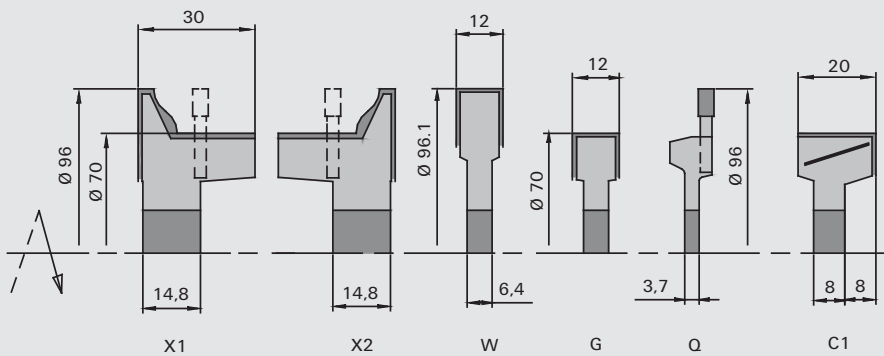
Product

Drawing



Tungsten Carbide [HW]

MEC



Machine / Application

| CNC routers
 | for length- and counterprofiles
 | in solid wood and wood-based
 | materials

Design

| number of teeth Z = 2
 | n max = 14,500 min-1

Advantages

Notes

| to be used with correspond-
 | ing shank adapters and in
 | combination with other
 | Modula cutterheads
 | wrenches are not included in
 | delivery
 | mounting-set Ident-
 | No.9210474

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	20	8.0	25	2	C-1	879827
70	12	6.4	25	2	G	879829
70	5,0		25	2	Q	881155
96	12	6.4	25	2	W	882457
96	30	14.8	25	2	X-2	882458
96	30	14.8	25	2	X-1	882459
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Cutterhead

Class-No.

PU

Ident-No.

Set Screws	M5x10		995161	10	881087
Pressure Bars	B=10	W, G	925300	2	164526
Pressure Bars	B=18	C-1, C-2	925300	2	164076
Pressure Bars	B=30	X-1, X-2	925300	2	882473
Magnetic Stops	1,0		997800	1	166094
	[mm]			[pc.]	

150512 / 150521

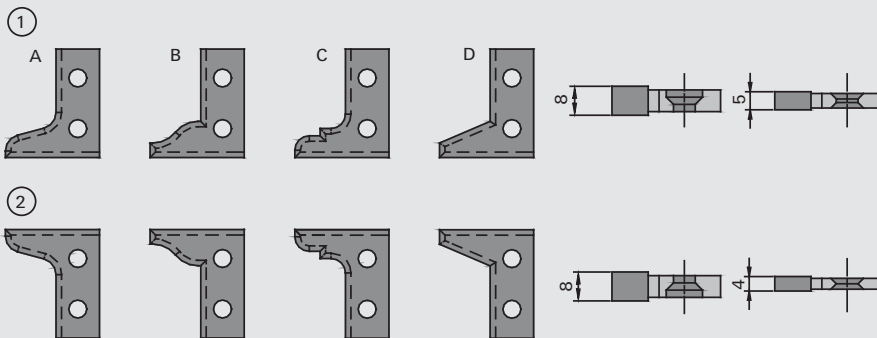
Modula Turnover Knives, Profile Knives HW

Product

Drawing



Tungsten Carbide [HW]



Machine / Application

l for length- and counterprofiles in solid wood and wood-based materials

Design

l number of teeth $Z = 2$

Advantages

Notes

l type 1 for cutterheads lefthand X-1
l type 2 for cutterheads righthand X-2

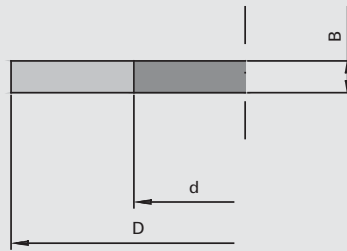
	B	H	S	Type	Ident-No.
grooving knives l + r	4,0	13			881180
grooving knives l + r	5,0	13			879870
grooving knives left	8			X-1	882483
grooving knives right	8			X-2	882460
raker	12	12	1.5		003080
raker	20	12	1.5	W, G	003082
profile A left	30	26	2.0	C-1	882465
profile A right	30	26	2.0	X-1	882466
profile B left	30	26	2.0	X-2	882463
profile B right	30	26	2.0		882464
profile C left	30	26	2.0		882461
profile C right	30	26	2.0		882462
profile D left	30	26	2.0		882467
profile D right	30	26	2.0		882468
	[mm]	[mm]	[mm]		

955520

Modula Spacers

Product

Drawing



Machine / Application

Design

Advantages

Notes

I special spacers with double keyway for Modula tool system

Ø D	B	Ø d	DKN	Ident-No.	
40	20	25	DKN	879880	
40	10	25	DKN	879881	
40	6,0	25	DKN	879882	
40	5,0	25	DKN	879883	
40	4,0	25	DKN	879884	
40	2,0	25	DKN	879885	
40	1,0	25	DKN	879886	
40	1,0	25	DKN	set 3x0,2 + 4x0,1	881178
40	0,5	25	DKN	879887	
40	0,2	25	DKN	881029	
40	0,1	25	8x3,3	881028	
[mm]	[mm]	[mm]	[mm]		

985700

Modula Mounting Sets

Product	Drawing	
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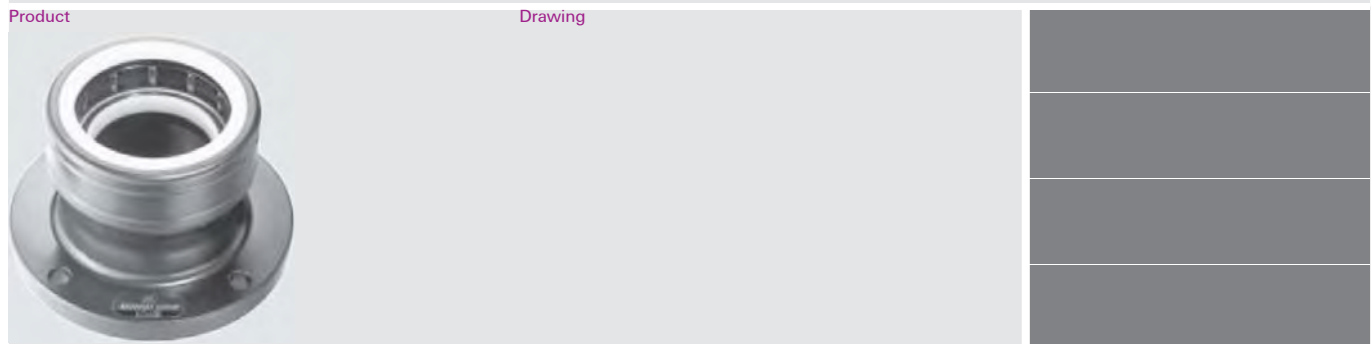
Machine / Application	Design	Advantages	Notes
			<ul style="list-style-type: none"> all Modula cutterheads and sets will be generally supplied without mounting tools; therefore please order the complete mounting-set once the supplied Ø 25mm arbor allows for simplest changing of the cutterheads

	Ident-No.
complete mounting-set	9210474

Content Mounting Set	Dimension	Class-No.	PU	Ident-No.
Screwdrivers	T20	985730	1	9210391
Screwdrivers	T15x80	985730	1	171188
Magnetic Stops	0,5	997800	1	166093
Magnetic Stops	1,0	997800	1	166094
Copper Paste		993420	1	879330
Torque Screwdrivers		985730	1	9210355
Hexagon Insert	SW2,5	985730	1	9210356
Screwdrivers	SW4x100	985730	1	166091
Screwdrivers	SW6	985730	1	881191
Mounting Aids	Ø25	995122	1	881194
	[mm]			[pc.]

985700

Mounting device for tools with HSK 63



<p>Machine / Application</p>	<p>Design</p>	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> for collet chucks, SINO clamping system and change of turnover knives etc. Tool-Support: with clamp lever for torsion protection; tiltable with latch at 90°; simple and secure handling Combi-Grip: especially for Sino clamping system; secure grip by roller clamp
------------------------------	---------------	-------------------	--

	<p>Ø d</p>	<p>Ident-No.</p>
<p>Kombi-Grip</p>	<p>HSK 63E + F [mm]</p>	<p>199874</p>

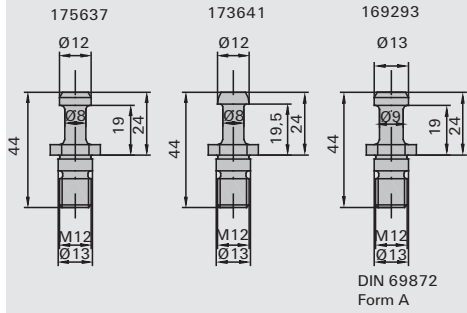


	<p>Ø d</p>	<p>Ident-No.</p>
<p>tool-man</p>	<p>HSK 63F</p>	<p>incl. 3-piece replacement clamping ring 9215520</p>
<p>Replacement clamping ring</p>	<p>HSK 63F [mm]</p>	<p>9205048</p>

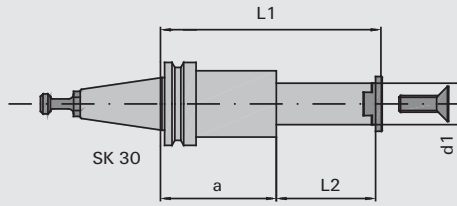
997200

Tool Adapters SK 30

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter SK 30
- | steep angle taper according to DIN 69871 without dog and locating grooves
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | please order retaining bolt separately
- | the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1 min	L2	L1	a	Ident-No.
SK 30	25	25-70	118	45	198971
SK 30	25	25-70	143	70	198973
SK 30	25	25-70	163	90	198975
SK 30	30	25-70	163		198977
[mm]	[mm]	[mm]	[mm]	[mm]	

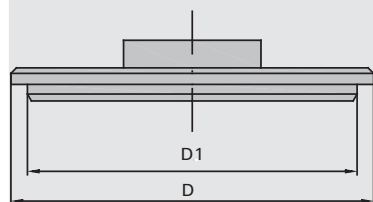
Spare parts

		Class-No.	PU	Ident-No.
Retaining Bolts	up to 08/92	997870	1	175637 o
Retaining Bolts	for SK 30	997870	1	169293
Retaining Bolts	Ø 12 mm - HSD motor	997870	1	173641
			[pc.]	

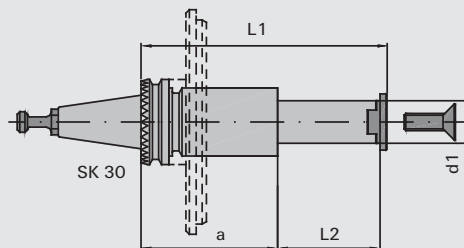
997200

Tool Adapters SK 30 with ring gear

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | adapter SK 30 Morbidelli and SCM
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | for Morbidelli 510 and SCM storage lids are not needed
- | for Morbidelli 503 and 504 a storage lid is necessary (to be ordered separately)
- | the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 30 [mm]	25 [mm]	25-70 [mm]	154 [mm]	80 [mm]	882166

Spare parts

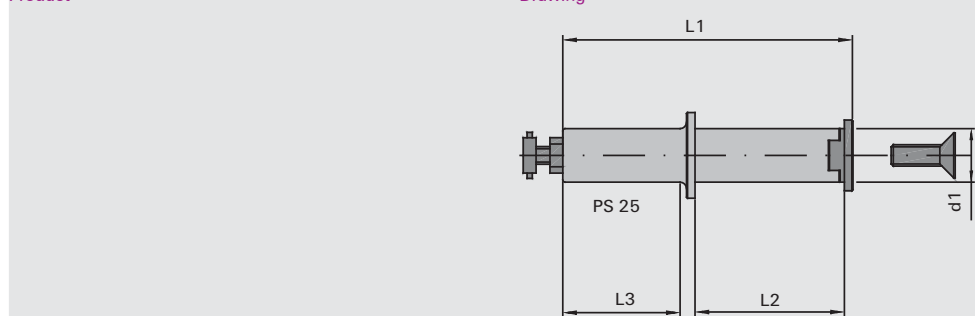
		Class-No.	PU	Ident-No.
Retaining Bolts	Morbidelli, SCM	997870	1	173646
Storage Lids	Morbidelli 503/504 Ø 125 mm	997300	1	882311
Storage Lids	Morbidelli 503/504 Ø 135 mm	997300	1	882308

[pc.]

997200

Tool Adapters PS 25

Product



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter PS 25 or collets
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | clamping length depending on application; please always state dimension L2

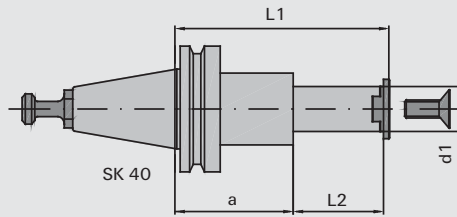
Ø d	L3	Ø d1min	L2	L1	Ident-No.
PS 25	126	25	4,5	135	199708
PS 25	113	25	12,5	135	198953
PS 25	101	25	25	135	198956
PS 25	81	25	45	135	198958
PS 25	55	25	71	135	198960

997200

Tool Adapters SK 40

Product

Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter SK 40
- | steep angle taper according to DIN 69871 without dog and locating grooves
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | incl. retaining bolt according to DIN 69871A
- | the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 40	30	25-80	163		198985
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Retaining Bolts

up to 08/92

Class-No.

PU

Ident-No.

997870

1

169294

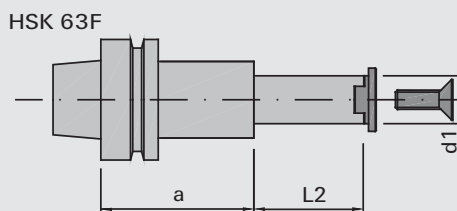
[pc.]

997200

Tool Adapters HSK 63F - Modula

Product

Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter HSK 63F
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

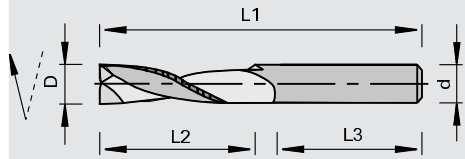
- | incl. retaining bolt according to DIN 69871A
- | the clamping length is determined as required; please always state requested dimensions L2 and A
- | retention bores for toolbooy is possible at a surcharge
- | ident. no. 198968 is a blank

Ø d	Ø d1min	L2	a	Ident-No.
HSK 63F	25	25-87	50	199720 &
HSK 63F	25	25-71	80	198967 &
HSK 63F	25	25-71	100	199719 &
HSK 63F	30	25-80	36	198968 &
[mm]	[mm]	[mm]	[mm]	

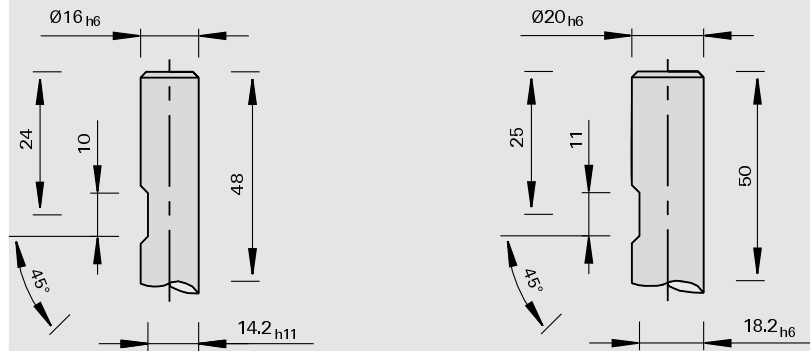
Solid Tungsten Carbide Shank-Type Cutters

Shank design for finishing cutter with chip breakers Class-No. 129460

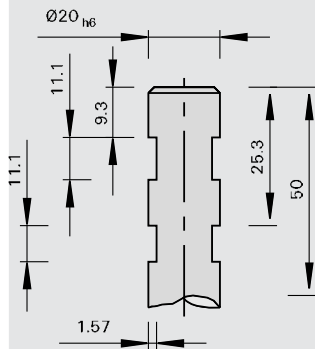
Cylindrical shank without clamping surface



For clamping in spacer sleeves according to DIN 6359 also called Weldon chuck

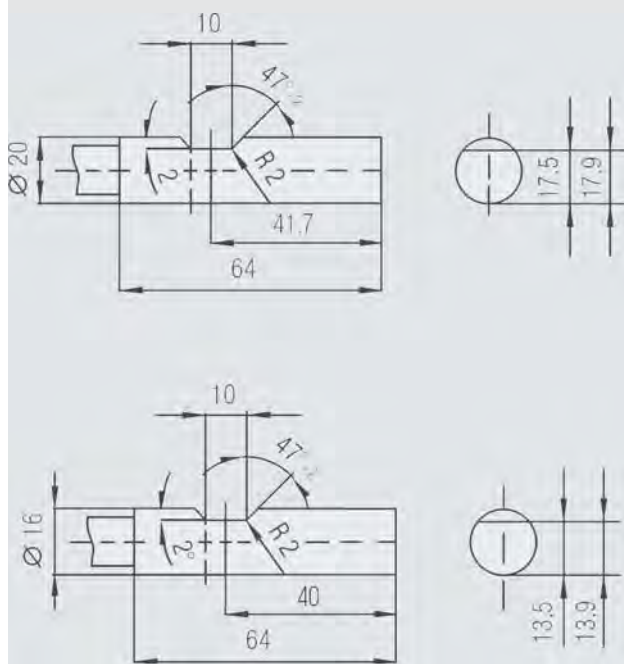


For clamping in special clamping chucks by MAKA

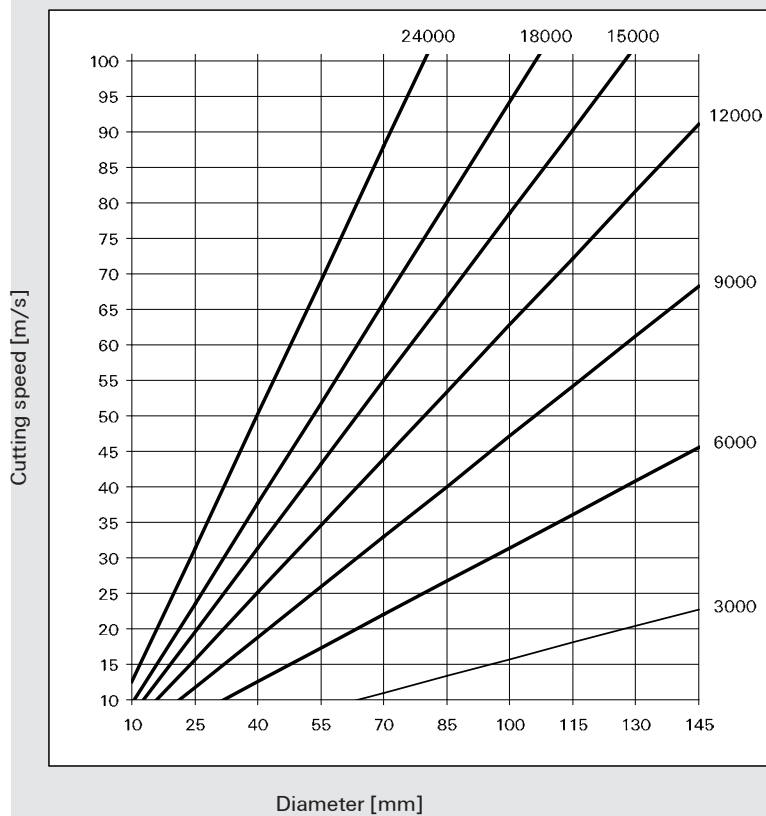


Clamping surface on Shank-Type Cutters

Particularly for solid carbide Lock-Case Cutters used in horizontal drilling/-milling aggregates of Homag and Weeke.



Determination of RPM [min-1]



Order / Inquiry for Special Tools: Shank-Type Cutters

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	<input type="radio"/>
Company:	_____	Inquiry:	<input type="radio"/>
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Maker: _____

Model: _____

Motor output [kW]: _____

RPM range [min-1]: _____

Feed rate [m/min]: _____

Workpiece material

Description: _____

Cutting quality:

Trimming cut	<input type="radio"/>
Finish cut	<input type="radio"/>

Direction of cut:

With grain	<input type="radio"/>
Across grain	<input type="radio"/>

Coating

Yes	<input type="radio"/>	No	<input type="radio"/>
-----	-----------------------	----	-----------------------

Description: _____

Further Information _____

Coating

Description: _____

Further Information _____

Tool

With tipped cutting edges:

With exchangeable cutting edges:

EcoPro Cutterhead	<input type="radio"/>
SuperProfiler	<input type="radio"/>
UltraProfiler	<input type="radio"/>
Standard	<input type="radio"/>

Cutting diameter D [mm]: _____

Cutting length L2 [mm]: _____

Cutting width B [mm]: _____

Overall length L1 [mm]: _____

Shank length L3 [mm]: _____

Shank design:

Cylindrical shank [Ø]: _____

Other shank types [MK2, HSK F63, ...] _____

Only solid carbide cutters: shank design [no.] _____

Type of feed:	MAN	<input type="radio"/>	<input type="radio"/>
Sense of rotation:	Left	<input type="radio"/>	Right <input type="radio"/>
Only solid carbide cutters: spiral	Positive	<input type="radio"/>	Negative <input type="radio"/>
No. of teeth [pcs.]:			
Rakers:	_____		
Spur:	_____		
Grooving knives:	_____		
Edge breaker:	_____		
Arrangement of cutting edges:			
Only peripheral cutting			<input type="radio"/>
With face cutting edge			<input type="radio"/>
With plunge tip			<input type="radio"/>
Shear angle:	Single-sided	<input type="radio"/>	Alternate <input type="radio"/>

Cutting material

Carbide	<input type="radio"/>	Diamond	<input type="radio"/>
Stellite	<input type="radio"/>	HS	<input type="radio"/>

Face side:

Top	<input type="radio"/>	Bottom	<input type="radio"/>
-----	-----------------------	--------	-----------------------

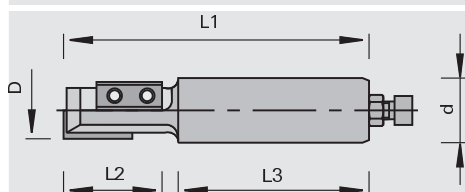
check if applicable

Please indicate the following on workpiece samples or drawings:

Bottom side of workpiece	Dimension
Sense of rotation	Application conditions
Motor spindle	Profile drawing
Workpiece support	Tool drawing

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.



519-01.0708



Drill Bits

Product	Page
Twist Drills	5-1
Through-Hole Bits	5-4
Dowel Bits	5-11
Boring Spikes	5-22
Countersink	5-23
Cylinder Boring Bits	5-27
Technical Information	5-33

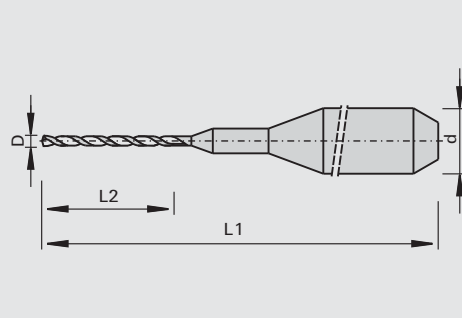
130010

Micro Twist Drills with solid carbide body

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for drilling micro bores in wood-based materials, particularly acoustic plates

Design

- | specific tip and spiral geometry
- | design in solid tungsten carbide
- | drill bits for left sense of rotation with color marking for easier identification

Advantages

- | good stability and hole quality
- | good chip evacuation

Notes

- | clamping element: adapter Ident-No. 186165
- | packing unit 10 pieces

Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
1.0	8,5	3,175	38.2	186167	186166
[mm]	[mm]	[mm]	[mm]		

Accessories

Adapters for micro twist drills

Dimension

Ø3,175x52xØ10
[mm]

Class-No.

933389

PU

1
[pc.]

Ident-No.

186165

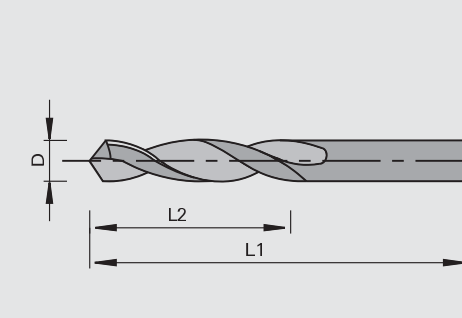
130010

Twist Drills with solid carbide body

Product



Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through holes and dowel holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges
- | solid carbide design
- | cutting Ø = shank Ø
- | tip angle 120°

Advantages

- | high feed rates possible
- | large resharpenable area

Notes

- | clamping element: draw-in collet chuck, adapter Class-No. 933389, drill chuck

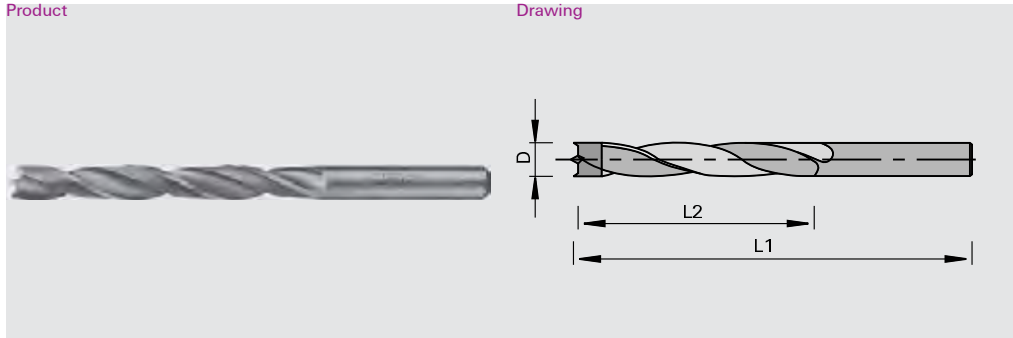
Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	25	50	182625	182626
2.5	27	55	182627	182628
3.0	27	55	182629	182630
3.5	27	52	182631	182632
4.0	27	55	182633	182634
5.0	28	60	182635	182636
[mm]	[mm]	[mm]		

130010

Twist Drills HW

Product

Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | centering point
- | cutting Ø = shank Ø
- | 2 negative spurs
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating
- | chip-free hole edges thanks to negative spurs

Notes

- | clamping element: draw-in collet chuck, drill chuck

Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
5.0	35	70	173145 o	167929
6.0	35	70		167930 o
8.0	35	70		167932 o
10	35	70	173150 o	167934 o
4.0	55	80		160503
4.5	60	85		160504 o
5.0	60	90		160505
5.5	65	100		164243 o
6.0	65	100		160506
6.5	70	110		164244 o
7.0	70	110		160507 o
8.0	75	120		160508
8.5	80	130		164245 o
9.0	80	130		160509 o
10	90	140		160510
11	95	150		160511 o
12	100	155		160512
[mm]	[mm]	[mm]		

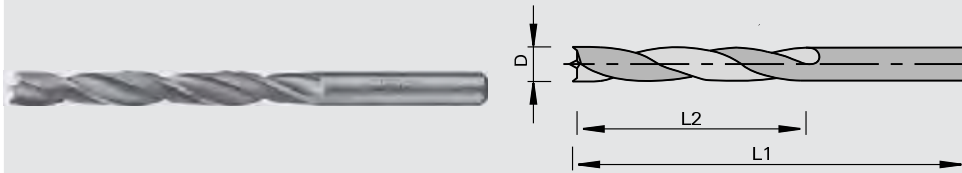


330010

Twist Drills HS

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for drilling of dowel holes in solid woods

Design

- | 2 spurs
- | centering point
- | special coating
- | cutting \varnothing = shank \varnothing
- | HS design

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point
- | long edge lives thanks to special coating

Notes

- | clamping element: draw-in collet chuck, drill chuck

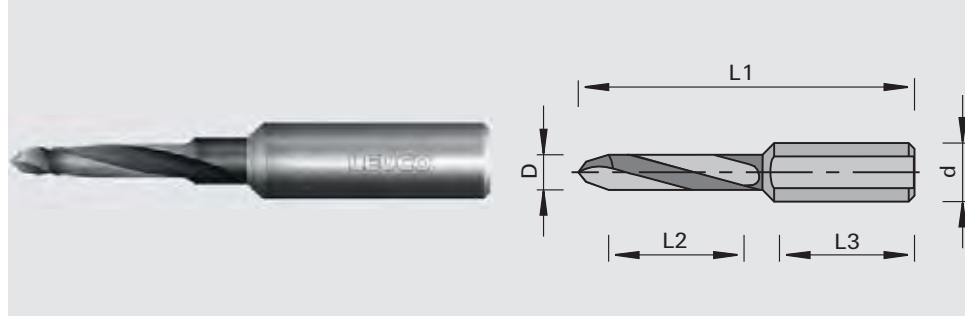
\varnothing D	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	22	49	167671	167669
2.5	25	57	167672	167670
3.0	30	61	160530	160518
3.5	35	70	160531 o	160519 o
4.0	40	75	160532	160520
4.5	45	80	160533 o	160521
5.0	45	83	160534	160522
5.5	50	90	160535 o	160523 o
6.0	50	90	160536 o	160524 o
6.5	55	98	177175 o	160525 o
7.0	60	105	177176 o	160526 o
7.5	60	105		177177 o
8.0	70	113	160539 o	160527
8.5	70	113		177178 o
9.0	75	120		160528 o
10	80	130		160529 o
[mm]	[mm]	[mm]		

130012

Through-Hole Bits VHW - topline

Product

Drawing

LEUCO
toplineLEUCO
DUR

Solid Tungsten Carbide

MAN

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | cylindrical shank with clamping surface
- | special cutting edge geometry
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | considerably increased edge lives compared to traditional through-hole bits thanks to special HW and special grinding
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | other dimensions possible; price and delivery time on request

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	10	25	57.5	185738	185737
8.0	25	10	25	57.5	185740	185739
5.0	30	10	30	70	185742	185741
8.0	30	10	30	70	185744	185743
[mm]	[mm]	[mm]	[mm]	[mm]		

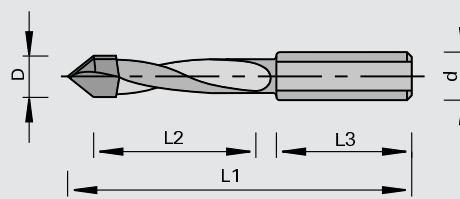
130013

Mosquito Through-Hole Bits HW

Product



Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | HW-plunging tip made from super-fine grain material

Advantages

- | chip-free hole edges thanks to special cutting edge geometry
- | long edge lives thanks to HW plunging tip
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

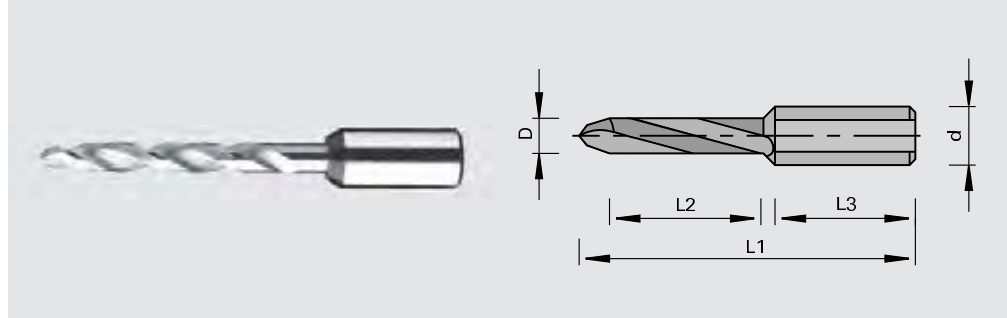
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	27	10	26	57.5	182458	182459
8.0	27	10	26	57.5	182460 o	182461 o
5.0	35	10	26	70	182462	182463
6.0	35	10	26	70	183689	183688
7.0	35	10	26	70	183691	183690
8.0	35	10	26	70	182464	182465
10	35	10	26	70	183693	183692
[mm]	[mm]	[mm]	[mm]	[mm]		

130013

Mosquito Through-Hole Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- boring part made from fine-grain solid tungsten carbide

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- through-hole bit with shank length L3=24 mm is not suitable for Weeke adjusting screw
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	27	10	30	70	183687	183686
4.0	35	10	24	70	183167	183166
5.0	35	10	24	70	183153	183152
6.0	35	10	24	70	183155	183154
8.0	35	10	24	70	183157	183156
10	35	10	24	70	186523	186524
[mm]	[mm]	[mm]	[mm]	[mm]		
Ø D	L2	Ø d	L3	L1	Ident-No. [R]	
6.0	35	10	50	100	for Lamello Clamex P®	184289
[mm]	[mm]	[mm]	[mm]	[mm]		

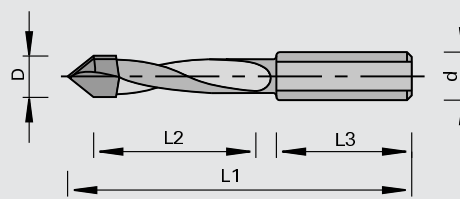
130011

EcoLine Through-Hole Bits HW

Product



Drawing



LEUCO
ecoline

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges with 60 degrees
- | HW-tipped
- | cylindrical shank with clamping surface
- | spiral without back guide

Advantages

- | Standard quality at low price

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	40	10	20	70	186481	186480
6.0	40	10	20	70	186483	186482
7.0	40	10	20	70	186485	186484
8.0	40	10	20	70	186487	186486
10	40	10	20	70	186489	186488
5.0	44	10	20	77	186491	186490
8.0	44	10	20	77	186493	186492
[mm]	[mm]	[mm]	[mm]	[mm]		

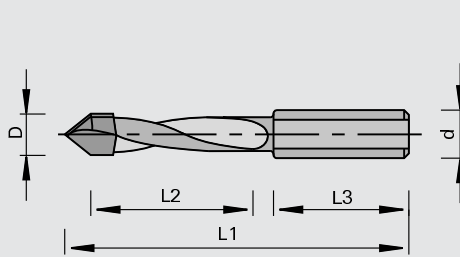
130015

Through-Hole Bits HW - without back-guide

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges (60 degree angle)
- | HW-tipped
- | cylindrical shank with clamping surface
- | spiral without back guide

Advantages

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	27	10	25	57.5	182239 o	182240 o
5.0	25	10	25	57.5	055827	055823
5.1	25	10	25	57.5	176473 o	176472 o
6.0	25	10	25	57.5	176475	176474
7.0	27	10	25	57.5	182245 o	182246 o
8.0	22	10	25	57.5	055830	055826
3.0	27	10	25	70	182237 o	182238 o
4.0	35	10	25	70	182241	182242
5.0	35	10	25	70	176505	176504
5.5	35	10	25	70	182243 o	182244 o
6.0	35	10	25	70	176259	176258
7.0	35	10	25	70	181581	181582
8.0	35	10	25	70	176507	176506
10	35	10	25	70	182669	182670
11	35	10	25	70	182249 o	182250 o
5.0	45	10	25	77	176477	176476
6.0	45	10	25	77	176479	176478
7.0	45	10	25	77	182251 o	182252 o
8.0	43	10	25	77	176481	176480
9.0	42	10	25	77	182253 o	182254 o
10	42	10	25	77	176483	176482
11	40	10	25	77	182255 o	182256 o
12	40	10	25	77	176485	176484
[mm]	[mm]	[mm]	[mm]	[mm]		

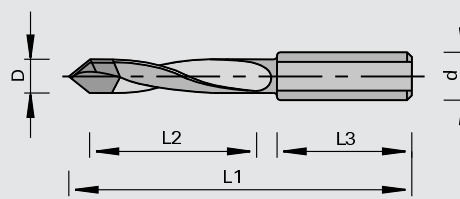
130015

Through-Hole Bits HW - with back-guide

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges (60 degree angle)
- | HW-tipped
- | cylindrical shank with clamping surface
- | spiral with back-guide

Advantages

- | protection of the hole edge upon exiting thanks to spiral with back guide

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | clamping elements: combi chuck, quick-change chuck

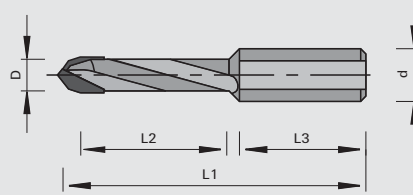
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	8,0	20	55.5	176497 o	176496 o
8.0	25	8,0	20	55.5	176499 o	176498 o
5.0	25	10	20	57.5	173604	173595
8.0	25	10	20	57.5	173611 o	173596 o
5.0	35	8,0	20	67	176501	176500
8.0	35	8,0	20	67	176503	176502
5.0	35	10	25	70	176255	176254
8.0	35	10	25	70	176257	176256
[mm]	[mm]	[mm]	[mm]	[mm]		

230012

Through-Hole Bits DP

Product

Drawing

LEUCO
DIA

Polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels and composite materials

Design

- | special cutting edge geometry, roof-shaped tip and double chamfer
- | spiral without back guide
- | DP-tipped

Advantages

- | long edge life when machining extremely abrasive materials
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
5.0	27	10	26	57.5	1	183015 o	183014 o
5.0	35	10	26	70	1	183017 o	183016 o
8.0	35	10	26	70	2	183021 o	183020 o
10	35	10	26	70	2		183050 o
[mm]	[mm]	[mm]	[mm]	[mm]			

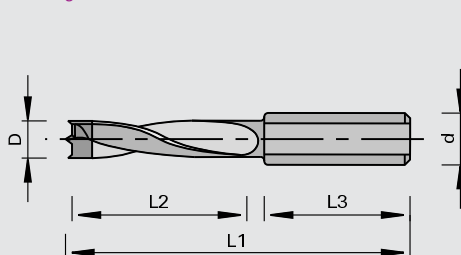
130215/130216/130217

Dowel Bits HW - with back-guide

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw: Ident-No. 001600 M5x10 DIN 551 for precise length adjustment
- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | clamping element: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	30	8,0	19	55.5	166107 o	166106 o
5.0	30	8,0	19	55.5	011543	011542
6.0	30	8,0	19	55.5	054884	054883
8.0	30	8,0	19	55.5	054892	054891
10	30	8,0	19	55.5	054896	054895
12	30	8,0	20	55.5	166113 o	166112 o
4.0	40	8,0	19	67	167164 o	167154 o
5.0	40	8,0	19	67	057494	057493
6.0	40	8,0	19	67	057496 o	057495
7.0	40	8,0	19	67	167167	167157
8.0	40	8,0	19	67	057498	057497
9.0	40	8,0	19	67	167169 s	167159 s
10	40	8,0	19	67	057500	057499
12	40	8,0	19	67	167172 o	167162 o
[mm]	[mm]	[mm]	[mm]	[mm]		

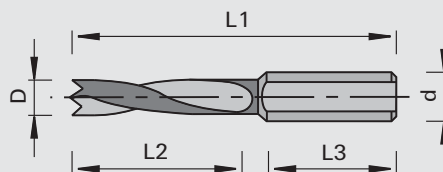
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	30	10	19	57.5	167184	167174
6.0	30	10	20	57.5	167185	167175
7.0	30	10	20	57.5	167186	167176
8.0	30	10	20	57.5	167187	167177
10	30	10	20	57.5	167188	167178
12	30	10	20	57.5	167189	167179
13	30	10	20	57.5	167190 o	167180
14	30	10	20	57.5	167191	167181
15	30	10	20	57.5	167192	167182
16	30	10	20	57.5	167193 o	167183 o
5.0	43	10	19	70	167203	167194
6.0	43	10	19	70	167204	167195
8.0	43	10	19	70	167205	167196
9.0	43	10	19	70	167206 o	167197
10	43	10	19	70	167207	167198
12	43	10	19	70	167208	167199
[mm]	[mm]	[mm]	[mm]	[mm]		

130212

Dowel Bits VHW - topline

Product

Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | centering point
- | boring part made from fine-grain solid tungsten carbide
- | enhancement of the previous topline HW design

Advantages

- | tool life increased up to twelve-fold compared to traditional dowel bits thanks to special HW and special grinding
- | chip-free hole edges thanks to special cutting edge geometry
- | safe drilling thanks to centering point
- | excellent chip evacuation thanks to optimized spiral design

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeco quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | other dimensions possible; price and delivery time on request

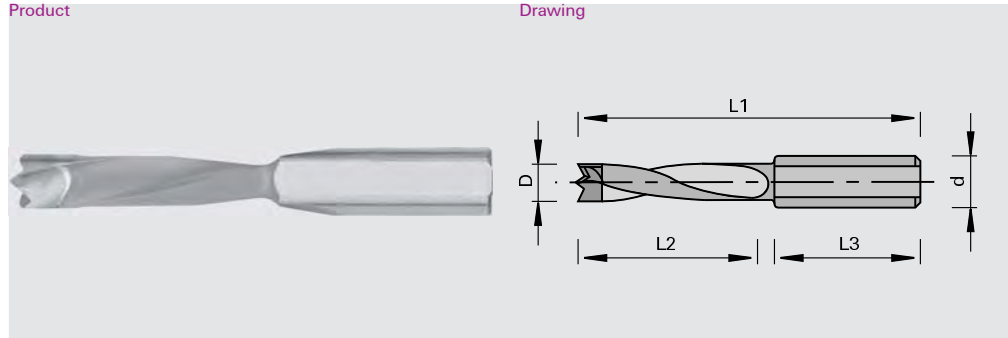
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	30	8,0	19	57.5	185746	185745
4.0	20	10	27	57.5	185748	185747
5.0	25	10	27	57.5	185750	185749
6.0	25	10	27	57.5	185752	185751
8.0	25	10	27	57.5	185754	185753
10	30	10	27	57.5	185756	185755
4.0	20	10	30	70	185758	185757
5.0	35	10	30	70	185760	185759
6.0	35	10	30	70	185762	185761
8.0	35	10	30	70	185764	185763
10	35	10	30	70	185766	185765
[mm]	[mm]	[mm]	[mm]	[mm]		

130213

Mosquito Dowel Bits HW

Product

Drawing



MOSQUITO

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | HW-tipped

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high process safety thanks to constant quality of the bores for a long time
- | tool life increased up to sixfold compared to traditional dowel bits thanks to wear-resistant HW plunging tip

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

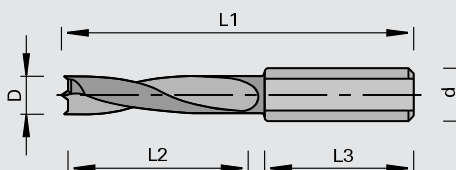
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	25	10	27	57.5	181168	181167
6.0	25	10	27	57.5	181522	181521
7.0	27	10	27	57.5	183159 o	183158 o
8.0	25	10	27	57.5	181170	181169
9.0	27	10	27	57.5	183161 o	183160 o
10	25	10	27	57.5	181524	181523
5.0	35	10	30	70	181172	181171
6.0	35	10	30	70	181526	181525
7.0	35	10	30	70	183163	183162
8.0	35	10	30	70	181174	181173
9.0	35	10	30	70	183165 o	183164 o
10	35	10	30	70	181528	181527
[mm]	[mm]	[mm]	[mm]	[mm]		

130213

Mosquito Dowel Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- | through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3.0	9,0	10	35	57.5	183143 o	183142 o
3.0	18	10	31	57.5	182380	182381
4.0	20	10	29	57.5	182382 o	182383 o
5.0	22	10	27	57.5	182384	182385
6.0	22	10	25	57.5	183145 o	183144 o
8.0	22	10	25	57.5	183147 o	183146 o
3.0	18	10	43.5	70	182386	182387
4.0	30	10	31.5	70	182388	182389
5.0	30	10	31.5	70	182390	182391
6.0	30	10	30	70	183149	183148
8.0	35	10	22	70	183151	183150
[mm]	[mm]	[mm]	[mm]	[mm]		



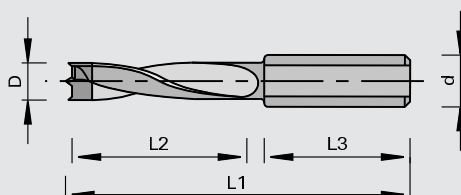
130215

Dowel Bits HW - with back-guide, long version

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | long cutting length
- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | deep holes thanks to long cutting length
- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

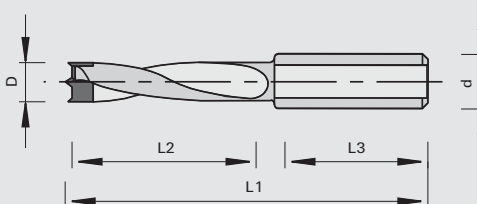
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	50	10	30	85	177194	177193
5.0	65	10	30	105	177206 o	177205
6.0	50	10	30	85	177196 o	177195
6.0	65	10	30	105	177208 o	177207
7.0	50	10	30	85	177198	177197
7.0	65	10	30	105	177210	177209
8.0	50	10	30	85	177200	177199
8.0	65	10	30	105	177212	177211
10	50	10	30	85	177202	177201
10	65	10	30	105	177214	177213
12	50	10	30	85	177204	177203
12	65	10	30	105	177216 o	177215
[mm]	[mm]	[mm]	[mm]	[mm]		

130211

EcoLine Dowel Bits HW

Product

Drawing



LEUCO
ecoline

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | plunging tip with HW plate for reduced demands

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	26	10	20	57.5	183375	183374
8.0	31	10	20	57.5	183377	183376
10	32	10	20	57.5	183379	183378
5.0	39	10	20	70	183381	183380
6.0	40	10	20	70	183383	183382
8.0	44	10	20	70	183385	183384
10	45	10	20	70	183387	183386
[mm]	[mm]	[mm]	[mm]	[mm]		



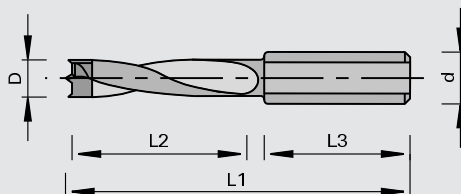
130215/130217

Dowel Bits HW - without back-guide

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	27	10	27	57.5	003175	003174
4.5	27	10	27	57.5	177228	177227
5.0	27	10	27	57.5	003179	003178
5.1	27	10	27	57.5	177230	177229
5.2	27	10	27	57.5	167707 o	167708 o
6.0	27	10	27	57.5	003183	003182
7.0	27	10	27	57.5	003187	003186
8.0	27	10	27	57.5	003191	003190
8.2	27	10	27	57.5	167216	167213
9.0	27	10	27	57.5	003195	003194
10	27	10	27	57.5	003199	003198
10.5	27	10	27	57.5	182261 o	182262 o
11	27	10	27	57.5	177232 o	177231
12	27	10	27	57.5	003207	003206
4.0	35	10	30	70	173175	173174
4.5	35	10	30	70	182263 o	182264 o
5.0	35	10	30	70	003231	003230
5.1	35	10	30	70	182265 o	182266 o
5.5	35	10	30	70	182267	182268 o
6.0	35	10	30	70	003235	003234
6.5	35	10	30	70	182269 o	182270 o
7.0	35	10	30	70	167224	167219
7.5	35	10	30	70	182271 o	182272 o
8.0	35	10	30	70	003243	003242
8.1	35	10	30	70	182273 o	182274 o
8.2	35	10	30	70	182275	182276 o
8.5	35	10	30	70	182277 o	182278 o
9.0	35	10	30	70	167225	167220
10	35	10	30	70	003251	003250
10.2	35	10	30	70	182279 o	182280 o
11	35	10	30	70	167226	167221
12	35	10	30	70	167227	167222
13	35	10	30	70	183042	183043
14	35	10	30	70	183044	183045
16	35	10	30	70	183046	183047
5.0	44	10	30	77	167233	167228
6.0	44	10	30	77	167234	167229
[mm]	[mm]	[mm]	[mm]	[mm]		

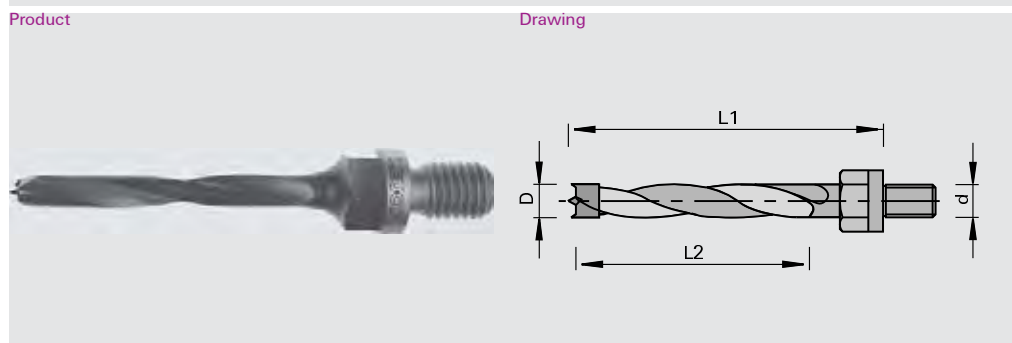
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
8.0	44	10	30	77	167235	167230
10	44	10	30	77	167236	167231
12	44	10	30	77	173181 o	173180 o
[mm]	[mm]	[mm]	[mm]	[mm]		

130226

Dowel Bits HW - without back-guide, with threaded shank

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | threaded shank
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating
- | high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- | for coordination with machines see section Clamping Systems

Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5.0	45	M8	63	160570 o	160566 o
5.0	45	M10	63	167697	167698
6.0	45	M10	63	160576 o	160574 o
8.0	45	M8	63	160572 o	160568 o
8.0	45	M10	63	160577	160575
10	45	M10	63	167699 o	167700 o
12	45	M8	63	167691 o	167692 o
12	45	M10	63	167701 o	167702 o
[mm]	[mm]	[mm]	[mm]		

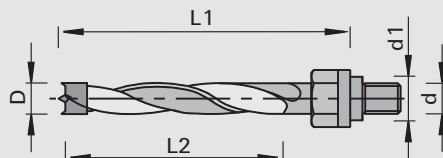
130226

Dowel Bits HW - with back-guide and threaded shank

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | shank with thread and passfit
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating
- | high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- | for coordination with machines see section Clamping Systems

Ø D	L2	Ø d1	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5.0	45	11	M10	63	167703 o	167704 o
6.0	45	11	M10	63	167705 o	167706 o
8.0	45	11	M10	63	160584	160582
10	45	11	M10	63	160585 o	160583 o
[mm]	[mm]	[mm]	[mm]	[mm]		

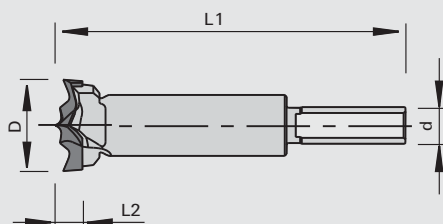
130214

Drill Bits HW for Lamello Cabineo® pockets

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC machining centers with 3-fold drilling aggregates e.g. BENZ MULTI V3 CABINEO, ATEMAG Verti-Line Cabineo
- | Boring machines with special boring heads e.g. Gannomat Basica
- | for drilling of machining pockets system Lamello Cabineo® in one machining step (3 in 1)

Design

- | 2 spurs
- | Centering point
- | high-quality cutting material
- | Tool shank with clamping surface

Advantages

- | special LEUCO tooth and spur geometry for minimal cutting force and cutting pressure
- | high balancing quality
- | adapted design for "3 in 1" or multispindle aggregates

Notes

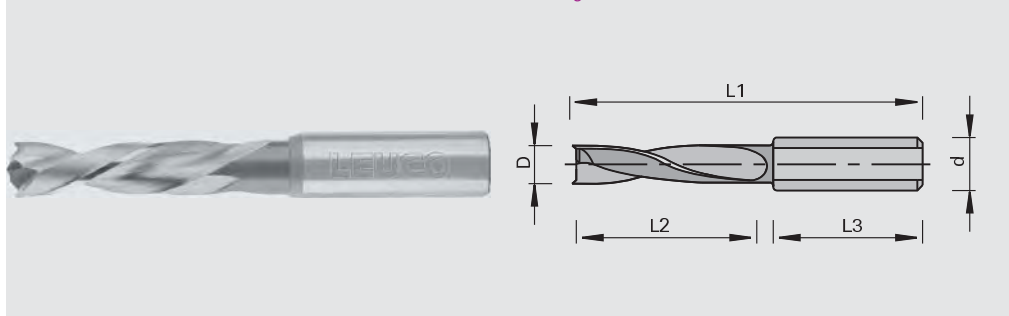
Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
15	4,5	6	57.5	186737	186736
[mm]	[mm]	[mm]	[mm]		

130214

High-Performance Dowel Bits with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | stationary boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through holes and dowel holes in solid woods, wood-based panels and composite materials

Design

- | special cutting edge geometry
- | 2 spurs
- | spiral with back-guide
- | boring part made from solid tungsten carbide

Advantages

- | special tooth geometry and spurs for minimal cutting force and cutting pressure
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | high feed rates and large resharpenable area thanks to solid carbide bit

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | patented tooth geometry
- | change of grinding or reduction of diameter ist not possible

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5.0	32	10	22	57.5	185768	185767
8.0	32	10	22	57.5	185770	185769
5.0	36	10	30	70	185772	185771
6.0	36	10	30	70	185774	185773
8.0	36	10	30	70	185776	185775
10	36	10	30	70	185778	185777
[mm]	[mm]	[mm]	[mm]	[mm]		

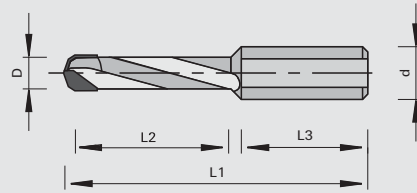


230215

Dowel Bits DP

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels and composite materials

Design

- | special cutting edge geometry, 2 DP rakers which form a double chamfer
- | spiral without back guide
- | DP-tipped

Advantages

- | long edge life when machining extremely abrasive materials
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

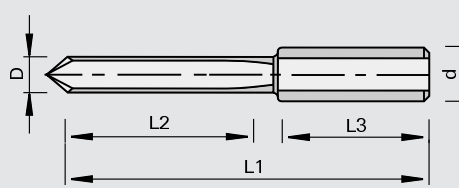
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
8.0	27	10	26	57.5	2	183009 o	183008 o
8.0	35	10	30	70	2	183013 o	183012 o
10	35	10	30	70	2	183053 o	183054 o
[mm]	[mm]	[mm]	[mm]	[mm]			

130010

Boring Spikes with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for drilling of dowel holes in wood-based panels

Design

- | cylindrical shank \varnothing 10 mm with clamping surface and adjusting screw
- | solid carbide design

Advantages

- | large resharpenable area
- | long edge lives

Notes

- | for clockwise and counter-clockwise rotation
- | clamping element: combi chuck, quick-clamping chuck

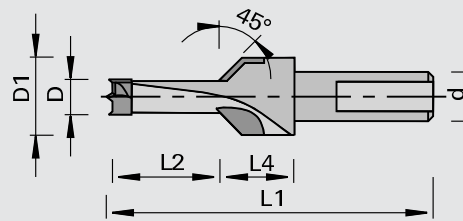
\varnothing D	L2	\varnothing d	L3	L1	Ident-No.
2.0	12	2,0		38	183059 o
2.5	12	2,5		45	180942
3.0	12	3,0		45	180943
3.5	15	3,5		45	183060 o
4.0	12	4,0		45	180944 o
2.5	15	10	33	57.5	183061 o
3.0	15	10	33	57.5	183062 o
5.0	25	10	25	57.5	180945 o
3.5	30	10	24	70	183063 o
4.0	32	10	25	70	183064 o
5.0	35	10	25	70	180946 o
[mm]	[mm]	[mm]	[mm]	[mm]	

130710

Boring Countersink HW

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- for drilling and countersinking in solid woods and wood-based panels

Design

- spiral PTFE coated
- 2 spurs
- centering point

Advantages

- for drilling and countersinking in one pass
- safe drilling thanks to centering point

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Ø D	L2	Ø D1	L4	Ø d	L1	Ident-No. [L]	Ident-No. [R]
8.0	12	16	15	10	57.5	180847	180846
8.0	15	16	15	10	57.5	180849	180848
10	12	16	15	10	57.5	180853	180852
10	15	16	15	10	57.5	180855 o	180854 o
8.0	12	16	15	10	70	180859	180858
8.0	15	16	15	10	70	180861 o	180860 o
8.0	20	16	15	10	70	180863	180862
10	12	16	15	10	70	180865	180864
10	15	16	15	10	70	180867 o	180866 o
10	20	16	15	10	70	180869 o	180868 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

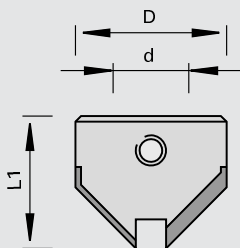
130660

Countersink Parts HW to be mounted on Twist Drills and Dowel Bits

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on twist drills and dowel bits with back-guide on the drill spiral with set screw
- continuous adjustment of the countersink diameter and the boring depth

Ø D	Ø d	L1	Ident-No. [L]	Ident-No. [R]
15.5	3,0	17.5		177291
16	4,0	15	183811 o	183812
16	5,0	15	183174	183175
16	6,0	15	183176	183177
16	7,0	15	183178	183179
18	8,0	15	183180	183181
18	9,0	15	183813 o	183814 o
20	10	15	183182	183183
20	12	15	183815 o	183816
[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Set Screws	M5x5 DIN EN ISO 4029	995161	10	001609
Cranked Wrench Keys	SW2,5 DIN ISO 2936	985730	1	009671
	[mm]		[pc.]	

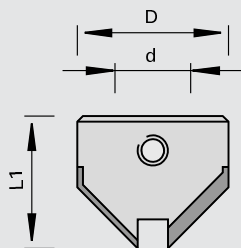
130660

Countersink Parts HW to be mounted on Dowel Bits

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on elongated shank of dowel bits \varnothing 5 - 12 mm with setscrew
- continuous adjustment of the countersink diameter and the boring depth

\varnothing D	\varnothing d	L1	Ident-No. [L]	Ident-No. [R]
15.5	10	16.5	177294	177293
20	10	16	183184	183185
22	10	16.5		177295 o
[mm]	[mm]	[mm]		

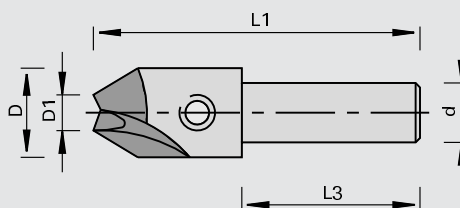
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Set Screws	M6x4 DIN EN ISO 4029	169312, 177293	995161	10	167068
Set Screws	M6x5 DIN EN ISO 4029	177295	995161	10	165049
Cranked Wrench Keys	SW3 DIN ISO 2936	For all	985730	1	009672
	[mm]			[pc.]	

130660

Countersink Bits HW for Twist Drills

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for mounting of twist drills with \varnothing 3 - 6 mm
- continuous adjustment of the countersink diameter and the boring depth

\varnothing D	\varnothing D1	\varnothing d	L3	L1		Ident-No.
15	3.0	10	30	58	R	173190
15	3.0	10	30	58	L	173191 o
15	3.5	10	30	58	R	173192
15	4.0	10	30	58	R	173194
15	4.0	10	30	58	L	173195
15	4.5	10	30	58	R	173196
15	4.5	10	30	58	L	173197 o
15	5.0	10	30	58	R	173198
15	5.0	10	30	58	L	173199
15	6.0	10	30	58	R	173202 o
15	6.0	10	30	58	L	173203 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Set Screws

M6x6 DIN EN ISO 4029
[mm]

995161

10

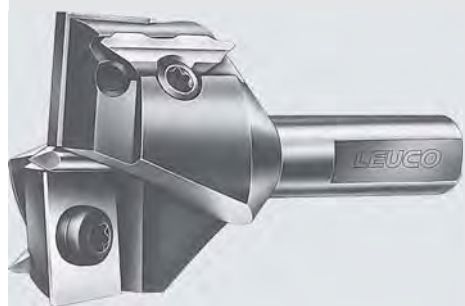
180003

[pc.]

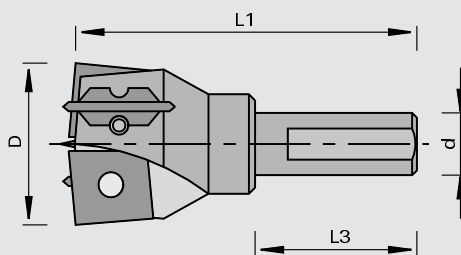
130135

Cylinder Boring Bits with HW Turnover Knives

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 turnover spurs and centering point

Advantages

- | long edge lives thanks to wear-resistant HW grade
- | chip-free hardware hinge holes thanks to scoring cut of the turnover spurs

Notes

- | replaceable and adjustable centering point
- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5		162612 s
26	10	26	57.5		162614
30	10	26	57.5		162616 s
35	10	26	57.5	162619	162618
25	10	26	70		182570 s
26	10	26	70		182571 s
30	10	26	70		182572 s
35	10	26	70	184896	182573
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	10,5x12x1,5	162612, 182570	150515	10	162636
Turnover Knives	11x12x1,5	162614, 162615, 182571	150515	10	162637
Turnover Knives	13x12x1,5	162616, 182572	150515	10	162638
Turnover Knives	15,7x12x1,5	162618, 162619, 182573	150515	10	163846
Spurs	18x5,7x3,5	For all	150557	10	181263
Centering Points	3x33,5	For all	165512	10	162624
	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Set Screws	M6x6 DIN EN ISO 4028	For all	995161	10	163841
Countersunk Screws	M3,5x6 T15	162614, 162615, 162616, 162618, 162619, 182571, 182572, 182573	995125	10	162648
Countersunk Screws	M3,5x5,5 T15	162612, 182570	995125	10	162649
Head Cap Screws	M3,5x3,8 T15	For all	995115	10	162645
	[mm]			[pc.]	

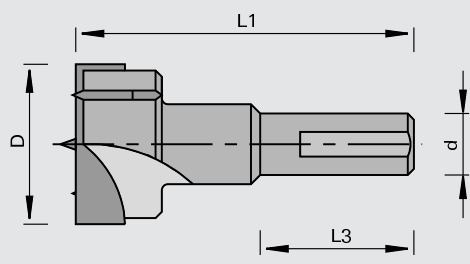
130117

Cylinder Boring Bits HW - Z=2+2

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 spurs and centering point
- | HW-tipped

Advantages

- | chip-free holes thanks to scoring cut of the spurs

Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	003303	003302
16	10	26	57.5	003305	003304
18	10	26	57.5	003309	003308
20	10	26	57.5	003313	003312
22	10	26	57.5	003315	003314
25	10	26	57.5	003319	003318
26	10	26	57.5	003321	003320
30	10	26	57.5	003327	003326
35	10	26	57.5	003333	003332
40	10	26	57.5	003337	003336
15	10	26	70	178978	172250
18	10	26	70	178983	178984
20	10	26	70	178979	172251
22	10	26	70	182257	182258
25	10	26	70	178980	172252
26	10	26	70	182374	182375
30	10	26	70	178981	172253
35	10	26	70	178982	172254
40	10	26	70	182259	182260
[mm]	[mm]	[mm]	[mm]		

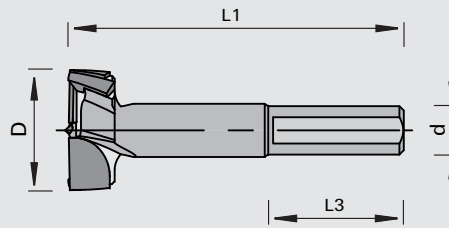
130115 / 130117

Cylinder Boring Bits HW - "Light"

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 spurs and centering point
- | HW-tipped

Advantages

- | chip-free bore holes even on partly open holes near the edge of the panel thanks to particular geometry of spurs
- | excellent chip removal thanks to big gullets
- | the shorter center point allows for drilling deep holes close to the bottom of panel
- | low cutting pressure

Notes

- | cylindrical shank with clamping surface
- | with length adjusting screw M5x10 DIN 551
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	184677	184676
18	10	26	57.5	185029	185028
20	10	26	57.5	185031	185030
25	10	26	57.5	184679	184678
26	10	26	57.5	185033	185032
35	10	26	57.5	184681	184680
[mm]	[mm]	[mm]	[mm]		

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	70	184685	184684
18	10	26	70	185035	185034
20	10	26	70	185037	185036
25	10	26	70	184687	184686
26	10	26	70	185039	185038
35	10	26	70	184689	184688
[mm]	[mm]	[mm]	[mm]		

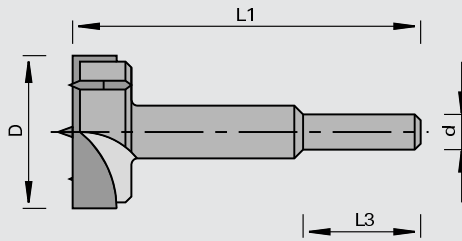
130119

Cylinder Boring Bits HW - portable boring machines

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

portable boring machines
for chip-free drilling in solid woods and wood-based panels

Design

2 rakers, 2 spurs and centering point
HW-tipped
Ø 12: spurs in rakers
cylindrical shank

Advantages

chip-free holes thanks to scoring cut of the spurs

Notes

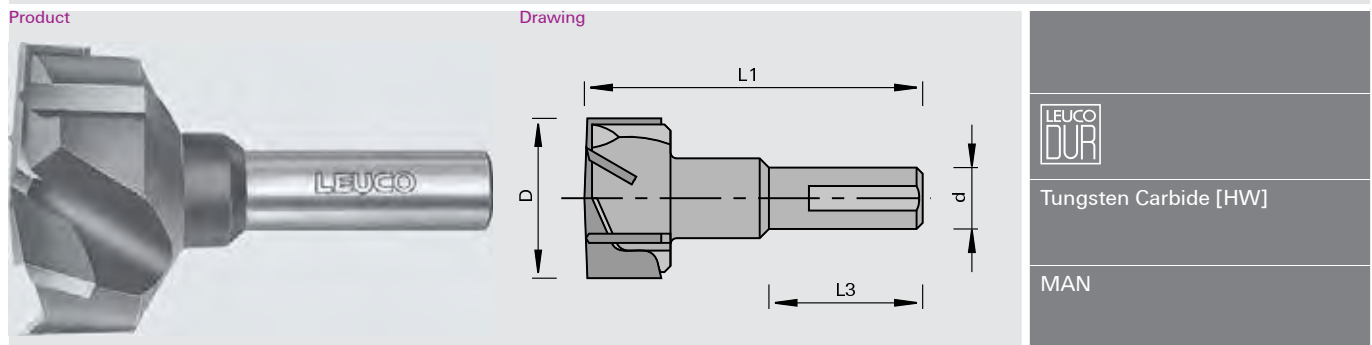
diameter of the cylindrical shank is adapted to the cutting pressure
clamping elements: drill chuck

Ø D	Ø d	L3	L1	Ident-No.
12	10	62	90	173204 o
14	10	60	90	167685
15	10	60	90	160424
16	10	60	90	160425
17	10	60	90	167686
18	10	60	90	160426
19	10	60	90	167687
20	10	60	90	160427
21	10	60	90	173205
22	10	60	90	160428
23	10	60	90	167688
24	10	60	90	160429
25	10	60	90	160430
26	10	60	90	160431
27	10	74	90	173206 o
28	10	60	90	160432
30	10	60	90	160433
32	10	60	90	160434
34	10	74	90	167689 o
35	10	60	90	160435
36	10	30	90	160436 o
38	10	60	90	160437 o
40	10	60	90	160438
42	10	30	90	167690 o
45	10	60	90	173207
50	10	60	90	173208
[mm]	[mm]	[mm]	[mm]	

Ø D	Ø d	L3	L1	Ident-No.
15	13	108	140	173210 o
16	13	108	140	173211 o
18	13	107	140	160388 o
20	13	105	140	160389 o
22	13	105	140	160390 o
24	13	105	140	173212 o
25	13	103	140	160392 o
26	13	103	140	160393 o
28	13	103	140	160394 o
30	13	103	140	160395 o
32	16	103	140	160396 o
34	16	103	140	173213 o
35	16	103	140	160398 o
[mm]	[mm]	[mm]	[mm]	

Ø D	Ø d	L3	L1	Ident-No.
38	16	103	140	173215 o
40	16	103	140	160401 o
42	16	120	140	160402 o
44	16	120	140	173216 o
45	16	120	140	180742 o
46	16	120	140	173217 o
48	16	120	140	173218 o
50	16	118	140	160407 o
52	16	118	140	160408 o
54	16	118	140	173219 o
55	16	118	140	160409 o
56	16	118	140	173220 o
58	16	118	140	173221 o
60	16	50	140	160410 o
63	16	50	140	173228 o
65	16	50	140	160411 o
68	16	50	140	173222 o
70	16	50	140	160412 o
75	20	115	140	173223 o
80	20	115	140	160414 o
90	20	115	140	173225 o
[mm]	[mm]	[mm]	[mm]	

130115
Cylinder Boring Bits HW - Z=3+3



Tungsten Carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in solid woods and wood-based panels

Design

- | 3 rakers, 3 spurs, without centering point
- | HW-tipped

Advantages

- | boring depths close to the bottom-side laminate
- | chip-free holes thanks to scoring cut of the spurs
- | high feed rates thanks to Z = 3+3

Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

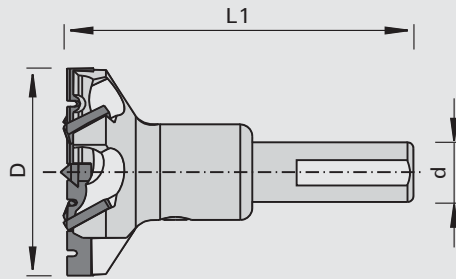
Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5	160385	160384
26	10	26	57.5		003278
30	10	26	57.5		003280
35	10	26	57.5	003285	003284
40	10	26	57.5		713347 o
[mm]	[mm]	[mm]	[mm]		

230115

Cylinder Boring Bits DP

Product

Drawing



Polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels

Design

- | 2 DP rakers with chip breakers
- | 4 DP spurs
- | HW centering point
- | Multiple resharpening

Advantages

- | Long edge life when machining abrasive materials
- | Economic efficiency thanks to possibility of multiple resharpening
- | Clean holes with no tear out thanks to the special geometry of the 4 spurs
- | Centering point for safe spot drilling

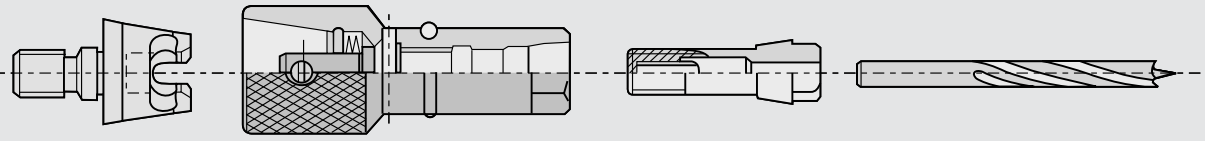
Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

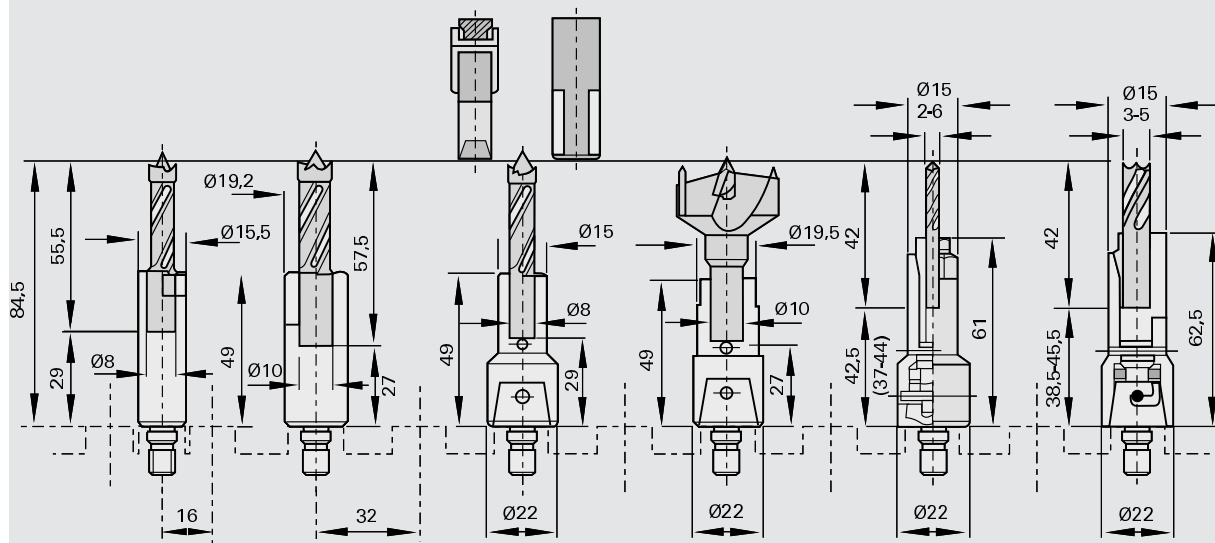
Ø D	Ø d	L1	Z	Ident-No. [R]
35	10	57.5	2+4	186782
35 [mm]	10 [mm]	70 [mm]	2+4	186783



Quick-Change Systems for Boring Bits



Features	Advantages	Benefit
<ul style="list-style-type: none"> precise tapered adapter 	<ul style="list-style-type: none"> precise radial running accuracy of the boring bit 	<ul style="list-style-type: none"> improved product quality
<ul style="list-style-type: none"> tight connection 	<ul style="list-style-type: none"> tight connection between boring bit and machine 	<ul style="list-style-type: none"> safe operation
<ul style="list-style-type: none"> simple locking 	<ul style="list-style-type: none"> quick change of the boring bit 	<ul style="list-style-type: none"> short downtimes
<ul style="list-style-type: none"> color-coded top part to mark the direction of rotation 	<ul style="list-style-type: none"> quick and easy recognition of the direction of rotation 	<ul style="list-style-type: none"> no high demands on the machine operators
<ul style="list-style-type: none"> compatible with old "Klack" and combi chuck 	<ul style="list-style-type: none"> upgrading and partial equipping of existing machines possible 	<ul style="list-style-type: none"> low cost



Order / Inquiry for Special Tools: Drill Bits / Plunge Cutters

Please copy and send the completed form to one of the LEUCO sales offices. (Only one tool description per form)

Customer-no.:	_____	Order:	<input type="radio"/>
Company:	_____	Inquiry:	<input type="radio"/>
Plant:	_____		
Street:	_____	Delivery (week no.):	_____
Zip / City:	_____	(Not binding)	
Country:	_____	No. of pieces:	_____
Contact partner:	_____		
Phone:	_____	Fax:	_____
City and Date:	_____	Signature:	_____

Machine

Maker: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Workpiece material

Description: _____

Through hole:

Blind hole:

Boring depth [mm]: _____

Coating

Yes No

Description: _____

Further Information _____

Product line

topline

Standard

Cutting material

Carbide

Diamond

HS

Tool

Twist Drills

Through-Hole Bits

Dowel Bits

Shell countersink

Countersink for twist drill bits

Cylinder boring bit

Brazed

With turnover knives

Bore diameter D [mm]: _____

Effective length L2 [mm]: _____

Overall length L1 [mm]: _____

Shank length L3 [mm]: _____

Shank design d:

 Cylindrical shank [Ø]: _____

 Other shank types: _____

 Type (per enclosure): _____

No. of cutting edges: _____

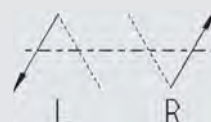
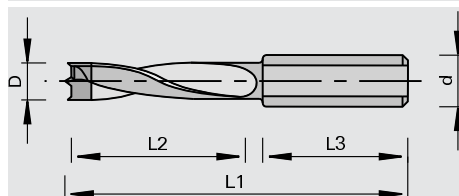
Rakers: _____

Spur: _____

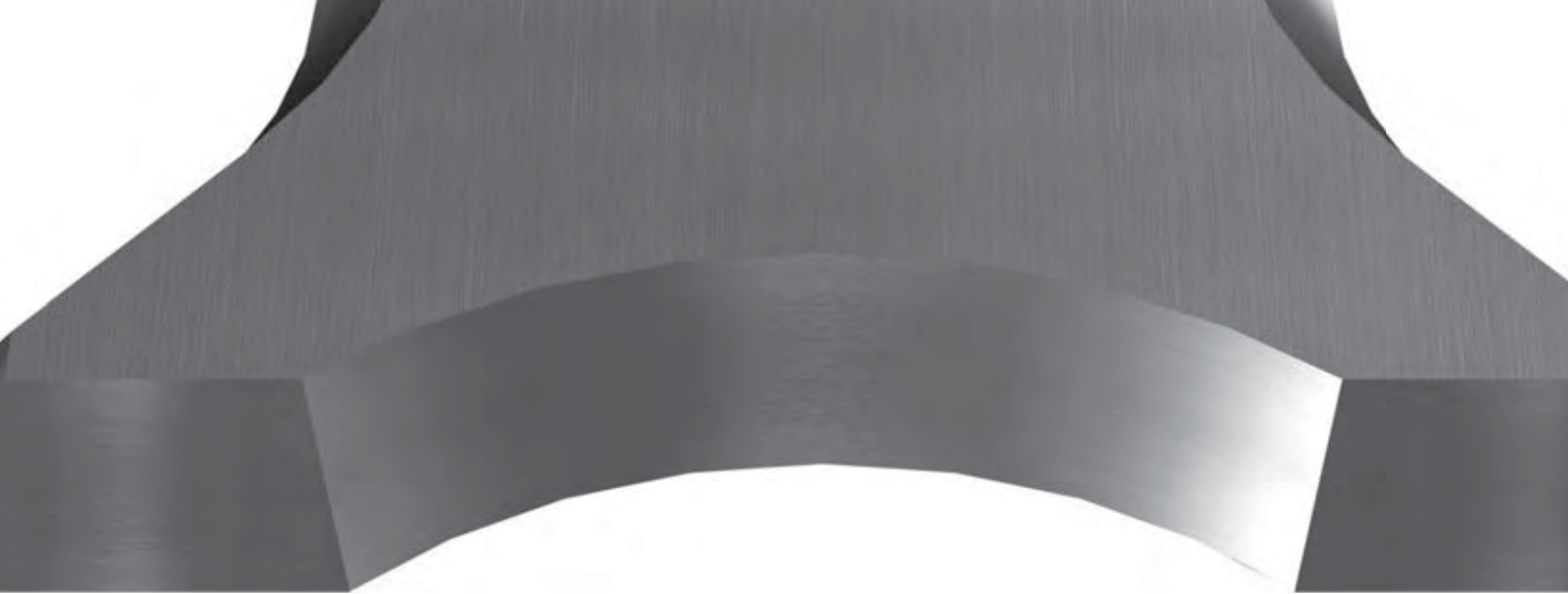
Sense of rotation: Right Left

o check if applicable

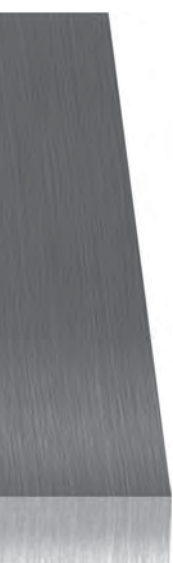
Please indicate additional dimension and markings in the tool drawing.



520-01.0708



Turnover Knives, Profile Knives, Knives



Product	Page
Turnover Knives, Profile Knives	6-1
Turnover Spurs	6-12
centering point	6-13
Radius and Chamfering Turnover Knives / Profile Knives	6-14
Profile Knives / Turnover Knives	6-22
Profile Turnover Knives	6-31
Scraper Turnover Knives / Knives	6-34
Cup Knives	6-52
Saw Teeth	6-53
Planing Knives	6-54
Blanks	6-73

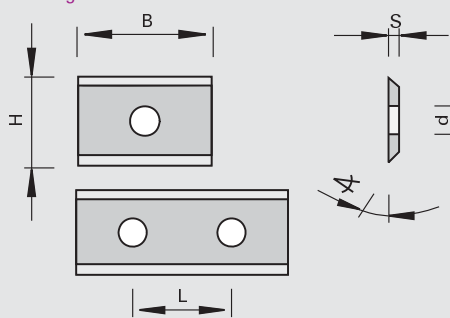
150511 / 150512 / 150515 / 150516 / 150517 / 150717

Turnover Knives HW with 2 cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

Advantages

Notes

- | topline (polished face and micro-ground clearance angle)
- | cutting material: HW
- | HW HL Board 01 for wood-based panels and plastics
- | HW HL Board 02 for wood-based panels and plastics
- | HL Board 06 for wood-based panels, plastics, hard and soft woods
- | HL Board 05 for wood-based panels, plastics and hard woods
- | HL Solid 20 for hard and soft woods
- | HL Solid 20 topline for hard and soft woods

- | long edge lives and optimum cutting quality in solid woods
- | EcoKnife: turnover knife with less weight, less unbalance

- | packing unit: 10 pieces

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
7,5	12	1.5	4,0	55		HL Board 05	052543
7,5	12	1.5	4,0	45		HL Solid 20	173473 o
9,6	12	1.5	4,0	55		HL Board 05	171163
10,5	12	1.5	4,0	55		HL Board 05	162636
11	12	1.5	4,0	55		HL Board 05	162637
13	12	1.5	4,0	55		HL Board 05	162638
15	12	1.5	4,0	55		HL Board 05	003081
15	12	1.5	4,0	45		HL Solid 20	173467 o
15,7	12	1.5	4,0	55		HL Board 05	163846
17	12	1.5	4,0	55		HL Board 05	162639
18	12	1.5	4,0	55		HL Board 05	162520
19	12	1.5	4,0	55		HL Board 05	164242
20	12	1.5	4,0	55		HL Board 02	176469
20	12	1.5	4,0	55		HL Board 06	178287
20	12	1.5	4,0	55		HL Board 06 EcoKnife	183569
20	12	1.5	4,0	55		HL Board 05	003082
20	12	1.5	4,0	45		HL Solid 20	173468 o
20	12	1.5	4,0	45		HL Solid 20 topline	176265
30	12	1.5	4,0	14	55	HL Board 02	176470
30	12	1.5	4,0	14	55	HL Board 06	178288
30	12	1.5	4,0	11-14	55	HL Board 06 EcoKnife	183570
30	12	1.5	4,0	14	55	HL Board 05	003083
30	12	1.5	4,0	14	45	HL Solid 20	173469 o
30	12	1.5	4,0	14	45	HL Solid 20 topline	176266
40	12	1.5	4,0	26	55	HL Board 02	182191 o
40	12	1.5	4,0	26	55	HL Board 05	164078
40	12	1.5	4,0	26	45	HL Solid 20	173470 o
40	12	1.5	4,0	26	45	HL Solid 20 topline	176267
50	12	1.5	4,0	26	55	HL Board 02	176471
50	12	1.5	4,0	26	55	HL Board 06	178289
50	12	1.5	4,0	20-26	55	HL Board 06 EcoKnife	183571
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge∟	LEUCODUR	Ident-No.
50	12	1.5	4,0	26	55	HL Board 05	003085
50	12	1.5	4,0	26	45	HL Solid 20 topline	176268
60	12	1.5	4,0	26	55	HL Board 05	003086
60	12	1.5	4,0	26	45	HL Solid 20	173472 o
60	12	1.5	4,0	26	45	HL Solid 20 topline	176269
80	13	2.2	4,0	59-61	55	HL Board 06	003087
80	13	2.2	4,0	59-61	45	HL Solid 20 topline	181677
100	13	2.2	4,0	59-61	55	HL Board 06	003088
120	13	2.2	4,0	59-61	55	HL Board 06	003089
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

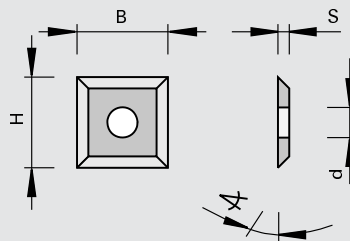
150513 / 150515 150518 / 150718

Turnover Knives HW with 4 cutting edges

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

Design

- | topline (polished face and micro-ground clearance angle)
- | cutting material: HW
- | HL Board 03 for wood-based panels and plastics
- | HL Board 05 for wood-based panels, plastics and hard woods
- | HL Solid 20 topline for hard and soft woods
- | HL Solid 30 for hard and soft woods

Advantages

- | long edge lives and optimum cutting quality in solid woods

Notes

- | packing unit: 10 pieces

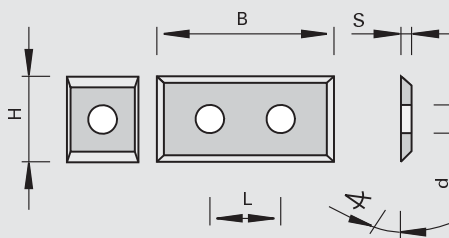
B	H	S	Ø d	Wedge∟	LEUCODUR	Ident-No.
10,5	10,5	1.5	4,0	55	HL Solid 30	162316
12	12	1.5	4,0	55	HL Board 03	* 180820
12	12	1.5	4,0	55	HL Board 05	* 003080
12	12	1.5	4,0	45	HL Solid 20 topline	* 176340
17	17	2.0	4,0	55	HL Board 05	Weinig 162581
19	19	2.0	4,0	55	HL Board 05	162582
[mm]	[mm]	[mm]	[mm]	[°]		

150513 / 150515

Turnover Knives HW with 2 cutting edges, end sharpened

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

| for use in shank-type cutters

Design

| cutting material: HW
 | HL Board 02 for wood-based panels and plastics
 | HL Board 03 for wood-based panels and plastics
 | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces


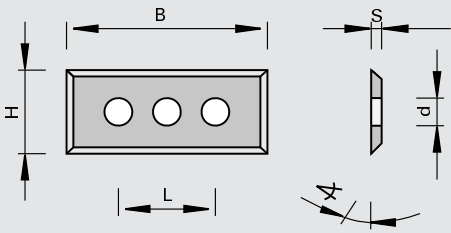

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
17,5	7.0	1.5			55	HL Board 05	184257
29,5	7.0	1.5	3,3	14	55	HL Board 05	184258
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
29,5	9.0	1.5	4,0	14	55	HL Board 03	180807
29,5	9.0	1.5	4,0	14	55	HL Board 05	180821
39,5	9.0	1.5	4,0	26	55	HL Board 05	180815
49,5	9.0	1.5	4,0	26	55	HL Board 03	180808
49,5	9.0	1.5	4,0	26	55	HL Board 05	180806
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
9	12	1.5	4,0		55	HL Board 05	167256
10	12	1.5	4,0		55	HL Board 05	165914
19,5	12	1.5	4,0		55	HL Board 05	183777
29,5	12	1.5	4,0	14	55	HL Board 02	181160
29,5	12	1.5	4,0	14	55	HL Board 05	180825
39,5	12	1.5	4,0	26	55	HL Board 05	171149
49,5	12	1.5	4,0	26	55	HL Board 05	180826
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150516 / 150513

Turnover Knives HW with 2 cutting edges, end sharpened - 3 holes


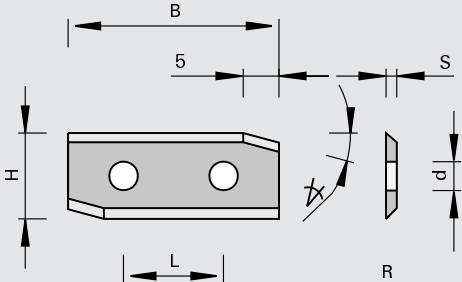

Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
	cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods HW HL Board 03 for wood-based panels and plastics		packing unit: 10 pieces

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
50	9.0	1.5	3,7	37	55	HL Board 03	181982
50	12	1.7	4,0	37	55	HL Board 06	179994
50	12	1.7	4,0	37	55	HL Board 03	182456
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150515

Turnover Knives HW with 2 cutting edges and chamfer - HOLZ-HER

Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
machines HOLZ-HER for use in edge banding / jointing cutterheads	grinding angle 55 degrees cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

Chamfer	B	H	S	Ø d	L	Ident-No. [L]	Ident-No. [R]
15	29,5	12	1.5	4,0	14	160118	160618
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

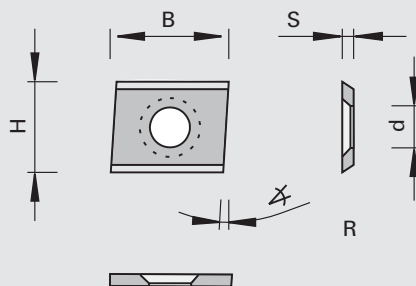
150516

Turnover Knives HW with 2 cutting edges, edge bevel - Brandt, Ott

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- | machines Brandt, Ott
- | Brandt: for use in grooving cutterheads and prism cutterheads or as flat scraper
- | Ott: for the use as flat scraper

Design

- | grinding angle 55 degrees
- | cutting material: HW
- | HL Board 06 for hard and soft woods

Advantages

Notes

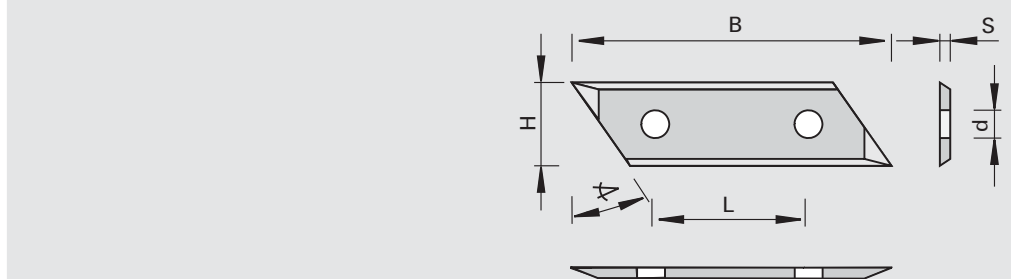
- | packing unit: 10 pieces

B	H	S	Ø d	Clearance \sphericalangle 1	Ident-No. [L]	Ident-No. [R]
15	14.3	2.5	6.3	6	186195	186196
[mm]	[mm]	[mm]	[mm]	[°]		

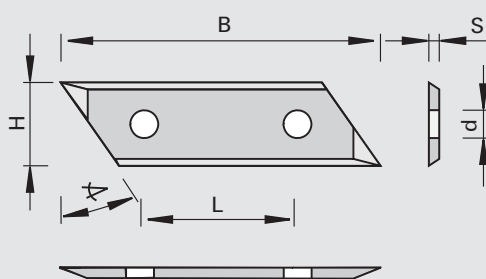
150515

Turnover Knives HW with 2 cutting edges, edge bevel for scribing cutters

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- | for use in scribing cutters

Design

- | grinding angle 55 degrees
- | cutting material: HW
- | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- | packing unit: 10 pieces

B	H	S	Ø d	L	\sphericalangle	Ident-No.
40	12	1.5	4.0	25.1	15	185369
50	12	1.5	4.0	26	35	185140
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

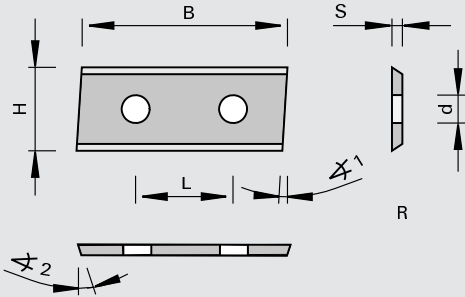
150515

Turnover Knives HW with 2 cutting edges, edge bevel and end sharpened

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in V-grooving cutter-heads and prism cutterheads

Design

grinding angle 55 degrees
cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

B	H	S	Ø d	L	Clearance $\sphericalangle 1$	Clearance $\sphericalangle 2$	Ident-No. [L]	Ident-No. [R]
19,5	12	1.5	4,0		3.5	10	160626	160625
29,5	12	1.5	4,0	14	5		003119	003118
49,2	12	1.5	4,0	26	5		003121	003120
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]		

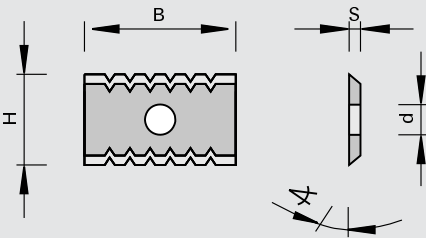
150515

Turnover Knives HW with 2 cutting edges - interrupted cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in hoggers

Design

chip breakers for optimum cut division
cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

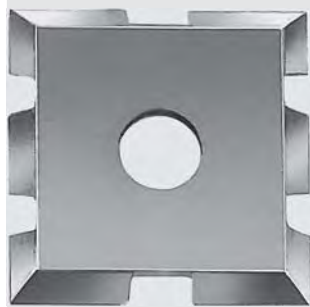
packing unit: 10 pieces

B	H	S	Ø d	Wedge \sphericalangle	Ident-No.
20	12	1.5	4,0	55	055905 s
[mm]	[mm]	[mm]	[mm]	[°]	

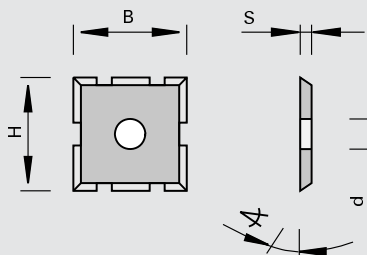
150517

Turnover Knives HW with 4 cutting edges - interrupted cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

Advantages

Notes

- | chip breakers for optimum cut division
- | cutting material: HW
- | HL Solid 20 for hard and soft woods

- | packing unit: 10 pieces

B	H	S	Ø d	Wedge	Ident-No.
15 [mm]	15 [mm]	2.0 [mm]	4,0 [mm]	55 [°]	167873

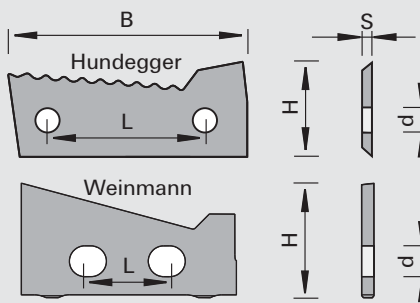
151557

Profile knives HW - for dove-tail profiles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

Advantages

Notes

- | for dove-tail cutterheads by Hundegger, Weinmann
- | joinery machining

- | cutting material: HW
- | HL Solid 20 for hard and soft woods

- | packing unit see table

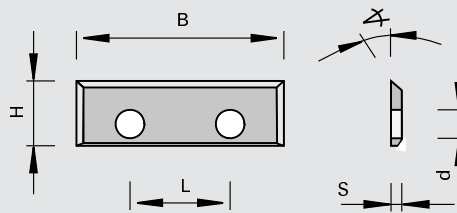
B	H	S	Ø d	L	Wedge	Profile	PU	Ident-No. [L]	Ident-No. [R]
39,5	15.7	1.5	4,0	26	55	A	10	185205	185510
39,5	15.7	1.5	4,0	26	55	B	10	185206	185511
39,5	15.7	1.5	4,0	26	55	C	10	185207	185512
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		[pc.]		
B	H	S	Ø d	L	Wedge		PU	Ident-No.	
34,9	18.6	2.0	5,0	13,8	55	without serration Weinmann	3	185363	
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		[pc.]		

150523 / 150525

Profile Knives HW with 1 cutting edge, end sharpened

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in shank-type cutters

Design

| cutting material: HW
 | HW HL Board 03 for wood-based panels and plastics
 | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces

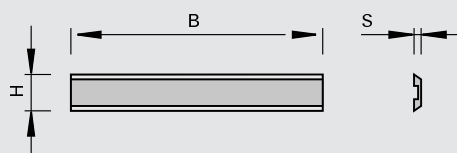
B	H	S	Ø d	L	Wedge∠	LEUCODUR	Ident-No.
16	7.0	1.5	3,4	7,0	55	HL Board 03	180262
23	7.0	1.5	3,4	14	55	HL Board 05	182697
28	7.0	1.5	3,4	14	55	HL Board 03	180260
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150515

Turnover Knives HW with 2 cutting edges - Leitz

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in Leitz cutterheads

Design

| cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces

B	H	S	Ident-No.
14,7	8.0	1.5	181504
19,7	8.0	1.5	181505
30	8.0	1.5	181506
35	8.0	1.5	181507
40	8.0	1.5	181508
50	8.0	1.5	181509
60	8.0	1.5	181510
80	8.0	1.5	181511 s
[mm]	[mm]	[mm]	

150516 / 150518 / 151557

Turnover Knives HW with 4 cutting edges with countersink - Hundegger

Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
machines Hundegger for use in cutterheads	cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods HL Solid 20 for hard and soft woods HL Solid 30 for hard and soft woods		packing unit 10 pieces Attention! it is not permitted to mount Ident-No. 186667 + 186668 together in one cutterhead. Danger of unbalance!

Type	B	H	S	Ø d	Wedge		LEUCODUR	Ident-No.
1	20,6	20,6	5,5	7,3	50	for surfCut cutterhead, with rounded edges (R=172 mm)	Hundegger	HL Solid 30 186667
1	21	21	5,5	7,3	50	with groove	Hundegger	HL Solid 30 186668
2	11,95	11,95	1,5	4,0	55	with rounded edges (R=70 mm)	Hundegger	HL Board 06 186448
2	13,8	13,8	2,5	6,2	60	with rounded edges (R=180 mm)		HL Solid 20 184942
2	15	15	2,5	6,2	50	with rounded edges (R=170 mm)	Hundegger	HL Solid 20 185367
	[mm]	[mm]	[mm]	[mm]	[°]			

151559

Turnover Knives HW with 4 cutting edges with countersink - EWD, Linck

Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
machines EWD, Linck for use in cutterheads	cutting material: HW HL Solid 60 for hard and soft woods		packing unit 10 pieces

B	H	S	Ø d	Wedge		LEUCODUR	Ident-No.
21	21	5,5	7,3	63	for Ø D=402 mm	HL Solid 60	186111
21	21	5,5	7,3	63	for Ø D=360 mm	HL Solid 60	186110
[mm]	[mm]	[mm]	[mm]	[°]			

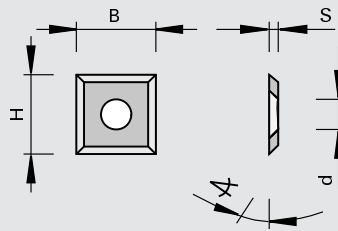
150517 / 150518 / 150553 / 150555 / 150557 / 150558 / 150757

Turnover Knives HW with 4 cutting edges and countersink

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | machines Homag, Fischer Brugg, IMA, Weinig, Lestro, HOLZ-HER
- | for the use as flat scraper on Homag edge banding machines FA20 + FA21
- | for use in edge jointing cutterheads
- | for use in spiral cutterheads
- | for use in cutterheads

Design

- | topline (polished face and micro-ground clearance angle)

Advantages**Notes**

- | Ident-No. 167777 for scoring device of the HOLZ-HER vertical panel sizing saw
- | * marking for easier mounting
- | packing unit: 10 pieces

B	H	S	Ø d	Wedge	LEUCODUR		Ident-No.
10,5	10.5	1.5	4,0	55	HL Solid 20	Lestro	176719
13,6	13.6	2.0	6,3	45	HL Solid 30	Fischer Brugg	163829
14	14	1.2	8,6	60	HL Solid 30		163701
14	14	1.2	8,6	60	HL Solid 30	HOLZ-HER	167777
14	14	2.0	6,3	60	HL Solid 20 topline		176341
14	14	2.0	6,3	60	HL Solid 30	Weinig	003079
14	14	2.0	6,3	60	HL Board 05		180954
14	14	2.0	6,3	60	HL Board 03		180646
14,3	14.3	2.5	6,3	45	HL Solid 20	IMA	183828
14,3	14.3	2.5	6,3	55	HL Solid 20	Homag (FA20 + FA21)	170248
15	15	2.5	6,2	50	HL Solid 20	Chamfering Cutterhead	181243
15	15	2.5	6,2	60	HL Solid 20	Weinig	185276 s
15	15	2.5	6,4	60	HL Solid 20	with rounded edges (R=50 mm for Spiral Cutterheads)	180454
15	15	2.5	6,4	60	HL Solid 20	with rounded edges (R=115 mm)	185950 s
15	15	2.5	6,4	60	HL Solid 20	with rounded edges (R=150)	185274
15	15	2.5	6,4	50	HL Solid 20	with rounded edges (R=190 mm for Weinig Powerlock Dual Tools Ø D=125 mm 541/542)	185865
20	14.3	2.5	6,3	55	HL Solid 20	Homag	168509
22	22	2.0	6,5	60	HL Solid 20	Weinig	185277
[mm]	[mm]	[mm]	[mm]	[°]			

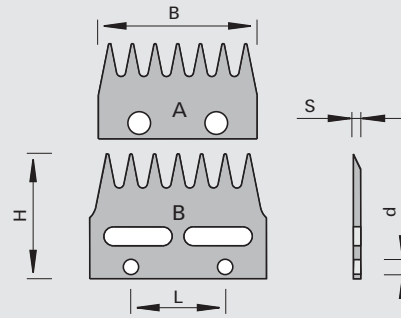
15 1586

Chip wiper insert knives HW - IMA

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

| machines IMA

Design

| cutting material: HW
| HL Board 06 for wood-based panels, plastics and hard woods


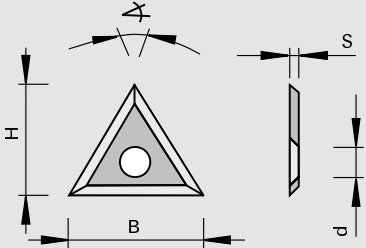
Advantages

Notes

B	H	S	Ø d	L	Type	PU	Ident-No.
70	42	2.0	10	34	A	10	185872 s
75	53	2.0	6,5	40	B	10	185873 s
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	


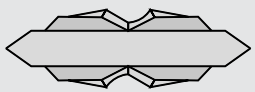
150557

Triangular Spur HW with 3 cutting edges

Product		Drawing			LEUCODUR		Tungsten Carbide [HW]	
								
Machine / Application for use in Leitz cutterheads		Design cutting material: HW HL Solid 20 for hard and soft woods		Advantages		Notes		
B	H	S	Ø d	Corner∟	LEUCODUR	PU	Ident-No.	
22 [mm]	19.05 [mm]	2.0 [mm]	6,5 [mm]	60 [°]	HL Solid 20	10 [pc.]	180779	

150557

Turnover spurs HW

Product		Drawing			LEUCODUR		Tungsten Carbide [HW]	
								
Machine / Application		Design cutting edge with scoring cut cutting material: HW HL Solid 20 for wood-based panels, hard and soft woods		Advantages chip-free hole edges thanks to cutting edge with scoring cut		Notes packing unit: 10 pieces		
Dimension		LEUCODUR			PU	Ident-No.		
18x5,7x3,5 [mm]		HL Solid 20			10 [pc.]	181263		

165512

Centering points HW

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

Design

Advantages

Notes

- | with surface on shank for set screw
- | cutting material: HW
- | HL Solid 40 for hard and soft woods

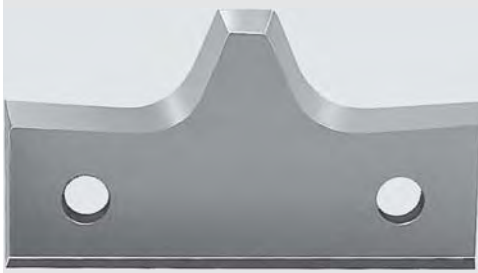
- | packing unit: 10 pieces

Ø D	L1	Ident-No.
3.0	33.5	162624
[mm]	[mm]	

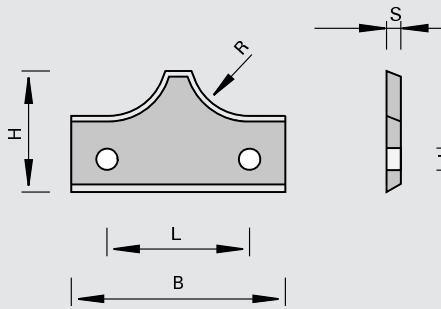
151545

Radius Profile Knives HW with 2 cutting radii and bottom chamfer - Homag, IMA

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board O5 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

R	B	H	S	Ø d	L		Ident-No.
2,0	20,5	15	2.0	3,0	12	Homag	163062 s
3,0	20,8	15	2.0	3,0	12	Homag	163063
5,0	30	17	2.0	3,0	20	Homag	163065
4,0	20,8	15	2.0	3,0	12	Homag	163064 s
6,0	30,5	17	2.0	3,0	20	Homag	163066
8,0	30,5	17	2.0	3,0	20	Homag	163068 s
2,0	20,8	14.7	2.0	3,0	12	IMA	164166 s
3,0	20,8	14.7	2.0	3,0	12	IMA	164167 s
4,0	20,8	14.7	2.0	3,0	12	IMA	164168 s
5,0	30,5	16.5	2.0	3,0	20	IMA	164169 s
6,0	30,5	16.5	2.0	3,0	20	IMA	164170 s
7,0	30,5	16.5	2.0	3,0	20	IMA	164171 s
8,0	30,5	16.5	2.0	3,0	20	IMA	164172 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

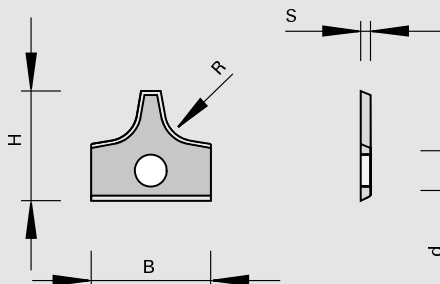
15 1545 / 15 1585

Radius Profile Knives HW with 2 cutting radii and bottom chamfer

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- type A for use in edge rounding cutterheads
- type B for use in scraper holders

Design

- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

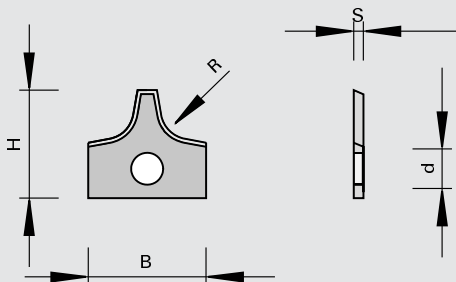
R	B	H	S	Ø d	Profile run-out	Type	PU	Ident-No.
2,0	12	12	1.5	4,0	5	A	HOLZ-HER	10 170340
3,0	12	12	1.5	4,0	5	A	HOLZ-HER	10 170341
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]
R	B	H	S	Ø d	Profile run-out	Type	PU	Ident-No.
2,0	16	15.5	2.0	4,4	10	A	Brandt	10 182087
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]
R	B	H	S	Ø d	Profile run-out	Type	PU	Ident-No.
1,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 186745
1,5	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 176583
2,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 163489
2,0	16	17.5	2.0	4,4	10	A	Brandt	10 180153
2,5	16	17.5	2.0	4,4	10	A		10 171178 s
3,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 163490
3,0	16	17.5	2.0	4,4	10	A	Brandt	10 180154
4,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 163491
5,0	16	17.5	2.0	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt	10 163492
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]
R	B	H	S	Ø d	Profile run-out	Type	PU	Ident-No.
2,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10 173475
2,5	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10 173476 s
3,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10 173477
4,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10 173478 s
5,0	16	17.5	2.0	3,0	10	B	IMA, Wilmsmayer, Torwegge	10 173479
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			[pc.]

151545 / 151585

Radius Profile Knives HW with 2 cutting radii

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

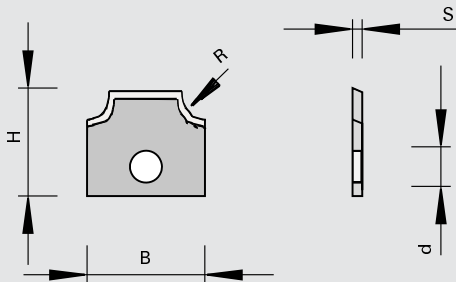
R	B	H	S	Ø d	Profile run-out	Ident-No.
2,0	12	13	2.0	5,0	10	Brandt
2,5	12	13	2.0	4,0	10	
3,0	12	13	2.0	5,0	10	Brandt
6,0	24	22	2.0	4,4	10	Homag, Ott
8,0	24	22	2.0	4,4	10	Homag, Ott
9,0	24	22	2.0	4,4	10	Homag, Ott
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

151586

Radius Profile Knives HW with 2 cutting radii - EBM, Hebrock

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

edge banding machines EBM, Hebrock
for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

R	B	H	S	Ø d	Profile run-out	Ident-No.
2,0	16	13.5	2.0	5,0	5	EBM, Hebrock
3,0	16	13.5	2.0	5,0	5	EBM, Hebrock
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

15 1555

Radius Profile Knives HW symmetrical with 2 cutting radii

Product	Drawing	

Machine / Application	Design	Advantages	Notes
for use in edge banding / rounding cutterheads	cutting material: HW HL Board O5 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

R	B	H	S	Ø d	Profile run-out	Ident-No.
2,0	13	16	2.0	4,0	5	162794
3,0	13	16	2.0	4,0	5	162795
4,0	13	16	2.0	4,0	5	162565
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

R	B	H	S	Ø d	Profile run-out	Ident-No.
2,0	13	16	2.0	4,0	15	IMA 172713
3,0	13	16	2.0	4,0	15	IMA 172714
4,0	13	16	2.0	4,0	15	IMA 172715 s
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

15 1555

Radius Turnover Knives HW symmetrical with 2 cutting radii

Product	Drawing	

Machine / Application	Design	Advantages	Notes
for use in edge banding / rounding cutterheads	5 degree profile run-out cutting material: HW HL Board O5 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

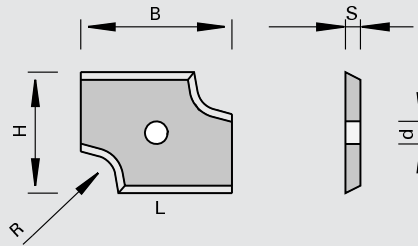
R	B	H	S	Ø d	Ident-No.
5,0	20	21	2.0	4,0	162566
6,0	20	21	2.0	4,0	162567
7,0	20	21	2.0	4,0	162568 s
8,0	20	21	2.0	4,0	162569
9,0	26	24	2.0	4,0	162796
10	26	24	2.0	4,0	162570
11	26	24	2.0	4,0	162571 s
12	26	24	2.0	4,0	162572
[mm]	[mm]	[mm]	[mm]	[mm]	

151555

Radius Turnover Knives HW with 2 cutting radii

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

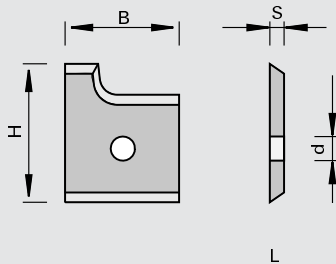
R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
3,0	20	16	2,0	3,0		168355	168356
2,0	30	14	2,0	4,0	Reich	177136 s	177135 s
2,5	30	14	2,0	4,0	Reich	177138 s	177137 s
3,0	30	14	2,0	4,0	Reich	177140 s	177139 s
[mm]	[mm]	[mm]	[mm]	[mm]			

151545 / 151546

Radius Profile Knives HW with 1 cutting radius and bottom chamfer

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 and HL Board 06 for wood-based panels, plastics and hard woods

Advantages

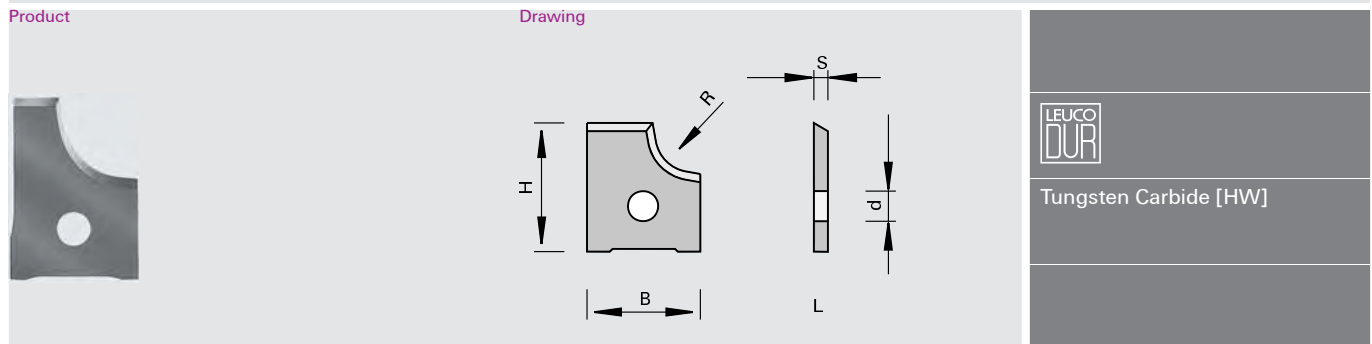
Notes

packing unit: 10 pieces

R	B	H	S	Ø d	LEUCODUR	Ident-No. [L]	Ident-No. [R]
2,0	12	14,5	2,0	4,0	HL Board 05	172142	172141
2,5	12	14,5	2,0	4,0	HL Board 05	171224	171223
3,0	12	14,5	2,0	4,0	HL Board 05	172144	172143
2,0	14,5	14,5	2,0	5,0	HL Board 06	185377	185376
2,5	14,5	14,5	2,0	5,0	HL Board 06	181657	181658
[mm]	[mm]	[mm]	[mm]	[mm]			

151545 / 151546

Radius Profile Knives HW with 1 cutting radius


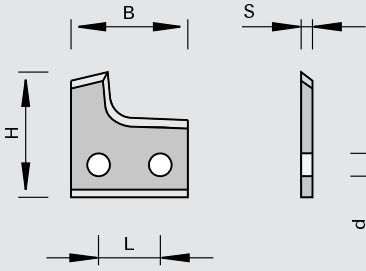



Machine / Application	Design	Advantages	Notes
for use in rounding cutterheads	cutting material: HW HL Board 05 and HL Board 06 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

R	B	H	S	Ø d	Profile run-out	LEUCODUR	Ident-No. [L]	Ident-No. [R]
2,0	12	15	2.0	4,0	10	HL Board 06	177034	177038
1,5	12	17	2.0	5,0	13	Homag HL Board 06	177605	177606
2,0	12	17	2.0	5,0	13	Homag HL Board 06	177607	177608
2,5	12	17	2.0	5,0	13	Homag HL Board 06	177609 s	177610 s
3,0	12	17	2.0	5,0	13	Homag HL Board 06	177611	177612
2,0	12	18	2.0	4,0	11	HL Board 05		172725 s
3,0	12	18	2.0	4,0	11	HL Board 05		172726 s
1,0	13	15	2.0	4,0	10	HL Board 05	180722	180721
1,5	13	15	2.0	4,0	10	HL Board 05	181954	181953
2,0	13	15	2.0	4,0	10	HL Board 05	181956	181955
2,5	13	15	2.0	4,0	10	HL Board 05	180728 s	180727 s
3,0	13	15	2.0	4,0	10	HL Board 05	181957	181958
4,0	14	17	2.0	4,0	10	HL Board 06	177036 s	177040 s
2,0	15	14.5	2.0	4,0	15	HL Board 05	177317	177318
2,5	15	14.5	2.0	4,0	15	HL Board 05	177319	177320
3,0	15	14.5	2.0	4,0	15	HL Board 05	177321	177322
5,0	15	17	2.0	4,0	10	HL Board 05	177037	177041
3,0	15	18.4	2.0	4,0	5	HL Board 06	168272 s	168279 s
4,0	15	18.4	2.0	4,0	5	HL Board 06	168273 s	168280 s
5,0	15	18.4	2.0	4,0	5	HL Board 06	168274 s	168281 s
6,0	15	21.6	2.0	4,0	5	HL Board 06	168286 s	168293 s
8,0	15	21.6	2.0	4,0	5	HL Board 06	168288 s	168295 s
2,0	16,1	14	2.0	4,0	15	HL Board 06	178219	178218
3,0	16,1	14	2.0	4,0	15	HL Board 06	178221	178220
2,0	19,6	15.2	2.0	4,0	15	HL Board 06	173817	173816
3,0	19,6	15.2	2.0	4,0	15	HL Board 05	173393	173392
9,0	20	25.8	2.0	4,0	5	HL Board 06	168301 s	168310 s
10	20	25.8	2.0	4,0	5	HL Board 06	168302 s	168311 s
12	20	25.8	2.0	4,0	5	HL Board 06	168304 s	168313
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			

151545

Radius Profile Knives HW with 1 cutting radius and bottom chamfer - IMA

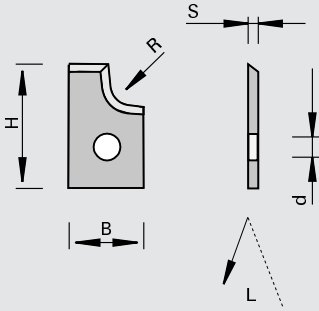

Product 	Drawing 	 Tungsten Carbide [HW]
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Machine / Application machine IMA for use in rounding cutterheads	Design 5 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	Advantages	Notes packing unit: 10 pieces
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R	B	H	S	Ø d	L		Ident-No. [L]	Ident-No. [R]
9,0	21,8	19,5	2,0	3,0	12	IMA	164173 s	164174 s
10	21,8	19,5	2,0	3,0	12	IMA	164175 s	164176 s
11	21,8	19,5	2,0	3,0	12	IMA	164177 s	164178 s
12	21,8	19,5	2,0	3,0	12	IMA	164179 s	164180 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

151545

Radius Profile Knives HW with 1 cutting radius - IMA

Product	Drawing 	 Tungsten Carbide [HW]
----------------	---	--

Machine / Application machines IMA for use in rounding cutterheads	Design 15 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	Advantages	Notes packing unit: 10 pieces
---	--	-------------------	---

R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
2,0	12	18	2,0	5,0		180174	180173
3,0	12	18	2,0	5,0		180176	180175
[mm]	[mm]	[mm]	[mm]	[mm]			

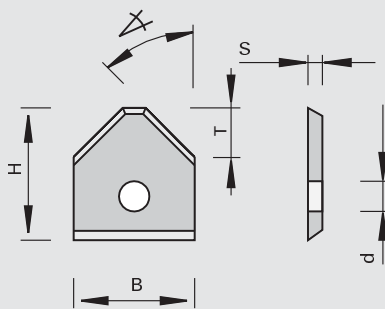
15 1545

Chamfering Knives HW with 2 cutting radii

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

Ident-No. 180792 for Modula
packing unit: 10 pieces

Chamfer∠	B	H	S	Ø d	T	Ident-No.
45	12	12	1.5	4,0	4,2	171190
45	12	12	1.5	4,0	5,5	180792
45	16	17.5	2.0	3,0	5,9	169292
45	16	17.5	2.0	4,3	6,4	170329
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	

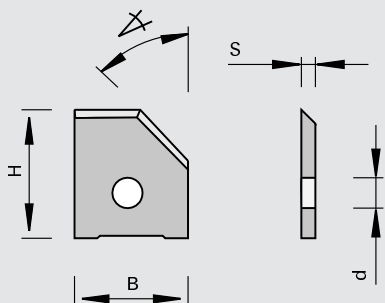
15 1586

Chamfering Knives HW with 1 cutting radius

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

machining centers Homag
for use in chamfering cutterheads

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

Chamfer∠	B	H	S	Ø d	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
5	12	16	2.0	5,0	HL Board 06	10	179174	179173
15	11,7	16	2.0	4,0	HL Board 06	10	177042	177045
30	13,5	16	2.0	4,0	HL Board 06	10	177043	177046
45	12,2	16	2.0	4,0	HL Board 06	10	177822	177823
45	15	16	2.0	4,0	HL Board 06	10	177044 s	177047 s
[°]	[mm]	[mm]	[mm]	[mm]		[pc.]		

151519

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 90 degrees

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> vertical panel sizing saws HOLZ-HER for use in 90 degree Folding cutterhead Ident-No. 182616 for the machining of aluminum composite materials 	<ul style="list-style-type: none"> cutting material: HW HL Solid 40 for hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	◁	Ident-No.
14 [mm]	14 [mm]	2.0 [mm]	6,4 [mm]	90 [°]	182079

151516

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 135 degrees

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> vertical panel sizing saws HOLZ-HER for use in 135 degree Folding cutterhead Ident-No. 703144 for the machining of aluminum composite materials 	<ul style="list-style-type: none"> cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	◁	Ident-No.
20 [mm]	18 [mm]	2.0 [mm]	5,7 [mm]	135 [°]	182080 s

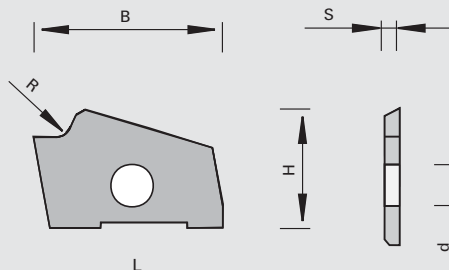
15 1586

Radius Profile Knives HW - Brandt

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

edge banding machines Brandt since date of fabrication 2005
for use in rounding cutterheads with special chip removing design

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
1,0	22,32	14	2.0	5,0	185238	185239
1,5	22,32	14	2.0	5,0	183068 s	183067 s
2,0	22,32	14	2.0	5,0	182332	182331
2,5	22,32	14	2.0	5,0	182368 s	182367 s
3,0	22,32	14	2.0	5,0	182334	182333
[mm]	[mm]	[mm]	[mm]	[mm]		

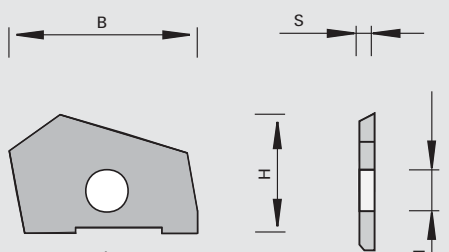
15 1586

Chamfering Profile Knives HW - Brandt

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

edge banding machines Brandt since date of fabrication 2005
for use in rounding cutterheads with special chip removing design

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

Chamfer◁	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
45	22,32	14	2.0	5,0	182667	182666
[°]	[mm]	[mm]	[mm]	[mm]		

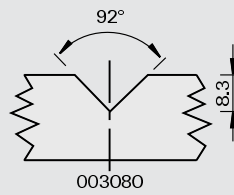
150515 / 151545

Profile Knives HW for ornamental groove cutterheads

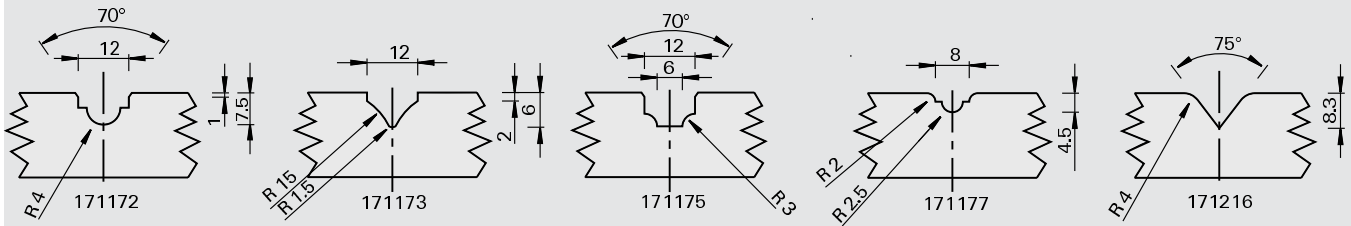
Product



Drawing



Tungsten Carbide [HW]



Machine / Application

for use in ornamental groove cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
12	12	1.5	4,0	003080
12	12	1.5	4,0	171177
11	12	1.5	4,0	171175
11	12	1.5	4,0	171172
12	12	1.5	4,0	171216
11	12	1.5	4,0	171173
[mm]	[mm]	[mm]	[mm]	

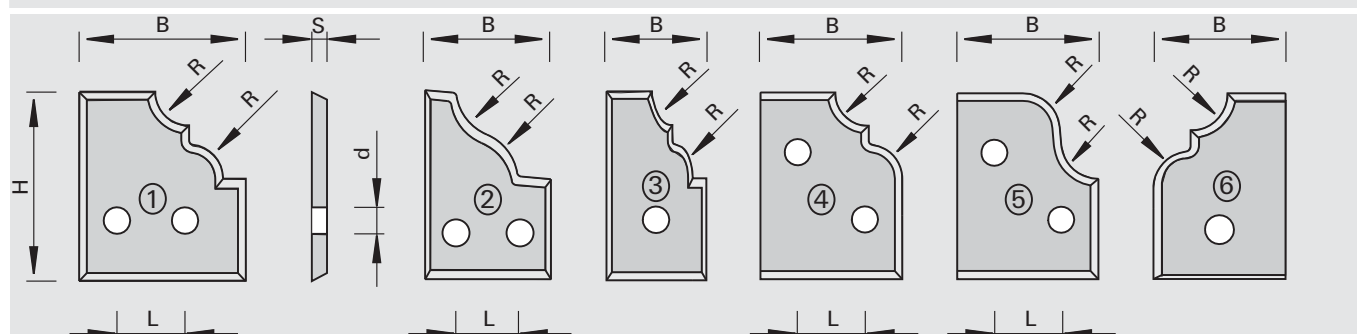
15 1547

Profile Knives HW for stile-and-rail profile cutterheads and panel raising cutterheads

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

l type 1, 2, 3 for use in stile-and-rail profile cutterheads
l type 4, 5, 6 for use in panel-raising cutterheads

Design

l cutting material: HW
l HL Solid 20 for hard and soft woods

Advantages

Notes

R	B	H	S	Ø d	L	Type	Ident-No.
4,5	19,3	24,5	2,0	3,5	11,2	1	165912 s
6,5	16,3	24,5	2,0	3,5	8,3	2	166127 s
7,0	13,3	24,5	2,0	3,5		3	167469 #
4,5	19	25	2,0	3,5	9,0	4	165930 s
5,0	19	25	2,0	3,5	9,0	5	165932 s
4,5	16	22,5	2,0	4,0		6	168883 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

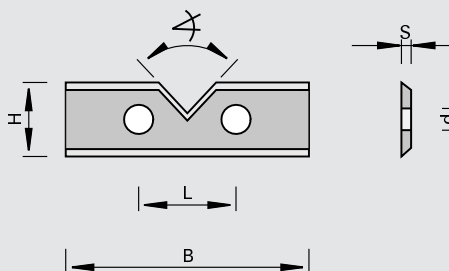
15 1547

Miter Glue Joint Profile Knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

l for use in miter glue joint cutterheads

Design

l cutting material: HW
l HL Solid 20 for hard and soft woods

Advantages

l very accurate profiling for optimum glue joints

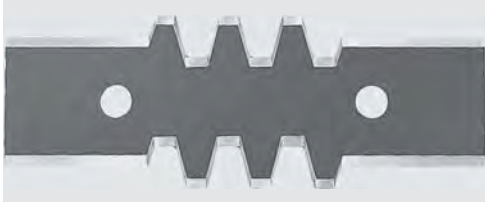
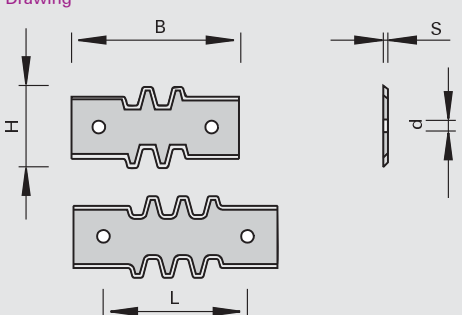

Notes

l packing unit: 10 pieces

Chamfer	B	H	S	Ø d	L	Ident-No.
86 [°]	39,5 [mm]	12 [mm]	1,5 [mm]	4,0 [mm]	26 [mm]	165916

151555 / 151557

Glue Joint Profile Turnover Knives HW


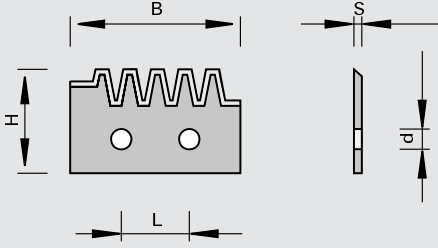

Product 	Drawing 	 Tungsten Carbide [HW]
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Machine / Application for use in glue joint cutterheads	Design cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods HL Solid 20 for hard and soft woods	Advantages very accurate profiling for optimum glue joints	Notes packing unit: 10 pieces
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B	H	S	Ø d	L	Ident-No.
50	21.6	2.0	4,0	26	165911
60	21.6	2.0	4,0	32	165909 s
50	23	2.0	4,0	26	180431
60	23	2.0	4,0	36	180432
[mm]	[mm]	[mm]	[mm]	[mm]	

151597

Glue Joint Profile Turnover Knives HW Set

Product 	Drawing 	 Tungsten Carbide [HW]
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Machine / Application for use in adjustable glue joint cutterheads	Design cutting material: HW HL Solid 20 for hard and soft woods	Advantages very accurate profiling for optimum glue joints	Notes set consists of 4 pieces Ident-No. 167977, 4 pieces Ident-No. 167976 Ident-No. 167976, 167977 packing unit: 10 pieces
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B	H	S	Ø d	L	Ident-No.
42	20	2.0	4,0	26	168240 s
[mm]	[mm]	[mm]	[mm]	[mm]	

Accessories	B	H	S	Class-No.	PU	Ident-No.
Glue Joint Profile Knives HW	43,5	20	2.0	151547	10	167976 s
Glue Joint Profile Knives HW	42	20	2.0	151547	10	167977 s
	[mm]	[mm]	[mm]		[pc.]	

132891

Turnover Knife Holders - Ledinek Rotoles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

l planing machines Ledinek Rotoles
l for LEUCODUR turnover knives straight and with chamfer

Design

l for mounting of LEUCODUR turnover knives 14 x 14 mm and 14.3 x 14.3 mm

Advantages

Notes

Ident-No.

for thicknesser (TOK 14x14x2) top	182082	o
for service planing rotor (TOK 14x14x2) bottom	182083	o
for thicknesser segments (TOK 14,3x14,3x2,5) top	182084	o
for service planing rotor segments (TOK 14,3x14,3x2,5) bottom	182085	o

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws	M5x9 T20 D=Ø9,3 [mm]	995 125	10 [pc.]	827277
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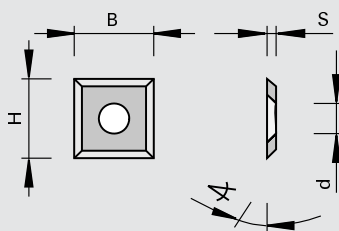
150517 / 150553 / 150555 / 150558

Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

l planing machines Ledinek Rotoles
l for use in turnover knife holders for plain milling

Design

l cutting material: HW
l HL Board 03 for wood-based panels and plastics
l HL Board 05 for wood-based panels, plastics and hard woods
l HL Solid 20 for wood-based panels, hard and soft woods
l HL Solid 30 for hard and soft woods

Advantages

Notes

l packing unit: 10 pieces

B	H	S	Ø d	Wedge∟	LEUCODUR	Ident-No.
14	14	2.0	6,3	60	HL Solid 30	003079
14	14	2.0	6,3	60	HL Board 05	180954
14	14	2.0	6,3	60	HL Board 03	180646
14,3	14.3	2.5	6,3	55	HL Solid 20	170248
[mm]	[mm]	[mm]	[mm]	[°]		

150557

Profile Turnover Knives HW with 4 cutting edges and chamfer - Ledinek Rotoles

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> planing machines Ledinek Rotoles for use in turnover knife holders for plain milling 	<ul style="list-style-type: none"> cutting material: HW HL Solid 20 for wood-based panels, hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	180933	180932
14,3	14.3	2.5	6,4	55	HL Solid 20	181144	181143
[mm]	[mm]	[mm]	[mm]	[°]			

150557

Profile Turnover Knives HW with 4 cutting edges and radius - Ledinek Rotoles

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> planing machines Ledinek Rotoles for use in turnover knife holders for plain milling 	<ul style="list-style-type: none"> cutting material: HW HL Solid 20 for wood-based panels, hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	182442	182441
14,3	14.3	2.5	6,4	55	HL Solid 20	182444	182443
[mm]	[mm]	[mm]	[mm]	[°]			

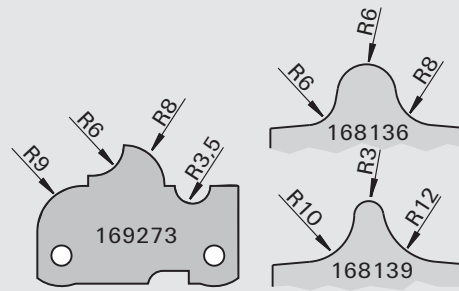
15 1526

SuperProfiler Knives HW "Multi-Profile"

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

table shapers
for use in SuperProfiler
cutterheads Ident-No. 167897
and 167894

Design

cutting material: HW
HL Board 06 for hard and soft
woods

Advantages

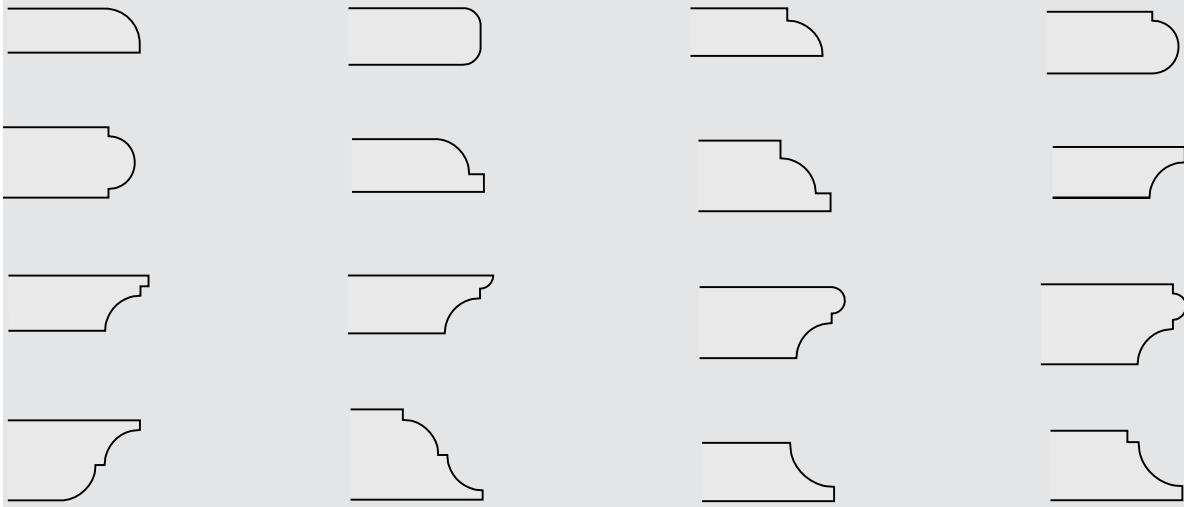
Notes

for cutting of various profiles
in one or more steps
profile examples see Technical
Appendix

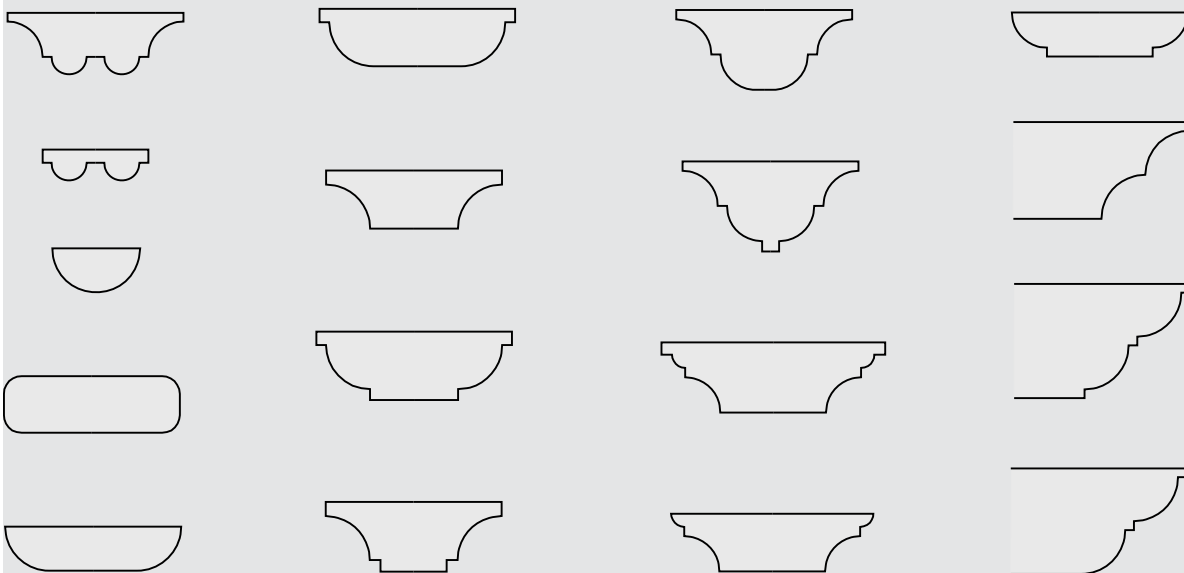
B	PU	Ident-No.
40	10	169273 s
39,5	10	168136 s
39,5	10	168139 s
[mm]		[pc.]

SuperProfiler "Multi-Profile"

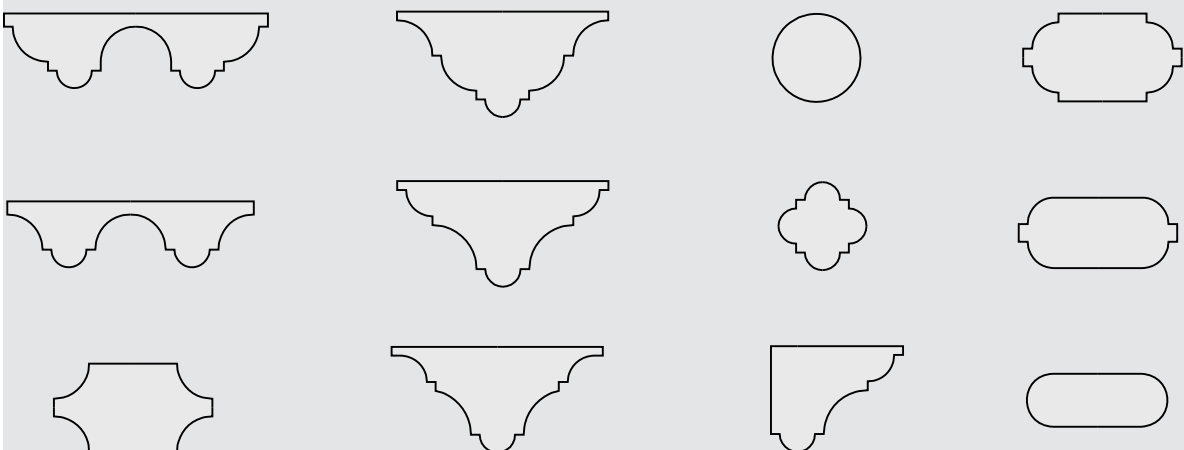
1 Operation



2 Operations



Several operations



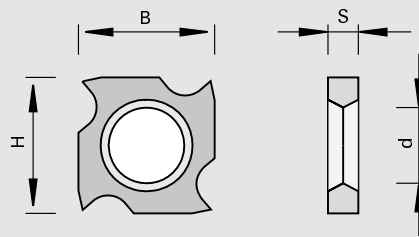
150508

Grooving Turnover Knives HW with 4 cutting edges - grooving cutterheads

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in grooving cutterheads

Design

cutting material: HW
HL Solid 30 for wood-based panels, hard and soft woods

Advantages

Notes

Ident-No. 163699 for groove width 4 mm
Ident-No. 165906 for groove width 5 mm
Ident-No. 169250 for groove width > 7 mm
packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
18	18	1.95	10	163699
18	18	2.5	10	165906
18	18	3.7	10	169250
[mm]	[mm]	[mm]	[mm]	

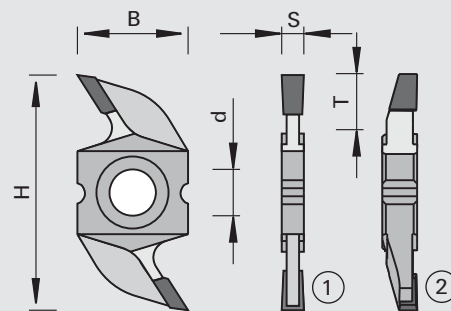
150508/150509

Grooving Turnover Knives HW with 2 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for grooving

Design

bore countersunk 90 degrees
cutting material: HW
HL Solid 30 and HL Solid 40 for hard and soft woods

Advantages

high accuracy thanks to radial positioning
more simple handling

Notes

spacer rings for the adjustment of the rounding knives see chapter replacement parts

B	H	S	Ø d	Tmax	LEUCODUR	PU	Ident-No.
13	36	3.5	7,4	10	HL Solid 30	5	165968
16	34	3.2	6,7	8,0	HL Solid 30	5	183663
16	34	3.5	6,7	8,0	HL Solid 30	5	183664 s
16	34	4.0	6,7	8,0	HL Solid 30	5	183665
16	34	5.0	6,7	8,0	HL Solid 30	5	183666
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

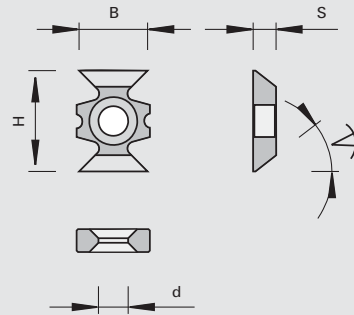
150577

Chamfering Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for chamfering

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
more simple handling

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the chamfer knives see chapter replacement parts
packing unit: 10 pieces

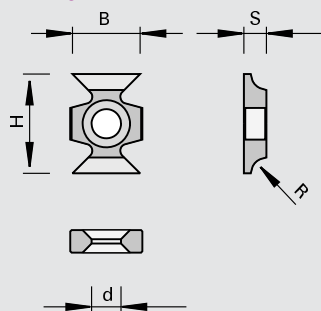
Chamfer [°]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Ident-No.
45	16	22	5.0	6,5	183668

150577

Rounding Turnover Knives HW with 4 cutting edges

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for rounding

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the rounding knives see chapter replacement parts
packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	16	22	5.0	6,5	176417 o
2,0	16	22	5.0	6,5	176418 o
2,5	16	22	5.0	6,5	176419 o
3,0	16	22	5.0	6,5	176420 o
[mm]	[mm]	[mm]	[mm]	[mm]	

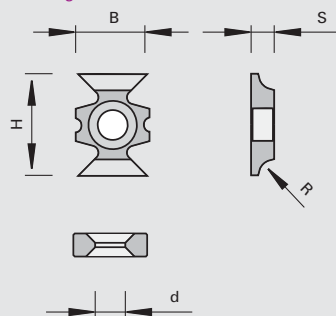
150577

Rounding Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for rounding

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
radii are interchangeable
more simple handling


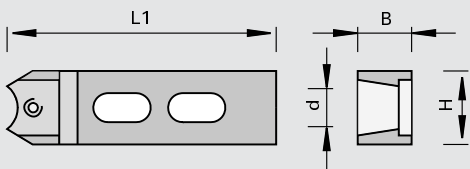

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the rounding knives see chapter replacement parts
packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	16	22	5.0	6,5	183669
2,0	16	22	5.0	6,5	183670 s
2,5	16	22	5.0	6,5	183671 s
3,0	16	22	5.0	6,5	183672
[mm]	[mm]	[mm]	[mm]	[mm]	

132891

Scraper Holders - Homag, Reich, IMA

Product	Drawing	
		 Tungsten Carbide [HW]


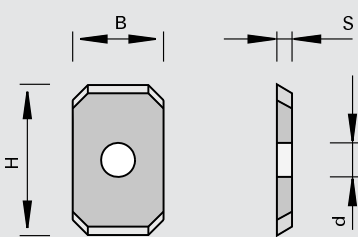

Machine / Application	Design	Advantages	Notes
edge banding machines Homag, Reich for installation of LEUCODUR radius-, chamfering- and scraper turnover knives			

B	H	Ø d	L1		Ident-No.	
for R <= 5	15	16	6,5	131	Homag, Reich	169252
for R <= 5	22	14	6,5	118	Homag	179463 s
[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966
Screwdrivers	T15	985730	1	163161
Screwdrivers	T15x80	985730	1	171188
	[mm]		[pc.]	

151555

Scraper Turnover Knives HW with 2 cutting edges and chamfer - Homag, IMA, Reich

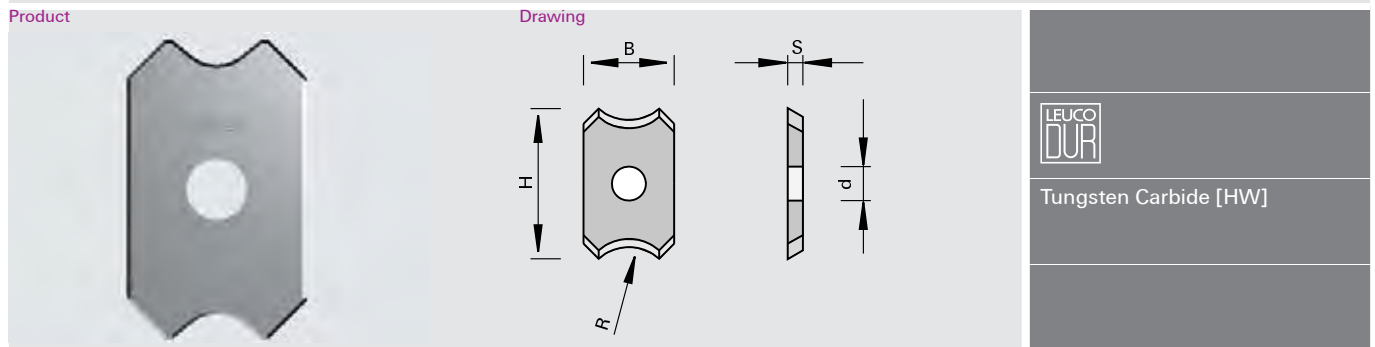
Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
edge banding machines Homag, IMA, Reich for use in scraper holders	chamfer angle 45 degrees cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		

B	H	S	Ø d		PU	Ident-No.
12	20	2.0	4,0		2	171188
[mm]	[mm]	[mm]	[mm]		[pc.]	

15 1555

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag, HOLZ-HER, Brandt


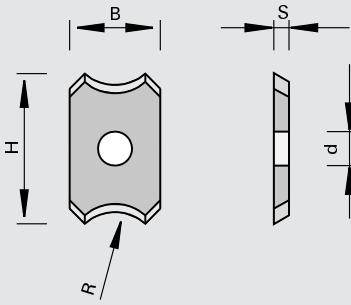




Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag PN10, Homag PN20 (to 2015-12-31), HOLZ-HER 1927/1929, Brandt Ambition - 1110 F (KDF110) / 1120 FC (KDF120C) for use in scrapper holders 	<ul style="list-style-type: none"> 6 degree profile run-out cutting material: HW HL Board 05 for wood-based panels and plastics 		

R	B	H	S	Ø d		PU	Ident-No.
0,8	12	20	2.0	4,0	Homag, HOLZ-HER	2	171401
1,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169253
1,3	12	20	2.0	4,0	Homag, HOLZ-HER	2	185454
1,5	12	20	2.0	4,0	Homag, HOLZ-HER	2	169254
2,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169255
2,5	12	20	2.0	4,0	Homag, HOLZ-HER	2	169256
3,0	12	20	2.0	4,0	Homag, HOLZ-HER	2	169257
4,0	12	20	2.0	4,0	Homag, HOLZ-HER	6	169259 s
5,0	12	20	2.0	4,0	Homag, HOLZ-HER	6	169261 s
1,2	12	20	2.0	4,0	Brandt	6	186102 s
2,0	12	20	2.0	4,0	Brandt	6	186103 s
3,0	12	20	2.0	4,0	Brandt	2	186104
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

151755

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag, HOLZ-HER, Reich for high gloss finish (on PE/PVC/ABS)

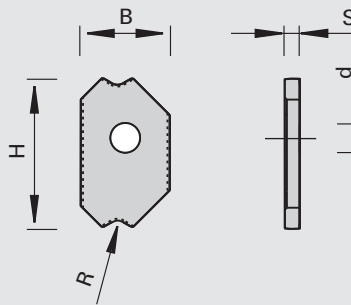

Product 	Drawing 	  Tungsten Carbide [HW]
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Machine / Application edge banding machines Homag PN10, Homag PN20 (to 2015-12-31), HOLZ-HER 1927/1929, Reich for use in scraper holders	Design 6 degree profile run-out special scraper which avoids material fracturing cutting material: HW HL Board 05 for wood-based panels and plastics	Advantages no material fracturing no additional work steps needed for high gloss finish	Notes
--	---	---	--------------

R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	2	186433
1,3	12	20	2.0	4,0	2	186434
1,5	12	20	2.0	4,0	2	181234
2,0	12	20	2.0	4,0	2	181235
3,0	12	20	2.0	4,0	2	181237
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151545

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag (non-symmetrical location of positioning hole)

Product	Drawing 	 Tungsten Carbide [HW]
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Machine / Application edge banding machines Homag Flexblade PN21	Design non-symmetrical profile and location of positioning hole cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	Advantages	Notes
---	---	-------------------	--------------

R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	2	185378
1,5	12	20	2.0	4,0	2	185379
2,0	12	20	2.0	4,0	2	185380
2,5	12	20	2.0	4,0	6	185850 s
3,0	12	20	2.0	4,0	6	185851 s
4,0	12	20	2.0	4,0	6	185852 s
5,0	12	20	2.0	4,0	6	185853 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151545

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag (non-symmetrical location of positioning hole, chamfer to prevent material fracturing)

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag Flexblade PN21 	<ul style="list-style-type: none"> non-symmetrical profile and location of positioning hole special scraper which avoids material fracturing cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods 	<ul style="list-style-type: none"> no material fracturing also in the case of PP-edges no additional work steps needed 	

R	B	H	S	Ø d	PU	Ident-No.
1,0	12	20	2.0	4,0	10	185854 s
1,5	12	20	2.0	4,0	10	185855 s
2,0	12	20	2.0	4,0	10	185856 s
2,5	12	20	2.0	4,0	10	185857 s
3,0	12	20	2.0	4,0	10	185858 s
4,0	12	20	2.0	4,0	10	185859 s
5,0	12	20	2.0	4,0	10	185860 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

132891

Scrapper-holder, 1 times - HOLZ-HER, aggregate ZK501

Product	Drawing	


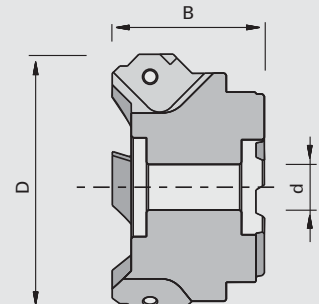
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines HOLZ-HER aggregate ZK501 for mounting of a radius- or chamfering scraper turnover knife 	<ul style="list-style-type: none"> scraper-holder, single, without scraper knife for application on top and bottom burnished 		

Ø D	B	Ø d	Z	Ident-No.
70	46,5	M12	2	185718
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x10,5 T15	995 195	10	179475
	[mm]		[pc.]	

132891

Scraper-holder, 5 times - HOLZ-HER, aggregate ZK701

Product 	Drawing 	
		Alloyed Steel


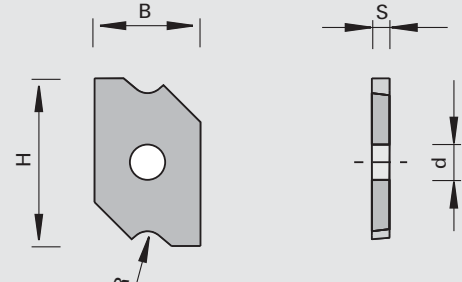
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines HOLZ-HER aggregate ZK701 for mounting of up to 5 radius or chamfering scraper turnover knives 	<ul style="list-style-type: none"> Scraper holder (turret) 5-times, without scraper knives burnished 	<ul style="list-style-type: none"> individual mounting of up to 5 different scraper knives very suitable for batch size 1, as no expenditure of time for setup increase of productivity 	<ul style="list-style-type: none"> rotating direction left can be used on bottom side, rotating direction right on top side

Ø D	B	Ø d	Z	Ident-No. bottom	Ident-No. top
70	40	12	5	185716	185717
[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x10,5 T15	995195	10	179475
Toothed ring	Ø50x9xØ20 [mm]	997300	1 [pc.]	185719

151586

Scraper Turnover Knives HW - HOLZ-HER, aggregate ZK501 / ZK701 (chamfer to prevent material fracturing)

Product 	Drawing 	
		LEUCO DUR Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines HOLZ-HER aggregate ZK501 / ZK701 for use in scraper-holders (turret) 	<ul style="list-style-type: none"> cutting edge with chamfer to prevent material fracturing cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods 	<ul style="list-style-type: none"> no material fracturing also in the case of PP-edges no additional work steps needed 	<ul style="list-style-type: none"> rotating direction left can be used on bottom side, rotating direction right on top side

R	B	H	S	PU	Ident-No. [L]	Ident-No. [R]
1,0	12	19	2,0	6	185720 s	185721 s
1,3	12	19	2,0	6	185722 s	185723 s
2,0	12	19	2,0	2	185724	185725
3,0	12	19	2,0	6	185726 s	185727 s
[mm]	[mm]	[mm]	[mm]	[pc.]		

Chamfer∠	B	H	S	PU	Ident-No. [L]	Ident-No. [R]
10	12	19	2,0	6	185728 s	185729 s
45	12	19	2,0	6	185730 s	185731 s
[°]	[mm]	[mm]	[mm]	[pc.]		

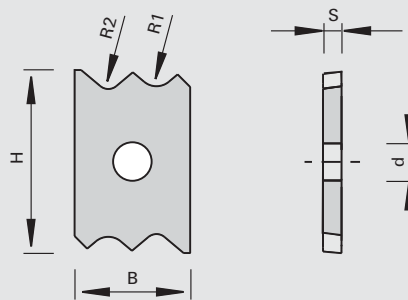
15 1555

Multi Scrapper Knives HW - HOLZ-HER, aggregate ZK502

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines HOLZ-HER aggregate ZK502
- for use in scrapper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scrapper
- Cutting material: HW
- HL Board 05 for wood-based materials, plastic and hard wood

Advantages

Notes

- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
2.0	1.3	12	19	2.0	4,0	2	186887	186788
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		

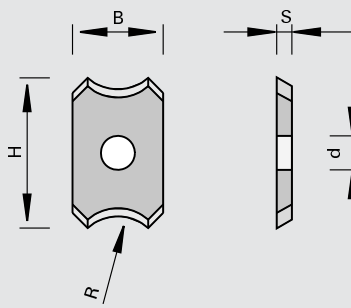
15 1555

Scrapper Turnover Knives HW with 2 cutting edges and radius - IMA

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines IMA
- for use in scrapper holders

Design

- 15 degree profile run-out
- cutting material: HW
- HL Board 05 for wood-based panels, plastics and hard woods


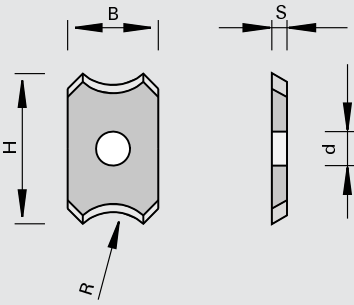

Advantages

Notes

R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	6	184788 s
1,0	12	20	2.0	4,0	2	178856
1,3	12	20	2.0	4,0	6	184791 s
1,5	12	20	2.0	4,0	2	185179
2,0	12	20	2.0	4,0	2	178957
2,5	12	20	2.0	4,0	6	184794 s
3,0	12	20	2.0	4,0	2	178857
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151755

Scrapper Turnover Knives HW with 2 cutting edges and radius - IMA (chamfer to prevent material fracturing)


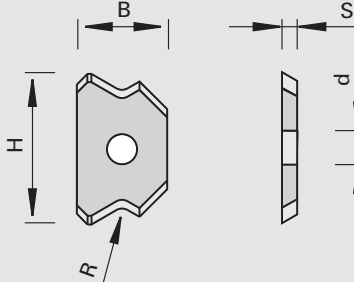

Product 	Drawing 	 Tungsten Carbide [HW]
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Machine / Application edge banding machines IMA for use in scrapper holders	Design 15 degree profile run-out special scrapper which avoids material fracturing cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	Advantages no material fracturing also in the case of PP-edges no additional work steps needed	Notes
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R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	6	184789 s
1,0	12	20	2.0	4,0	6	184790 s
1,3	12	20	2.0	4,0	6	184792 s
1,5	12	20	2.0	4,0	6	184793 s
2,0	12	20	2.0	4,0	2	181236
2,5	12	20	2.0	4,0	6	184795 s
3,0	12	20	2.0	4,0	2	181238
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]

151586

Scrapper Turnover Knives HW with 2 cutting edges and radius - IMA (asymmetrical)


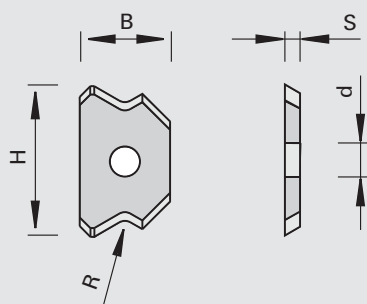
Product 	Drawing 	 Tungsten Carbide [HW]
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Machine / Application edge banding machines IMA for use in scrapper holders	Design non-symmetrical profile 15 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	Advantages	Notes
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R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	6	184796 s
1,0	12	20	2.0	4,0	6	184798 s
1,3	12	20	2.0	4,0	6	184800 s
1,5	12	20	2.0	4,0	2	184802
2,0	12	20	2.0	4,0	2	184804
2,5	12	20	2.0	4,0	6	184807 s
3,0	12	20	2.0	4,0	2	184809
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]

151755

Scrapper Turnover Knives HW with 2 cutting edges and radius - IMA (asymmetrical, chamfer to prevent material fracturing for high gloss finish on PE/PVC/ABS)

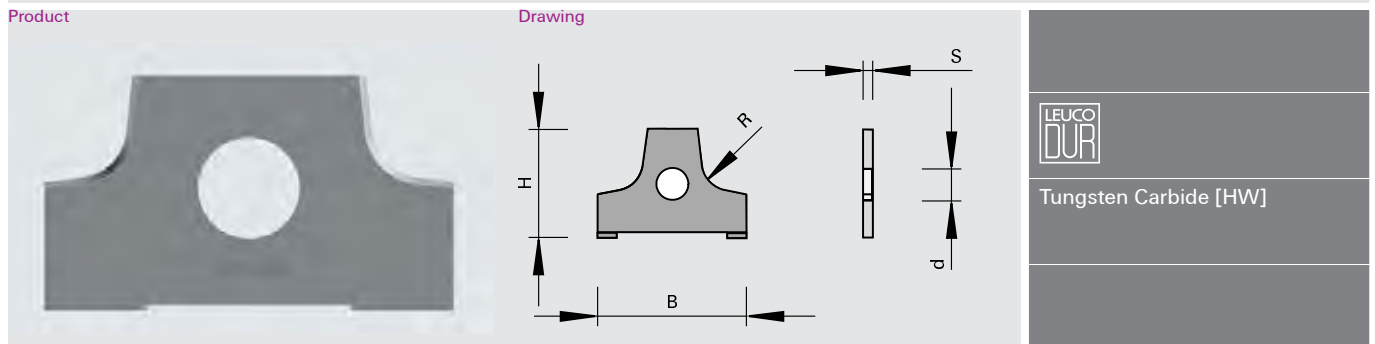
<p>Product</p> 	<p>Drawing</p> 	<p>LEUCO topline</p> <p>LEUCO DUR</p> <p>Tungsten Carbide [HW]</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> edge banding machines IMA for use in scrapper holders 	<p>Design</p> <ul style="list-style-type: none"> non-symmetrical profile 15 degree profile run-out cutting edge with chamfer to prevent material fracturing cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods 	<p>Advantages</p> <ul style="list-style-type: none"> no material fracturing no additional work steps needed for high gloss finish 	<p>Notes</p>
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R	B	H	S	Ø d	PU	Ident-No.
0,8	12	20	2.0	4,0	6	184797 s
1,0	12	20	2.0	4,0	6	184799 s
1,3	12	20	2.0	4,0	6	184801 s
1,5	12	20	2.0	4,0	2	184803
2,0	12	20	2.0	4,0	2	184806
2,5	12	20	2.0	4,0	6	184808 s
3,0	12	20	2.0	4,0	6	184810 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

151586 / 151786

Scraper Knives HW with 2 cutting edges and radius - working centers (topcoat, avoids material fracturing)



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines Homag combined with flush-cutting unit No. 1-056-11-0621 	<ul style="list-style-type: none"> 6 degree profile run-out cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods topcoat coating cutting edge with chamfer to prevent material fracturing 	<ul style="list-style-type: none"> no material fracturing also in the case of PP-edges no additional work steps needed 	

R	B	H	S	Ø d	PU	Ident-No.
1,5	20	11.5	2.0	5,0	2	180025
2,0	20	11.5	2.0	5,0	2	180020
2,5	20	11.5	2.0	5,0	2	180021
3,0	20	11.5	2.0	5,0	2	180022
4,0	20	11.5	2.0	5,0	6	185295 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

R	B	H	S	Ø d	PU	Ident-No.
1,5	20	11.5	2.0	5,0	2	185386
2,0	20	11.5	2.0	5,0	2	185387
2,5	20	11.5	2.0	5,0	6	185388 s
3,0	20	11.5	2.0	5,0	6	185389 s
4,0	20	11.5	2.0	5,0	2	185390
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

R	B	H	S	Ø d	PU	Ident-No.
1,0	20	11.5	2.0	5,0	6	185159 s
1,5	20	11.5	2.0	5,0	6	185160 s
2,0	20	11.5	2.0	5,0	6	185161 s
2,5	20	11.5	2.0	5,0	6	185162 s
3,0	20	11.5	2.0	5,0	6	185163 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

15 1586

Scrapper Knives HW with 2 cutting edges and chamfer (glue joint) - working centers

Product	Drawing	

Machine / Application	Design	Advantages	Notes
l machines Homag combined with flush-cutting unit No. 1-056-11-0621	l cutting material: HW l HL Board 06 for wood-based panels, plastics and hard woods		

Chamfer \angle	B	H	S	\emptyset d	PU	Ident-No.
3	20	11.5	2.0	5,0	10	180023 s
15	20	11.5	2.0	5,0	10	180210 s
30	20	11.5	2.0	5,0	10	180211 s
45	20	11.5	2.0	5,0	10	185296 s
[°]	[mm]	[mm]	[mm]	[mm]	[pc.]	

15 1586

Chip Breakers HW for Scrapper Knives

Product	Drawing	

Machine / Application	Design	Advantages	Notes
l machines Homag combined with flush-cutting unit No. 1-056-11-0621	l 6 degree profile run-out l cutting material: HW l HL Board 06 for wood-based panels, plastics and hard woods		

R	B	H	S	\emptyset d	PU	Ident-No.
1,3	20	11.5	2.0	5,0	10	180024 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

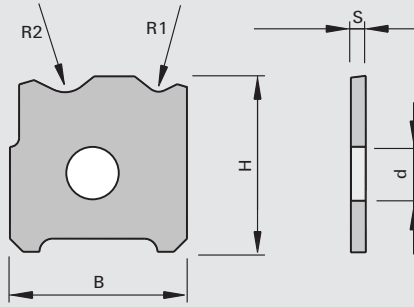
151586

Multi Scrapper Knives HW - Homag (Brandt)

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag (Brandt)
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting material: HW
- HL Board 06 for wood-based materials, plastic and hard wood

Advantages

Notes

- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
1.0	2.0	13,5	13.38	2.0	4,0	2	186451	186450
1.3	2.0	13,5	13.38	2.0	4,0	6	186457 s	186456 s
1.3	3.0	13,5	13.38	2.0	4,0	2	186453	186452
1.5	2.0	13,5	13.38	2.0	4,0	6	186455 s	186454 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		

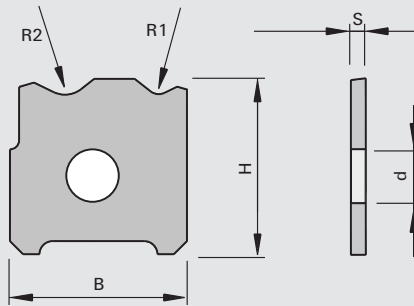
151786

Multi Scrapper Knives HW - to prevent material fracturing for high gloss finish on PE/PVC/ABS - Homag (Brandt)

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

- edge banding machines Homag (Brandt)
- for use in scraper holders
- for scraping of standard edge bandings such as PP / PVC / ABS

Design

- 2 different radius combinations in one scraper
- Cutting edge with chamfer to prevent material fracturing
- Cutting material: HW
- HL Board 06 for wood-based materials, plastic and hard wood

Advantages

- no material fracturing
- avoids rework
- for high gloss finish

Notes

- Sense of rotation right is mounted at the top
- Sense of rotation left is mounted at the bottom

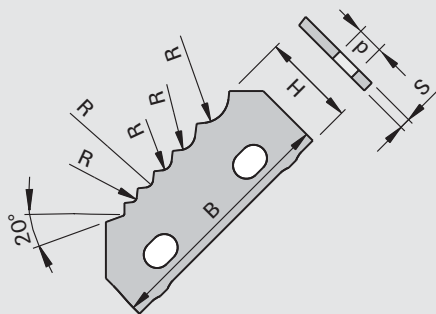
R1	R2	B	H	S	Ø d	PU	Ident-No. [L]	Ident-No. [R]
1.0	2.0	13,5	13.38	2.0	4,0	10	186459 s	186458 s
1.3	2.0	13,5	13.38	2.0	4,0	10	186465 s	186464 s
1.3	3.0	13,5	13.38	2.0	4,0	10	186461 s	186460 s
1.5	2.0	13,5	13.38	2.0	4,0	10	186463 s	186462 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]		

15 1586

Multi Scrapper Knives HW

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

l machines Homag with scraping unit Type MN 20

Design

l cutting material: HW
l HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

l Ident-No. [L] can be applied on the left lower or the right upper side
l Ident-No. [R] can be applied on the left upper or the right lower side

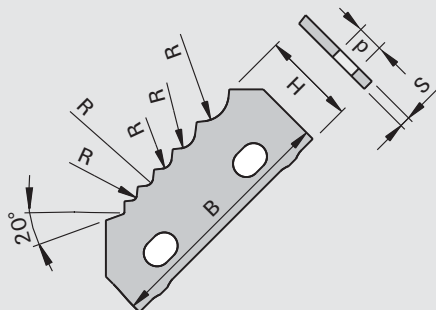
R	B	H	S	Ø d		PU	Ident-No. [L]	Ident-No. [R]
20°; 1; 1,5; 2; 3; 5	45,8	17,98	2,0	5,0	Profile: 6-fold	1	180755	180754
45°; 20°; 1; 1,3; 1,5; 2; 3	45,8	17,23	2,0	5,0	Profile: 7-fold	1	186681	186680
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

15 1786

Multi Scrapper Turnover Knives HW - to prevent material fracturing for high gloss finish on PP/PVC/ABS

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

l machines Homag with scraping unit Type MN 20

Design

l cutting edge with chamfer to prevent material fracturing
l cutting material: HW
l HL Board 06 for wood-based panels, plastics and hard woods

Advantages

l no material fracturing also in the case of PP-edges
l no additional work steps needed
l for high gloss finish

Notes

l Ident-No. [L] can be applied on the left lower or the right upper side
l Ident-No. [R] can be applied on the left upper or the right lower side

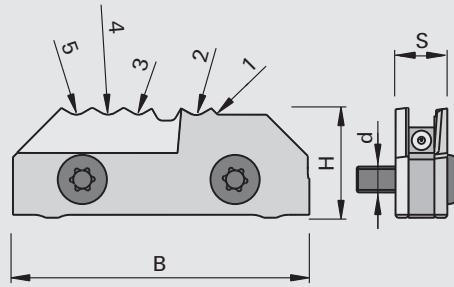
R	B	H	S	Ø d		PU	Ident-No. [L]	Ident-No. [R]
1; 1,5; 2; 3; 5	45,8	17,98	2,0	5,0	Profile: 6-fold	1	181239	181240
1; 1,5; 2; 2,5; 3	45,8	17,02	2,0	5,0	Profile: 6-fold	1	184670	184669
45°; 20°; 1; 1,3; 1,5; 2; 3	45,8	17,23	2,0	5,0	Profile: 7-fold	1	186683	186682
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

151786

TwinBlade Scaper Turnover Knives HW - to prevent material fracturing - Homag

Product

Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

machines Homag with scraping unit Type PN 21

Design

- | cutting edge with chamfer to prevent material fracturing
- | cutting material: HW
- | HL Board O6 for wood-based panels, plastics and hard woods
- | topline (polished face and micro-ground clearance angle)

Advantages

- | no material fracturing
- | no additional work steps needed
- | high-gloss edges in acrylic are possible

Notes

- | Position 1 + 2 TwinBlade
- | Position 3 - 5 high gloss

R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
1; 2; 1; 1,5; 2	45,8	17	8,0	5,0	topline	185322 o	185323 o
45°; 1,6; 1; 1,6; 2	45,8	17	8,0	5,0	topline	185324 o	185325 o
1; 2; 1; 2; 3	45,8	17	8,0	5,0	topline	185326 o	185327 o
1,5; 2; 45°; 1,5; 2	45,8	17	8,0	5,0	topline	185328 o	185329 o
1,5; 2; 1; 1,5; 2	45,8	17	8,0	5,0	topline	185331 o	185330 o
1; 1,5; 1; 1,5; 2	45,8	17	8,0	5,0	topline	185332 o	185333 o
45°; 2; 1,5; 2; 2	45,8	17	8,0	5,0	topline	185334 o	185335 o
1; 2; 20°; 2; 2,5	45,8	17	8,0	5,0	topline	185336 o	185337 o
1,3; 2; 1; 1,3; 2	45,8	17	8,0	5,0	topline	185338 o	185339 o
1; 2; 20°; 1; 2	45,8	17	8,0	5,0	topline	185340 o	185341 o
2; 2; 45°; 20°; 2	45,8	17	8,0	5,0	topline	185342 o	185343 o
1,3; 2; 20°; 2; 3	45,8	17	8,0	5,0	topline	185344 o	185345 o
1,3; 3; 1,3; 2; 3	45,8	17	8,0	5,0	topline	185346 o	185347 o
1; 1,5; 1; 1,2; 2	45,8	17	8,0	5,0	topline	185348 o	185349 o
1,5; 2,2; 1,5; 2; 3	45,8	17	8,0	5,0	topline	185350 o	185351 o
1; 1,5; 20°; 1,2; 2	45,8	17	8,0	5,0	topline	185352 o	185353 o
45°; 1,6; 2; 1,6; 2	45,8	17	8,0	5,0	topline	185354 o	185779 o
[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

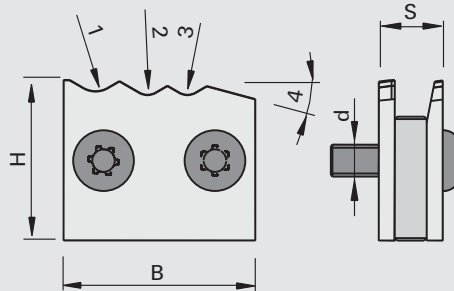
Sealing Rings	1,78x1,02 NBR872	955510	1	185004
Panhead Screws	M4x14 T15	995115	1	185005
	[mm]		[pc.]	

151786

TwinBlade Scraper Turnover Knives HW - to prevent material fracturing - IMA

Product

Drawing



LEUCO
topline

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

I machines IMA

Design

- I cutting edge with chamfer to prevent material fracturing
- I cutting material: HW
- I HL Board 06 for plastics
- I topline (polished face and micro-ground clearance angle)

Advantages

- I no material fracturing
- I no additional work steps needed
- I high-gloss edges in acrylic are possible

Notes

R	B	H	S	Ø d		Ident-No.
3; 2; 2; 30°	24	20.1	8.0	5.0	topline	R 80327522 s
3; 2; 2; 30°	24	20.1	8.0	5.0	topline	L 80327255 s
2; 1,5; 1; 45°	24	20.1	8.0	5.0	topline	R 80327183 s
2; 1,5; 1; 45°	24	20.1	8.0	5.0	topline	L 80327184 s
2; 1,2; 1; 45°	24	20.1	8.0	5.0	topline	R 80328447 s
2; 1,2; 1; 45°	24	20.1	8.0	5.0	topline	L 80328448 s
2; 1; 1; 45°	24	20.1	8.0	5.0	topline	R 80337118 s
2; 1; 1; 45°	24	20.1	8.0	5.0	topline	L 80337119 s
1,3; 1; 1; 15°	24	20.1	8.0	5.0	topline	R 80342343 s
1,3; 1; 1; 15°	24	20.1	8.0	5.0	topline	L 80342344 s
3; 1,5; 1,5; 45°	24	20.1	8.0	5.0	topline	L 80343463 s
3; 2,5; 1,5; 45°	24	20.1	8.0	5.0	topline	R 80350594 s
3; 2,5; 1,5; 45°	24	20.1	8.0	5.0	topline	L 80350593 s
2,5; 1,5; 30°	24	20.1	8.0	5.0	topline	R 80355718 s
2,5; 1,5; 30°	24	20.1	8.0	5.0	topline	L 80355719 s
2; 1,5; 1	24	20.1	8.0	5.0	topline	R 80357038 s
2; 1,5; 1	24	20.1	8.0	5.0	topline	L 80357039 s
2; 2; 1; 1	24	20.1	8.0	5.0	topline	R 80356483 s
2; 2; 1; 1	24	20.1	8.0	5.0	topline	L 80357389 s
3; 2; 1; 15°	24	20.1	8.0	5.0	topline	R 80357926 s
3; 2; 1; 15°	24	20.1	8.0	5.0	topline	L 80357927 s
3; 2; 1	24	20.1	8.0	5.0	topline	R 80360627 s
3; 2; 1	24	20.1	8.0	5.0	topline	L 80360628 s
3; 2; 1,5	24	20.1	8.0	5.0	topline	R 80361148 s
3; 2; 1,5	24	20.1	8.0	5.0	topline	L 80361149 s
0,8; 1,5; 1,2; 1,2	24	20.1	8.0	5.0	topline	R 80365346 s
2,5; 1,5; 1,2; 1,2	24	20.1	8.0	5.0	topline	L 80365348 s
2; 2; 1	24	20.1	8.0	5.0	topline	R 80370785 s
2; 2; 1	24	20.1	8.0	5.0	topline	L 80370786 s
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Panhead Screws

M4x14 T15

995115

1

185005

[mm]

[pc.]

151547

Scraper Knives HW with 1 cutting edge and chamfer

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines IMA units 181.91 and 0.6126 (BAZ) with 30 mm width, unit 08.50 with 55 mm width 	<ul style="list-style-type: none"> cutting material: HW HL Solid 20 for wood-based panels, hard and soft woods 		

Chamfer [°]	B [mm]	H [mm]	S [mm]	Ø d [mm]	PU [pc.]	Ident-No. [L]	Ident-No. [R]
15	30	22.5	3.0	5,8	2	178859	178858
15	55	25	3.0	5,8	2	178861	178860

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws - with Torx	M5x10 T20 [mm]	995125	10 [pc.]	171236

151547

Glue Joint Scraper Turnover Knives (flat scraper) HW - Homag aggregate FA10, FA11, FA12

Product	Drawing	
		Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines Homag aggregate FA10, FA11, FA12 	<ul style="list-style-type: none"> HW-tipped cutting material: HW HL Solid 20 for wood-based panels, hard and soft woods 		

Chamfer [°]	B [mm]	H [mm]	S [mm]	Ø d [mm]	PU [pc.]	Ident-No. [L]	Ident-No. [R]
15	32	55	4.5	5,8	1	178223	178224

150558

Scrapper Turnover Knives HW with 3 cutting edges - Biesse

Product		Drawing			Notes		
					<p>Tungsten Carbide [HW]</p>		
Machine / Application		Design		Advantages		Notes	
I machines Biesse-Polymac		I cutting material: HW I HL Solid 30 for wood-based panels, hard and soft woods					
B	H	S	Ø d	Cornerα	LEUCODUR	PU	Ident-No.
22,9 [mm]	19,8 [mm]	2,5 [mm]	6,4 [mm]	60 [°]	HL Solid 30	2 [pc.]	183685 o


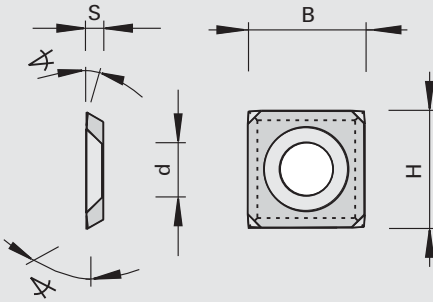

150517

Scrapper Turnover Knives HW with 2 cutting edges - IMA

Product		Drawing			Notes		
					<p>Tungsten Carbide [HW]</p>		
Machine / Application		Design		Advantages		Notes	
I machines IMA		I cutting material: HW I HL Solid 20 for hard and soft woods					
B	H	S	Ø d			PU	Ident-No.
11 [mm]	14,3 [mm]	2,5 [mm]	6,3 [mm]			2 [pc.]	184350

151515

Scrapper Turnover-Knives HW with 4 cutting edges - HOLZ-HER

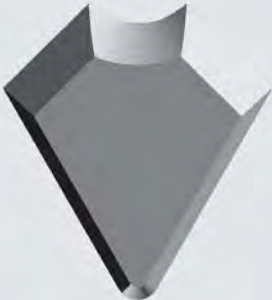
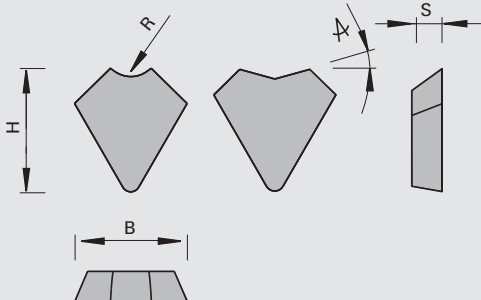

Product	Drawing	
		 Tungsten Carbide [HW]

Machine / Application	Design	Advantages	Notes
edge banding machines HOLZ-HER	cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		

B	H	S	Ø d	Wedge◊	◊	PU	Ident-No.
14	14	2.0	6,4	60	10	10	185 180 s
[mm]	[mm]	[mm]	[mm]	[°]	[°]	[pc.]	

151586

Scrapper Knives HW with 1 cutting edge and radius or chamfer - Ott

Product	Drawing	
		 Tungsten Carbide [HW]

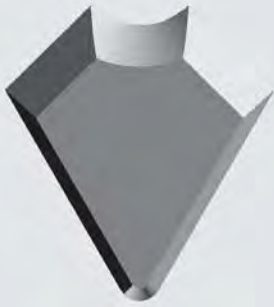
Machine / Application	Design	Advantages	Notes
edge banding machines Ott	10 degree profile run-out cutting material: HW HL Board 05 for plastics		

R	Chamfer◊	B	H	S	PU	Ident-No.
1,0		12,29	13.49	3.3	2	185019
2,0		12,29	13.49	3.3	2	185020
3,0		12,29	13.49	3.3	6	185021 s
4,0		12,31	12.69	3.3	6	185022 s
5,0		12,31	12.4	3.3	6	185023 s
	30	12,83	12.86	3.3	2	185024 #
[mm]	[°]	[mm]	[mm]	[mm]	[pc.]	

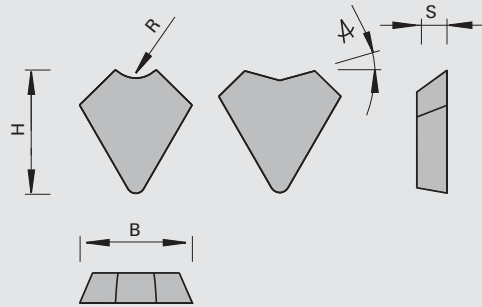
151786

Scrapper Knives HW with 1 cutting edge and radius or chamfer - polished, Ott

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

edge banding machines Ott

Design

10 degree profile run-out
cutting material: HW
HL Board 05 for plastics

Advantages

Less material fracturing
Better chip evacuation

Notes

R	Chamfer	B	H	S	PU	Ident-No.
1,0		12,29	13.49	3.3	6	186189 &
2,0		12,29	13.49	3.3	6	186190 &
3,0		12,29	13.49	3.3	6	186191 s
4,0		12,31	12.69	3.3	6	186192 s
5,0		12,31	12.4	3.3	6	186193 s
	30	12,83	12.86	3.3	6	186194 s
[mm]	[°]	[mm]	[mm]	[mm]	[pc.]	

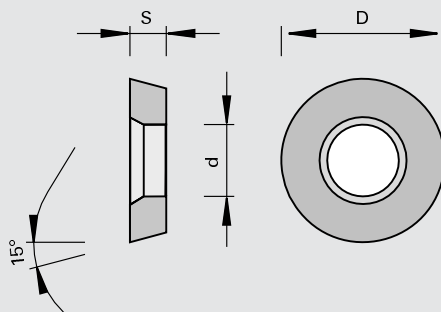
150503

Cup Knives HW

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- for use in side-and-face cutterheads

Design

- cutting material: HW
- HL Board 03 for wood-based panels and plastics

Advantages

- extremely long edge lives

Notes

- packing unit: 10 pieces

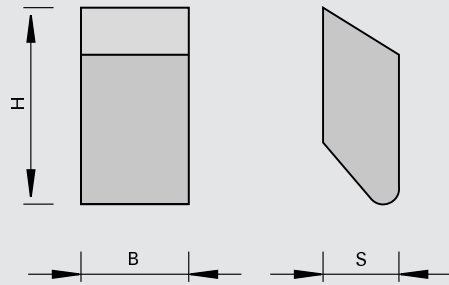
$\varnothing D$	S	$\varnothing d$	Ident-No.
11	4.0	5,0	173396
[mm]	[mm]	[mm]	

153301

Saw Teeth HW for Circular Saw Blades - with solder coating

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

Design

- | Solder-coated
- | Cutting material: HW
- | HL Board 06 for wood-based panels, MDF, plastics, particle boards, and exotic wood
- | HL Solid 15 for wood-based panels and hard wood
- | HL Solid 20 for hard wood and soft wood

Advantages

- | easy soldering during tooth installation thanks to solder coating

Notes

- | packing unit: 500 pieces

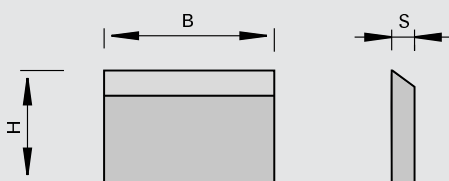
B	H	S	LEUCODUR	Ident-No.
2,7	7.1	2.0	HL Board 06	177493 s
2,8	8.0	2.3	HL Solid 15	177500 s
3,6	8.0	2.3	HL Board 06	177494
4,2	10.5	3.5	HL Solid 15	177501
4,3	10.5	3.0	HL Board 06	177496
4,5	8.0	2.3	HL Board 06	177495
5,0	10.5	3.0	HL Board 06	177497
5,0	10.5	3.5	HL Solid 15	80318077 s
5,4	10.5	3.0	HL Board 06	177498
5,6	10.5	4.0	HL Solid 20	80369454 s
5,8	10.5	3.5	HL Solid 25	80325122 s
6,0	10.5	3.5	HL Solid 15	80304506 s
6,0	10.5	4.0	HL Solid 15	80352231 s
6,0	12.5	4.0	HL Solid 15	80225542 s
6,0	12.5	4.0	HL Solid 15	177586
6,0	12.5	4.0	HL Solid 25	80356362 s
6,0	13	4.0	HL Solid 15	80344985 s
6,5	10.5	3.5	HL Solid 15	80357275 s
6,5	12.5	3.0	HL Solid 15	80373746 s
6,5	13	4.0	HL Solid 15	80344986 s
6,8	12.5	4.0	HL Board 06	177499
7,5	10.5	3.5	HL Solid 25	80325124 s
7,5	12.5	3.0	HL Solid 15	80373745 s
7,5	12.5	4.0	HL Solid 15	80282311 s
7,5	13	4.0	HL Solid 15	80363992 s
[mm]	[mm]	[mm]		

332121

Planing Knives HS

Product

Drawing



High Speed Steel [HS]

Machine / Application

| for use in planing cutterheads

Design

| cutting material: high speed steel (HS 18%) for soft woods
| wedge angle 40°

Advantages

Notes


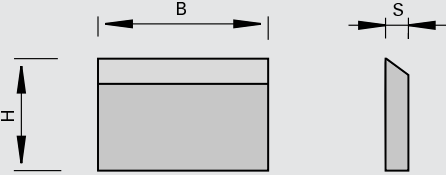
| from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
60	30	3.0	2	160593
80	30	3.0	2	160594
100	30	3.0	2	055647
110	30	3.0	2	160595 s
120	30	3.0	2	160596
130	30	3.0	2	006139
150	30	3.0	2	160597
170	30	3.0	2	160598
180	30	3.0	2	160599
210	30	3.0	2	160600
230	30	3.0	2	160601
260	30	3.0	2	006485
310	30	3.0	2	160602
310	35	3.0	2	165310
320	30	3.0	2	160603
320	35	3.0	2	165311 s
330	30	3.0	2	160604 s
330	35	3.0	2	165312
360	30	3.0	2	160605 s
360	35	3.0	2	165313 s
400	30	3.0	2	165307
400	35	3.0	2	165314 s
410	30	3.0	2	006486
410	35	3.0	2	006487
450	30	3.0	2	160606 s
450	35	3.0	2	165315 s
460	30	3.0	2	160607 s
460	35	3.0	2	165316 s
500	30	3.0	2	165308
500	35	3.0	2	165317
510	30	3.0	2	006488
510	35	3.0	2	006489
600	30	3.0	2	165309 s
600	35	3.0	2	165318 s
610	30	3.0	2	006490
610	35	3.0	2	006491
630	30	3.0	2	160608
630	35	3.0	2	165319
635	35	3.0	2	165320 s
640	30	3.0	2	160609
640	35	3.0	2	165321
700	35	3.0	2	165322 s
[mm]	[mm]	[mm]	[pc.]	

B	H	S	PU	Ident-No.
710	30	3.0	2	160610 s
710	35	3.0	2	165323 s
740	35	3.0	2	165324 s
810	30	3.0	2	160612
810	35	3.0	2	165325
840	30	3.0	2	160613 s
1050	25	3.0	2	185843 s
1050	30	3.0	2	176331
1050	35	3.0	2	176332
[mm]	[mm]	[mm]	[pc.]	

332121

Planing knife HS for hydro and jointing

Product	Drawing	
		
		High Speed Steel [HS]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> for use in hydro planing cutterheads 	<ul style="list-style-type: none"> cutting material: HS for soft woods wedge angle 30° for jointing topcoat coating 	<ul style="list-style-type: none"> high run-out accuracy due to grinding the knives in the hydro planing cutterhead with following jointing process in the machine 	<ul style="list-style-type: none"> from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
130	30	3.0	2	182759 o
150	30	3.0	2	182760 o
170	30	3.0	2	182761 o
180	30	3.0	2	182762 o
190	30	3.0	2	182763 o
210	30	3.0	2	182764 o
230	30	3.0	2	182765 o
240	30	3.0	2	182766 o
270	30	3.0	2	182767 o
310	30	3.0	2	182768 o
[mm]	[mm]	[mm]	[pc.]	

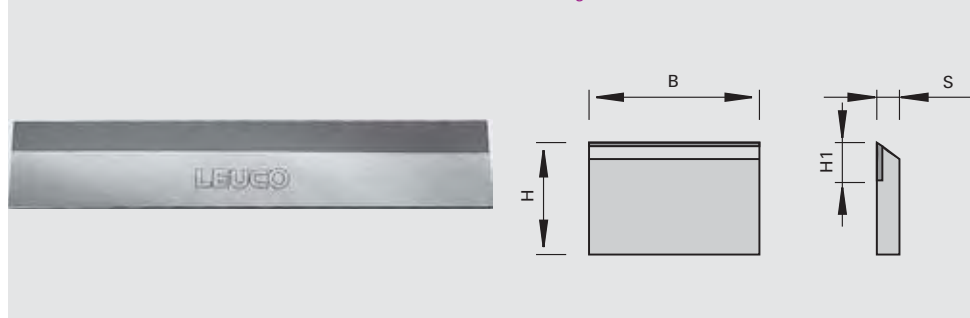
B	H	S		PU	Ident-No.
130	30	3.0	topcoat	10	186007 s
150	30	3.0	topcoat	10	186008 s
170	30	3.0	topcoat	10	186009 s
180	30	3.0	topcoat	10	186010 s
190	30	3.0	topcoat	10	186011 s
210	30	3.0	topcoat	10	186012 s
230	30	3.0	topcoat	10	186013 s
240	30	3.0	topcoat	10	186014 s
270	30	3.0	topcoat	10	186015 s
310	30	3.0	topcoat	10	186016 s
[mm]	[mm]	[mm]		[pc.]	

132121

Planing Knives HW

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in planing cutterheads

Design

| cutting material: HW-tipped for hard woods

Advantages

Notes

| from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	H1	PU	Ident-No.
60	30	3.0	11	2	160586
80	30	3.0	11	2	006204
100	30	3.0	11	2	006205
110	30	3.0	11	2	165329 o
120	30	3.0	11	2	006206 o
130	30	3.0	11	2	006207
150	30	3.0	11	2	006208
170	30	3.0	11	2	006209
180	30	3.0	11	2	055649
210	30	3.0	11	2	006210 o
230	30	3.0	11	2	160588
240	30	3.0	11	2	182641
260	30	3.0	11	2	160589 o
310	30	3.0	11	2	055648
310	35	3.0	11	2	165338 o
320	30	3.0	11	2	165330 o
320	35	3.0	11	2	165339 o
330	30	3.0	11	2	165331 o
330	35	3.0	11	2	165340 o
360	30	3.0	11	2	165332 o
360	35	3.0	11	2	165341 o
400	35	3.0	11	2	165342 o
410	30	3.0	11	2	006211
410	35	3.0	11	2	165343 o
450	30	3.0	11	2	165333 o
450	35	3.0	11	2	165344 o
460	30	3.0	11	2	165334 o
460	35	3.0	11	2	165345 o
500	35	3.0	11	2	165346 o
510	30	3.0	11	2	006212
510	35	3.0	11	2	165347 o
600	35	3.0	11	2	165348 o
610	30	3.0	11	2	006704 o
610	35	3.0	11	2	165349 o
630	30	3.0	11	2	165335 o
630	35	3.0	11	2	165350 o
635	35	3.0	11	2	165351 o
640	30	3.0	11	2	165336 o
640	35	3.0	11	2	165352 o
700	35	3.0	11	2	165353 o
710	30	3.0	11	2	160590 o
710	35	3.0	11	2	165354 o
[mm]	[mm]	[mm]	[mm]	[pc.]	

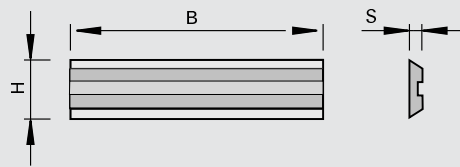
B	H	S	H1	PU	Ident-No.
740	30	3.0	11	2	165337 o
740	35	3.0	11	2	165355 o
810	30	3.0	11	2	160592
810	35	3.0	11	2	165356 o
[mm]	[mm]	[mm]	[mm]		[pc.]

332121

Turnover Knives HS with 2 cutting edges - Weinig

Product

Drawing



High Speed Steel [HS]

Machine / Application

I for use in Weinig planing cutterheads Centrolock for planing of soft woods

Design

I cutting material: high speed steel (HS 18%) for soft woods

Advantages

I high planing quality and long edge lives

Notes

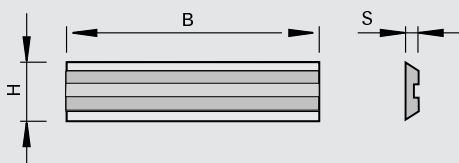
B	H	S	PU	Ident-No.
20	16	3.0	2	184334 o
60	16	3.0	2	184335 o
80	16	3.0	2	184336 o
100	16	3.0	2	184337 o
130	16	3.0	2	184338
150	16	3.0	2	184339 o
170	16	3.0	2	184340
180	16	3.0	2	184341 o
190	16	3.0	2	184342 o
210	16	3.0	2	184343 o
230	16	3.0	2	184344 o
240	16	3.0	2	184345
260	16	3.0	2	184346 o
270	16	3.0	2	184347 o
285	16	3.0	2	184331 o
310	16	3.0	2	184348 o
460	16	3.0	2	184349 o
[mm]	[mm]	[mm]		[pc.]

150517

Turnover Knives HW with 2 cutting edges - Weinig

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in Weinig planing cutterheads Centrolock for planing of glued soft woods, hard woods and MDF

Design

cutting material: HW
HL Solid 20 for hard and soft woods

Advantages

high planing quality and long edge lives

Notes

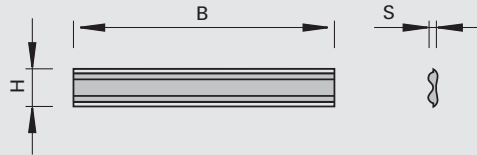
B	H	S	PU	Ident-No.
20	16	3.0	2	181593 o
60	16	3.0	2	181594 o
80	16	3.0	2	181595 o
100	16	3.0	2	181596 o
130	16	3.0	2	181597
150	16	3.0	2	181598 o
170	16	3.0	2	181599
180	16	3.0	2	181600 o
190	16	3.0	2	181601 o
210	16	3.0	2	181602 o
230	16	3.0	2	181603 o
240	16	3.0	2	181604
260	16	3.0	2	181605 o
270	16	3.0	2	181606 o
285	16	3.0	2	186575 o
310	16	3.0	2	181607 o
460	16	3.0	2	181608 o
[mm]	[mm]	[mm]		[pc.]

332751

Turnover Knives HS with 2 cutting edges - Tersa

Product

Drawing



High Speed Steel [HS]

Machine / Application

I for use in Tersa planing cutterheads

Design

I cutting material: HS for soft woods

Advantages

Notes

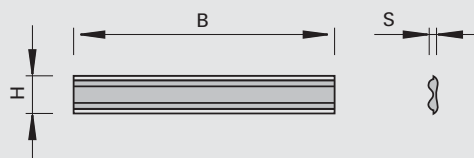
B	H	S	PU	Ident-No.
60	10	2.3	2	175305 o
80	10	2.3	2	175307 o
90	10	2.3	2	175308 o
100	10	2.3	2	175309 o
110	10	2.3	2	175310 o
120	10	2.3	2	175311 o
130	10	2.3	2	175312 o
140	10	2.3	2	175313 o
150	10	2.3	2	175314 o
160	10	2.3	2	175315 o
170	10	2.3	2	175316 o
180	10	2.3	2	175317 o
185	10	2.3	2	175318 o
190	10	2.3	2	175319 o
200	10	2.3	2	175320 o
210	10	2.3	2	175321 o
220	10	2.3	2	175322 o
230	10	2.3	2	175323 o
240	10	2.3	2	175324 o
250	10	2.3	2	175325 o
260	10	2.3	2	175326 o
265	10	2.3	2	175327 o
270	10	2.3	2	175328 o
280	10	2.3	2	175329 o
300	10	2.3	2	175331 o
310	10	2.3	2	175332
320	10	2.3	2	175334 o
330	10	2.3	2	175335 o
350	10	2.3	2	175337 o
360	10	2.3	2	175338 o
400	10	2.3	2	175342 o
410	10	2.3	2	175343
420	10	2.3	2	175344 o
430	10	2.3	2	175345 o
450	10	2.3	2	175347 o
500	10	2.3	2	175352 o
510	10	2.3	2	175353
520	10	2.3	2	175354
530	10	2.3	2	175355 o
540	10	2.3	2	175356 o
610	10	2.3	2	175363 o
630	10	2.3	2	175365
635	10	2.3	2	175366 o
640	10	2.3	2	175368
650	10	2.3	2	175369 o
[mm]	[mm]	[mm]		[pc.]

132751

Turnover Knives HW with 2 cutting edges - Tersa

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in Tersa planing
cutterheads

Design

| cutting material: HW for hard
and exotic woods

Advantages

| optimal precision as manu-
factured from one piece up to
B=650 mm

Notes

B	H	S	PU	Ident-No.
60	10	2.3	2	175205 o
70	10	2.3	2	175206 o
80	10	2.3	2	175207 o
90	10	2.3	2	175208 o
100	10	2.3	2	175209 o
110	10	2.3	2	175210 o
120	10	2.3	2	175211 o
130	10	2.3	2	175212 o
140	10	2.3	2	175213 o
150	10	2.3	2	175214 o
160	10	2.3	2	175215 o
170	10	2.3	2	175216 o
180	10	2.3	2	175217 o
185	10	2.3	2	175218 o
190	10	2.3	2	175219 o
200	10	2.3	2	175220 o
210	10	2.3	2	175221 o
220	10	2.3	2	175222 o
230	10	2.3	2	175223 o
240	10	2.3	2	175224 o
250	10	2.3	2	175225 o
260	10	2.3	2	175226 o
265	10	2.3	2	175227 o
270	10	2.3	2	175228 o
280	10	2.3	2	175229 o
290	10	2.3	2	175230 o
300	10	2.3	2	175231 o
310	10	2.3	2	175232 o
315	10	2.3	2	175233 o
320	10	2.3	2	175234 o
330	10	2.3	2	175235 o
340	10	2.3	2	175236 o
350	10	2.3	2	175237 o
360	10	2.3	2	175238 o
370	10	2.3	2	175239 o
380	10	2.3	2	175240 o
390	10	2.3	2	175241 o
400	10	2.3	2	175242 o
410	10	2.3	2	175243 o
420	10	2.3	2	175244 o
430	10	2.3	2	175245 o
440	10	2.3	2	175246 o
450	10	2.3	2	175247 o
460	10	2.3	2	175248 o
[mm]	[mm]	[mm]		[pc.]

B	H	S	PU	Ident-No.
470	10	2.3	2	175249 o
480	10	2.3	2	175250 o
490	10	2.3	2	175251 o
500	10	2.3	2	175252 o
510	10	2.3	2	175253
520	10	2.3	2	175254 o
530	10	2.3	2	175255 o
540	10	2.3	2	175256 o
550	10	2.3	2	175257 o
560	10	2.3	2	175258 o
570	10	2.3	2	175259 o
580	10	2.3	2	175260 o
590	10	2.3	2	175261 o
600	10	2.3	2	175262 o
610	10	2.3	2	175263 o
620	10	2.3	2	175264 o
630	10	2.3	2	175265 o
635	10	2.3	2	175266 o
640	10	2.3	2	175268 o
650	10	2.3	2	175269 o
[mm]	[mm]	[mm]	[pc.]	

332121

Turnover Knives HS with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product	Drawing	
		High Speed Steel [HS]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of soft woods 	<ul style="list-style-type: none"> cutting material: HS for soft woods constant diameter 	<ul style="list-style-type: none"> high planing quality and long edge lives 	

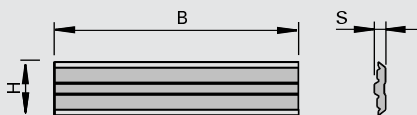
B	H	S	PU	Ident-No.
80	12	2.7	4	182769 o
100	12	2.7	4	182770 o
130	12	2.7	4	182771 o
150	12	2.7	4	182772 o
170	12	2.7	4	182773 o
180	12	2.7	4	182774 o
190	12	2.7	4	182775 o
210	12	2.7	4	182776 o
230	12	2.7	4	182777 o
240	12	2.7	4	182778 o
310	12	2.7	4	182779 o
410	12	2.7	4	182780 o
520	12	2.7	4	182781 o
510	12	2.7	4	182782 o
640	12	2.7	4	182783 o
[mm]	[mm]	[mm]	[pc.]	

150517

Turnover Knives HW with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of hard woods and MDF

Design

cutting material: HW
HL Solid 20 for hard and exotic woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

a cutting length of more than 630 mm is reached by means of several knives

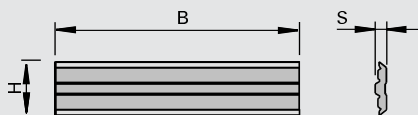
B	H	S	PU	Ident-No.
100	12	2.7	2	182784 o
130	12	2.7	2	182785 o
150	12	2.7	2	182786 o
170	12	2.7	2	182787 o
180	12	2.7	2	182788 o
190	12	2.7	2	182789 o
210	12	2.7	2	182790 o
230	12	2.7	2	182791 o
240	12	2.7	2	182792 o
410	12	2.7	2	182793 o
510	12	2.7	2	182794 o
640	12	2.7	2	182795 o
[mm]	[mm]	[mm]	[pc.]	

150613 / 150617

Turnover Knives HW with 2 cutting edges - Versofix

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in planing cutterhead systems Versofix for planing of hard woods and MDF

Design

cutting material: HW
HL Board 03 for wood-based
HL Solid 20 for hard and soft woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

topcoat coating are possible

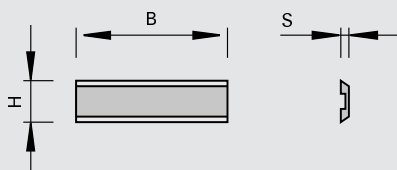
B	H	S	LEUCODUR	PU	Ident-No.
20	5.5	1.1	HL Board 03	2	186244 s
20	5.5	1.1	HL Solid 20	2	186245 s
20	10	1.5	HL Board 03	2	186246 s
20	10	1.5	HL Solid 20	2	186247 s
30	6.5	1.1	HL Board 03	2	186248 s
30	6.5	1.1	HL Solid 20	2	186249 s
30	10	1.5	HL Board 03	2	186250 s
30	10	1.5	HL Solid 20	2	186251 s
50	6.5	1.1	HL Board 03	2	186252 s
50	6.5	1.1	HL Solid 20	2	186253 s
50	10	1.5	HL Board 03	2	186254 s
50	10	1.5	HL Solid 20	2	186256 s
[mm]	[mm]	[mm]		[pc.]	

150535

Mini Turnover Knives HW with 2 cutting edges

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in shank-type cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

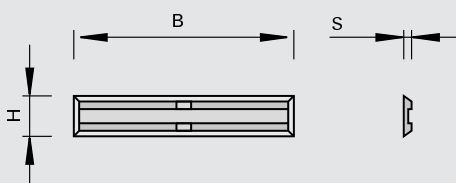
B	H	S	PU	Ident-No.
12	5.5	1.1	10	162670
20	5.5	1.1	10	160623
40	5.5	1.1	10	160674
50	5.5	1.1	10	163572
[mm]	[mm]	[mm]	[pc.]	

150535

Mini Turnover Knives HW with 2 cutting edges, end sharpened

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

| for use in shank-type cutters

Design

| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

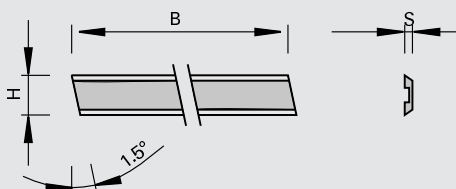
B	H	S	PU	Ident-No.
12	5.5	1.1	10	168696
20	4.1	1.1	10	173480
20	5.5	1.1	10	173481
25	5.5	1.1	10	173793
30	5.5	1.1	10	173482
50	5.5	1.1	10	173483
[mm]	[mm]	[mm]	[pc.]	

150535

Mini Turnover Knives HW with 2 cutting edges, end bevel

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

| CNC machining centers
| for use in shank-type cutters

Design

| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods


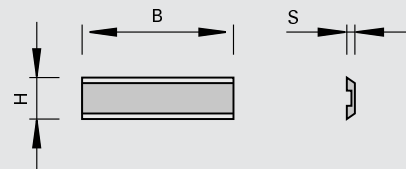
Advantages

Notes

B	H	S	PU	Ident-No.
39,8	5.5	1.1	10	163211 o
[mm]	[mm]	[mm]	[pc.]	

332121

Mini Turnover Knives HW with 2 cutting edges - for planing cutterheads with centrifugal clamping

Product	Drawing	
		High Speed Steel [HS]

Machine / Application	Design	Advantages	Notes
for use in planing cutterheads with centrifugal clamping	cutting material: HS-TRI or HW		

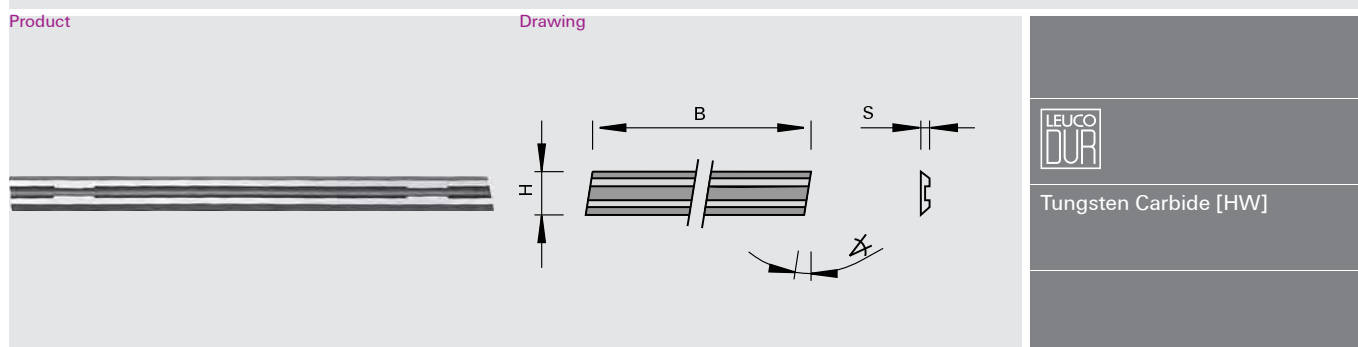
Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	60	HS-TRI	332121	2	70469707 o
	80	HS-TRI	332121	2	70469708 o
	100	HS-TRI	332121	2	70469710 o
	120	HS-TRI	332121	2	70469712 o
	130	HS-TRI	332121	2	70469713 o
	136	HS-TRI	332121	2	70469736 o
	140	HS-TRI	332121	2	70469714 o
	150	HS-TRI	332121	2	70469715 o
	160	HS-TRI	332121	2	70469716 o
	180	HS-TRI	332121	2	70469718 o
	186	HS-TRI	332121	2	70469786 o
	190	HS-TRI	332121	2	70469719 o
	200	HS-TRI	332121	2	70469720 o
	210	HS-TRI	332121	2	70469721 o
	220	HS-TRI	332121	2	70469722 o
	230	HS-TRI	332121	2	70469723 o
	240	HS-TRI	332121	2	70469724 o
	260	HS-TRI	332121	2	70469726 o
	300	HS-TRI	332121	2	70469730 o
	310	HS-TRI	332121	2	70469731 o
	400	HS-TRI	332121	2	70469740 o
	410	HS-TRI	332121	2	70469741 o
	430	HS-TRI	332121	2	70469743 o
	500	HS-TRI	332121	2	70469750 o
	510	HS-TRI	332121	2	70469751 o
	610	HS-TRI	332121	2	70469761 o
	630	HS-TRI	332121	2	70469763 o
	640	HS-TRI	332121	2	70469764 o
	710	HS-TRI	332121	2	70469771 o
	1350	HS-TRI	332121	2	70469798 o
	[mm]				[pc.]

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	80	HW	132121	2	70469908 o
	100	HW	132121	2	70469910 o
	120	HW	132121	2	70469912 o
	130	HW	132121	2	70469953 o
	140	HW	132121	2	70469914 o
	150	HW	132121	2	70469915 o
	160	HW	132121	2	70469916 o
	180	HW	132121	2	70469918 o
	200	HW	132121	2	70469920 o
	210	HW	132121	2	70469921 o
	220	HW	132121	2	70469922 o
	[mm]				[pc.]

Turnover Knives	B	Cutting material	Class-No.	PU	Ident-No.
	230	HW	132121	2	70469923 o
	240	HW	132121	2	70469924 o
	250	HW	132121	2	70469925 o
	260	HW	132121	2	70469926 o
	300	HW	132121	2	70469930 o
	610	HW	132121	2	70469999 o
	[mm]			[pc.]	

150549

Portable Planer Turnover Knives HW with 2 cutting edges and edge bevel



Machine / Application	Design	Advantages	Notes
portable planers	cutting material: HW HL Solid 40 for hard and soft woods		Ident-No. 166381 can only be used in the original ELU clamping element packing unit: 10 pieces

B	H	S	Clearance \sphericalangle 1		PU	Ident-No.
75,5	5.5	1.1	1.5	AEG HTH 75, Bosch 0590, P400, 1590, 1591, Festo REP 75, Haffner FH 222, HOLZ-HER 2223, 2286, 2320, Kress Jet Star 6701, Mafell HU 75, Metabo 6375, Scheer MH 80, MH 75/3, Skil 98 H	10	162439
75,7	5.5	1.2	8	Black&Decker DN 750	10	166079 o
80,5	5.9	1.2	8	ELU MFF 80	10	166381
82	5.5	1.1	3	AEG, Fein, Haffner, Hitachi, Mafell, Makita, Metabo, Bosch, Black&Decker DN712	10	165617
102	5.5	1.1	3	AEG EH 102, HB 750	10	419671 o
[mm]	[mm]	[mm]	[°]		[pc.]	

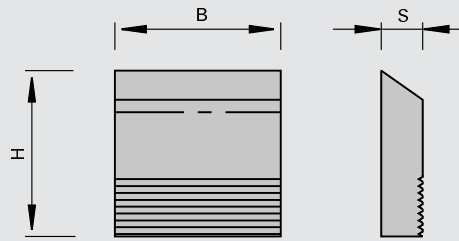
332511

Back-serrated HS Planing Knives

Product



Drawing



High Speed Steel [HS]

Machine / Application

also for Weing Powermat machines, RPM up to 12,000 min-1
for use in cutterheads with serration

Design

cutting material: HS for soft woods

Advantages

Notes

from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
100	38	5.0	2	182096 s
130	38	5.0	2	182097 s
170	38	5.0	2	182098 s
190	38	5.0	2	182099 s
230	38	5.0	2	182100 s
240	38	5.0	2	182101 s
[mm]	[mm]	[mm]	[pc.]	

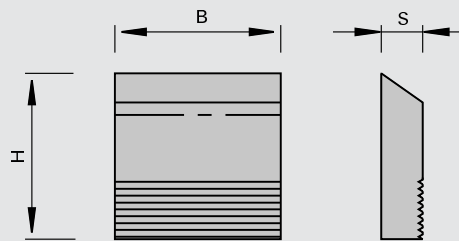
332511

Back-serrated HS Planing Knives - Quicklock

Product



Drawing



High Speed Steel [HS]

Machine / Application

for use in hydro planing cutterheads Quicklock with serration

Design

cutting material: HS for soft woods

Advantages

Notes

from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
100	30	4.0	2	183354 s
130	30	4.0	2	183355 s
150	30	4.0	2	183356 s
180	30	4.0	2	183357 s
210	30	4.0	2	183358 s
230	30	4.0	2	183359 s
240	30	4.0	2	183360 s
270	30	4.0	2	183361 s
310	30	4.0	2	183362 s
320	30	4.0	2	183363 s
[mm]	[mm]	[mm]	[pc.]	

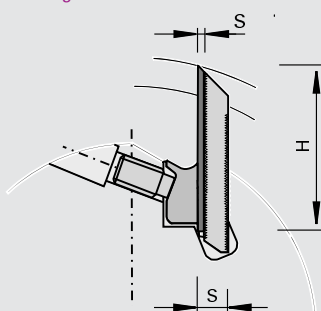
B	H	S	PU	Ident-No.
100	35	4.0	2	183364 s
130	35	4.0	2	183365 s
150	35	4.0	2	183366 s
180	35	4.0	2	183367 s
210	35	4.0	2	183368 s
230	35	4.0	2	183369 s
240	35	4.0	2	183370 s
270	35	4.0	2	183371 s
310	35	4.0	2	183372 s
320	35	4.0	2	183373 s
[mm]	[mm]	[mm]	[pc.]	

152548

SetProfiler set - planing

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

l molders
l for use in profile cutterheads with serration

Design

l n max = 12,000 min-1
l cutting material: HW
l HL Solid 30 topline for hard and soft woods
l HW topcoat
l topline (polished face)

Advantages

l significantly improved cutting edges
l excellent cutting quality
l compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
l adjustable knives by means of serration between knife and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

l from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
310	38	10	2	181974 o
[mm]	[mm]	[mm]	[pc.]	

Blanks	B	H	S	Class-No.	PU	Ident-No.
HW Blanks	310	38	3.2	152548	2	181975 o
HW topcoat Blanks	250	38	3.2	152548	2	181976 o
	[mm]	[mm]	[mm]		[pc.]	





Support plates	B	Suitable for blank height	Class-No.	PU	Ident-No.
	250	38	925400	2	181977 o
	310	38	925400	2	181978 o
	[mm]	[mm]		[pc.]	

332321

Knives - Linck

Product	Drawing	
		High Speed Steel [HS]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> Linck for hogger lines 	<ul style="list-style-type: none"> cutting material: HS for the machining of soft woods 		<ul style="list-style-type: none"> packing unit 10 pieces

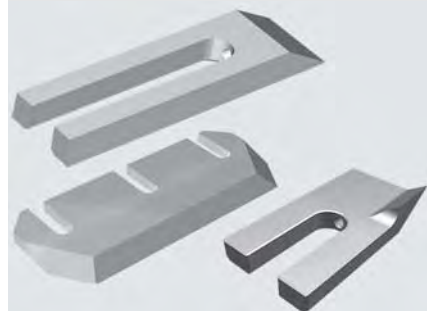
	Dimension	LEUCODUR	Ident-No.
	Chipping knives - Linck 105x41x8 [mm]	HS	185542 #
	Chipping knives - Linck 105x92x12 [mm]	HS	185540
	Chipping knives - Linck 184x108x14 [mm]	HS	185541 #
	Finishing knives - Linck 76x35x20 [mm]	HS	185543 #

332321

Knives - EWD

Product

Drawing



High Speed Steel [HS]

Machine / Application

Design

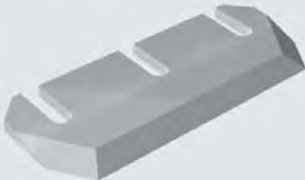


Advantages

Notes

| EWD
| for hogger lines

| cutting material: HS for the machining of soft woods

| packing unit 10 pieces

		Dimension		LEUCODUR	Ident-No.
	Rotor knives - EWD	289x115x12	3 openings 2 threads M6 on the back side chamfer 29° side bevel 34°	HS	185544
		[mm]			
	Chipping knives - EWD	153x40x14,5	1 openings 1 threads M6	HS	186494 s
		[mm]			
	Chipper Knives - EWD	15,9/9x75x39	1 openings 1 threads M5	HS	R 186514 s
		Chipper Knives - EWD			
		[mm]			

332321

Knives - Veisto HewSaw

Product

Drawing



LEUCODUR

High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

Veisto HewSaw
for hogger lines

cutting material: HS for the
machining of soft woods

packing unit 10 pieces

	Dimension		LEUCODUR	Ident-No.
	Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS R 185882 s
	Knives - Veisto HewSaw	72x53x34/27,9 [mm]	1 threads M12	HS L 185883 s
	Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS R 185884 s
	Knives - Veisto HewSaw	94,5x19,9x74,5/45 [mm]	1 threads M16	HS L 185885 s
	Chipping knives - Veisto HewSaw	82x25x10	1 threads M6 on the back	HS 186449 s
		[mm]		

132321

Peel Knives HW

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

I for hogger lines

Design

I cutting material: HW HL Solid
20 for hard and soft woods

Advantages

Notes

I packing unit 10 pieces



Dimension

LEUCODUR

Ident-No.

Peel Knives

49,5x103x23

2 threads M12

HW

R

185886 s

Peel Knives

49,5x103x23

2 threads M12

HW

L

185887 s

[mm]



Dimension

LEUCODUR

Ident-No.

Peel Knives

90x60x21

2 threads M12

HW

R

185889 s

Peel Knives

105x60x20

2 threads M12

HW

R

185888 s

[mm]

332321

Chip Breakers - EWD

Product



Drawing

LEUCO
DUR

High Speed Steel [HS]

Machine / Application

I EWD systems

Design

Advantages

I optimized chip breaking

Notes

I packing unit 10 pieces



Dimension

LEUCODUR

Ident-No.

Chip Breakers - EWD

274x43x25

HS

R

186470 s

Chip Breakers - EWD

274x43x25

HS

L

186469 s

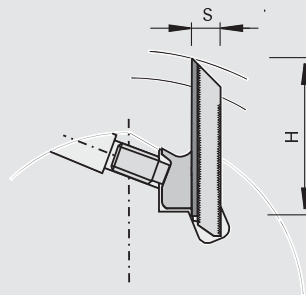
[mm]

152548

SetProfiler set - profiling

Product

Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

- | molders
- | for use in profile cutterheads with serration

Design

- | cutting material: HW
- | HL Solid 30 for hard and soft woods
- | HW topcoat
- | topline (polished face)

Advantages

- | significantly improved cutting edges
- | excellent cutting quality
- | compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
- | high economic efficiency thanks to reduced use of grinding wheels, as knives and support plates are profiled separately whereas only the knives are re-ground
- | adjustable knives by means of serration between knife and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

- | serration 60 degrees and partition 1,6 mm for profiling of solid woods and wood-based panels
- | blank height 50 and 60 mm for RPM up to 12,000 min-2
- | T = profile depth
- | from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	Tmax		PU	Ident-No.
40	50	10	14		2	181637 o
50	50	10	14		2	181638 o
60	50	10	14		2	181639 o
70	50	10	14		2	181640 o
80	50	10	14		2	181641 o
100	50	10	14		2	182182 o
130	50	10	14		2	182183 o
150	50	10	14		2	182184 o
250	50	10	14		2	181642 o
40	60	10	24		2	181643 o
50	60	10	24		2	181644 o
60	60	10	24		2	181645 o
70	60	10	24		2	181646 o
80	60	10	24		2	181647 o
100	60	10	24		2	182322 o
130	60	10	24		2	182323 o
150	60	10	24		2	182324 o
250	60	10	24		2	181648 o
40	70	10	34		2	181649 o
50	70	10	34		2	181650 o
60	70	10	34		2	181651 o
70	70	10	34		2	181652 o
80	70	10	34		2	181653 o
250	70	10	34		2	181654 o
[mm]	[mm]	[mm]	[mm]		[pc.]	

HW Blanks topline

B	H	S	T	Class-No.	PU	Ident-No.
40	50	3.2	14	152548	2	181619
50	50	3.2	14	152548	2	181620 o
60	50	3.2	14	152548	2	181621
70	50	3.2	14	152548	2	181622 o
[mm]	[mm]	[mm]	[mm]		[pc.]	

HW Blanks topline	B	H	S	T	Class-No.	PU	Ident-No.
	80	50	3.2	14	152548	2	181623 o
	100	50	3.2	14	152548	2	182179
	130	50	3.2	14	152548	2	182180
	150	50	3.2	14	152548	2	182181 o
	250	50	3.2	14	152548	2	181624
	40	60	3.2	24	152548	2	181625
	50	60	3.2	24	152548	2	181626 o
	60	60	3.2	24	152548	2	181627
	70	60	3.2	24	152548	2	181628 o
	80	60	3.2	24	152548	2	181629
	100	60	3.2	24	152548	2	182319
	130	60	3.2	24	152548	2	182320 o
	150	60	3.2	24	152548	2	182321 o
	250	60	3.2	24	152548	2	181630
	40	70	3.2	34	152548	2	181631 o
	50	70	3.2	34	152548	2	181632 o
	60	70	3.2	34	152548	2	181633 o
	70	70	3.2	34	152548	2	181634 o
	80	70	3.2	34	152548	2	181635 o
	250	70	3.2	34	152548	2	181636
	[mm]	[mm]	[mm]	[mm]		[pc.]	
HW topcoat Blanks	B	H	S	T	Class-No.	PU	Ident-No.
	40	50	3.2	14	152548	2	181665 o
	50	50	3.2	14	152548	2	181666 o
	60	50	3.2	14	152548	2	181667 o
	70	50	3.2	14	152548	2	181668 o
	80	50	3.2	14	152548	2	181669 o
	100	50	3.2	14	152548	2	182188 o
	130	50	3.2	14	152548	2	182189 o
	150	50	3.2	14	152548	2	182190 o
	250	50	3.2	14	152548	2	181670 o
	40	60	3.2	24	152548	2	181671 o
	50	60	3.2	24	152548	2	181672 o
	60	60	3.2	24	152548	2	181673 o
	70	60	3.2	24	152548	2	181674 o
	80	60	3.2	24	152548	2	181675 o
	100	60	3.2	24	152548	2	182328 o
	130	60	3.2	24	152548	2	182329 o
	150	60	3.2	24	152548	2	182330 o
	250	60	3.2	24	152548	2	181676 o
	[mm]	[mm]	[mm]	[mm]		[pc.]	
Support plates	B	Suitable for blank height			Class-No.	PU	Ident-No.
	40	50			925400	2	181820
	50	50			925400	2	181821 o
	60	50			925400	2	181822
	70	50			925400	2	181823
	80	50			925400	2	181824
	100	50			925400	2	182185
	130	50			925400	2	182186
	150	50			925400	2	182187 o
	250	50			925400	2	181825
	40	60			925400	2	181826
	50	60			925400	2	181827
	60	60			925400	2	181828
	70	60			925400	2	181829
	80	60			925400	2	181830
	100	60			925400	2	182325
	130	60			925400	2	182326 o
	150	60			925400	2	182327 o
	250	60			925400	2	181831
	40	70			925400	2	181832 o
	[mm]	[mm]				[pc.]	

Support plates	B	Suitable for blank height	Class-No.	PU	Ident-No.
	50	70	925400	2	181833 o
	60	70	925400	2	181834 o
	70	70	925400	2	181835 o
	80	70	925400	2	181836 o
	250	70	925400	2	181837
	[mm]	[mm]			[pc.]

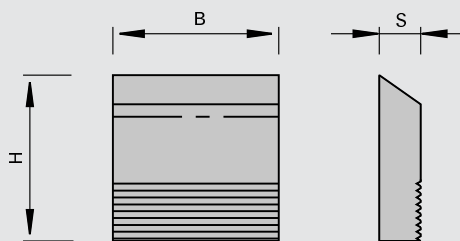
332511

Back-serrated HS blanks for profiling

Product



Drawing



High Speed Steel [HS]

Machine / Application

I for use in profile cutterheads with serration

Design

I cutting material: HS for soft woods

Advantages

Notes

I T = profile depth
I from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	Tmax	PU	Ident-No.
40	50	8.0	12	2	163385
40	60	8.0	20	2	163386
40	70	8.0	30	2	163387
50	50	8.0	12	2	180533 s
50	60	8.0	20	2	180534
60	50	8.0	12	2	163388
60	60	8.0	20	2	163389
60	70	8.0	30	2	163390
80	50	8.0	12	2	163391
80	60	8.0	20	2	163392
80	70	8.0	30	2	163393
100	50	8.0	12	2	163394
100	60	8.0	20	2	163395
100	70	8.0	30	2	163396
130	50	8.0	12	2	163397
130	60	8.0	20	2	163398
130	70	8.0	30	2	163399 s
150	50	8.0	12	2	163400
150	60	8.0	20	2	163401
150	70	8.0	30	2	163402
180	50	8.0	12	2	163403 s
180	60	8.0	20	2	163404 s
180	70	8.0	30	2	163405 s
230	50	8.0	12	2	164495
230	60	8.0	20	2	164496 s
650	50	8.0	12	2	176318
650	60	8.0	20	2	176319
650	70	8.0	30	2	176320
[mm]	[mm]	[mm]	[mm]		[pc.]

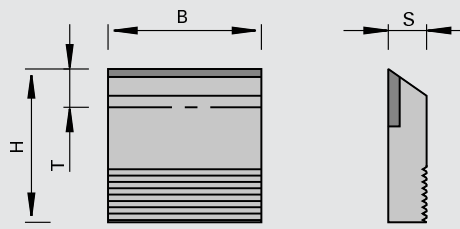
132511

Back-serrated HW blanks for profiling

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in profile cutterheads with serration

Design

HW-tipped for hard and exotic woods
 tipping height 14 mm for blank height 50 mm, tipping height 20 mm for blank height 60 mm

Advantages

Notes

T = profile depth
 from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

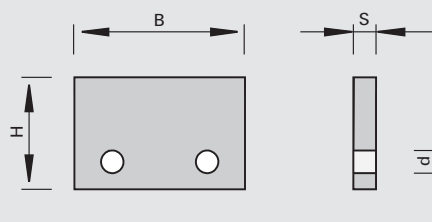
B	H	S	Tmax	PU	Ident-No.
40	50	10	13	2	165357
40	60	10	18	2	165365
60	50	10	13	2	165358
60	60	10	18	2	165366
80	50	10	13	2	165359 o
80	60	10	18	2	165367
100	50	10	13	2	165360
100	60	10	18	2	165368
130	50	10	13	2	165361 o
130	60	10	18	2	165369 o
150	50	10	13	2	165362 o
150	60	10	18	2	165370 o
180	50	10	13	2	165363 o
180	60	10	18	2	165371 o
230	50	10	13	2	165364 o
230	60	10	18	2	165372 o
[mm]	[mm]	[mm]	[mm]	[pc.]	

332521

Blanks HS and Deflector Blanks for profiling

Product

Drawing



High Speed Steel [HS]

Machine / Application

| for use in safety cutterheads

Design

| cutting material: HS for soft woods
| profile depth 15 mm max.

Advantages

Notes

| special steel deflector blanks

B	H	S	Ø d	Tmax	PU	Ident-No.
40	45	4.0	6,0	15	2	186686
50	45	4.0	6,0	15	2	186688
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

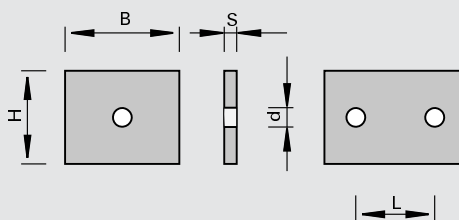
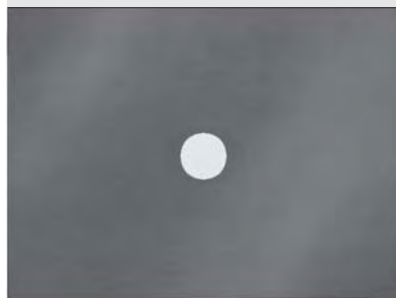
Deflectors for profiling	B	H	S	Ø d	T	Class-No.	PU	Ident-No.
deflector blanks	40	45	4.0	6,0	15	925400	2	186687 o
deflector blanks	50	45	4.0	6,0	15	925400	2	186689 o
	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

152555

Blanks HW - central bore

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
precision ground
| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

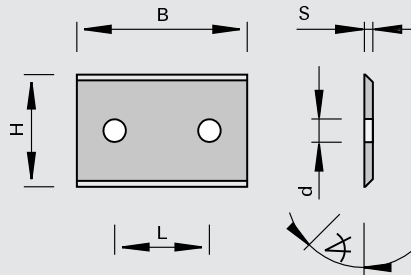
B	H	S	Ø d	L	PU	Ident-No.
24	22	2.0	4,2		10	168821
28	24	2.0	4,2		10	168822 s
32	24	2.0	4,2		10	168823 s
36	28	2.0	4,2		10	168824
40	26	2.0	4,2		10	168825 s
42	32	2.0	4,2	24	10	168826
52	34	2.0	4,2	24	10	168828 s
[mm]	[mm]	[mm]	[mm]	[mm]	[pc.]	

152555

Blanks HW - central bore, ground on both sides

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
precision ground
| cutting material: HW
| HL Board 05 for wood-based
panels, plastics and hard
woods

Advantages

Notes

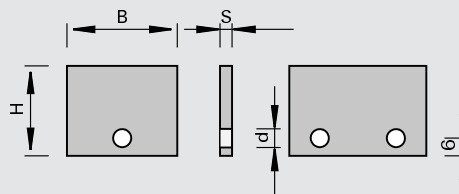
B	H	S	Ø d	L	Wedge	PU	Ident-No.
30	25	2.0	4,2	20	55	10	168871 s
40	30	2.0	4,2	20	55	10	168872 s
50	45	2.0	4,2	34	55	10	168873 s
60	25	2.0	4,2	26	55	10	168836
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		[pc.]

152545

Blanks HW - bore not central

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
precision ground
| cutting material: HW
| HL Board 05 for wood-based
panels, plastics and hard
woods

Advantages

Notes

B	H	S	Ø d	L	PU	Ident-No.
18	18.3	2.0	4,2		10	168829
20	25.3	2.0	4,2		10	168830
24	28.3	2.0	4,2		10	168831
32	22.3	2.0	4,2		10	168832
40	30.3	2.0	4,2		10	168833
50	32.3	2.0	4,2	24	10	168834 s
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]

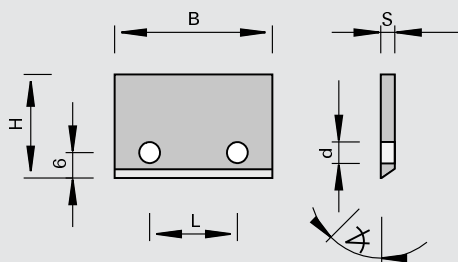
152545

Blanks HW - bore not central, ground seating surface

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
| precision ground
| cutting material: HW
| HL Board 05 for wood-based
panels, plastics and hard
woods

Advantages

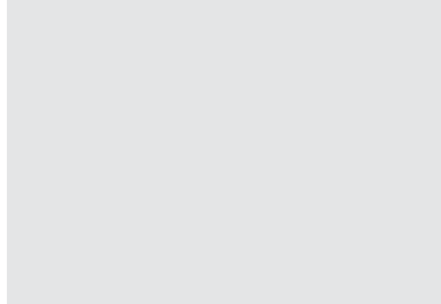
Notes

B	H	S	Ø d	L	Wedge	PU	Ident-No.
40	20.5	2.0	4,2	26	55	10	168838
52	27.5	2.0	4,2	26	55	10	168839
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[pc.]	

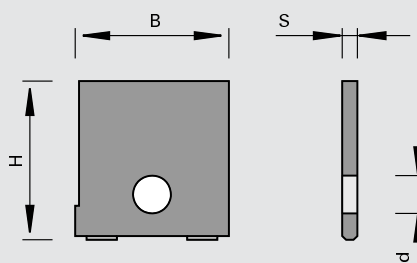
152586 / 152589

3P-Blanks HW (upright format)

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

| for use in LEUCO EcoPro and
special cutterheads

Design

| two-point seating surface and
point-stop
| optionally topline (polished
face)
| cutting material: HW
| HL Board 06 for wood-based
panels, plastics and hard
woods
| HL Solid 60 for soft woods

Advantages

| precise positioning of the
blanks for profiling and of the
single-sided profile knife in the
cutterhead
| topline design: highest cutting
quality and significantly
improved cutting edges

Notes

| profile knife can be profiled
per customer specifications

B	H	S	Ø d	LEUCODUR	PU	Ident-No.
12,5	20.5	2.0	5,0	HL Board 06	10	178509
15,5	20.5	2.0	5,0	HL Board 06	10	178510
15,5	25.5	2.0	5,0	HL Board 06	10	178511
16,4	20.5	2.0	5,0	HL Board 06	10	178512
16,7	25.9	2.0	5,0	HL Board 06	10	178513
18,4	18.9	2.0	5,0	HL Board 06	10	178514
18,4	25.9	2.0	5,0	HL Board 06	10	178515
18,4	36.3	2.0	5,0	HL Board 06	10	178516
20,3	20.5	2.0	5,0	HL Board 06	10	178517
[mm]	[mm]	[mm]	[mm]		[pc.]	

B	H	S	Ø d	LEUCODUR	PU	Ident-No.	
20,3	25.5	2.0	5,0	HL Board 06	10	178518	
20,3	30.4	2.0	5,0	HL Board 06	10	178519	
22,3	25.5	2.0	5,0	HL Board 06	10	178520	
24,3	20.9	2.0	5,0	HL Board 06	10	178521	
24,3	28.4	2.0	5,0	HL Board 06	10	178522	
25,3	25.9	2.0	5,0	HL Board 06	10	178523	
25,3	35.3	2.0	5,0	HL Board 06	10	178524	
28,2	25.5	2.0	5,0	HL Board 06	10	178525	
28,2	35.3	2.0	5,0	HL Board 06	10	178526	
12,5	20.5	2.0	5,0	HL Solid 60	10	179509	
15,5	20.5	2.0	5,0	HL Solid 60	10	179510	
15,5	25.5	2.0	5,0	HL Solid 60	10	179511	
16,4	20.5	2.0	5,0	HL Solid 60	10	179512	
16,7	25.9	2.0	5,0	HL Solid 60	10	179513	
18,4	18.9	2.0	5,0	HL Solid 60	10	179514	
18,4	25.9	2.0	5,0	HL Solid 60	10	179515	
18,4	36.3	2.0	5,0	HL Solid 60	10	179516	
20,3	20.5	2.0	5,0	HL Solid 60	10	179517	
20,3	25.5	2.0	5,0	HL Solid 60	10	179518	
20,3	30.4	2.0	5,0	HL Solid 60	10	179519	
22,3	25.5	2.0	5,0	HL Solid 60	10	179520	
24,3	20.9	2.0	5,0	HL Solid 60	10	179521 s	
24,3	28.4	2.0	5,0	HL Solid 60	10	179522	
25,3	25.9	2.0	5,0	HL Solid 60	10	179523	
25,3	35.3	2.0	5,0	HL Solid 60	10	179524	
28,2	25.5	2.0	5,0	HL Solid 60	10	179525	
28,2	35.3	2.0	5,0	HL Solid 60	10	179526	
[mm]	[mm]	[mm]	[mm]		[pc.]		
B	H	S	Ø d	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
12,5	20.5	2.0	5,0	HL Board 06 topline	10	179547 &	179548
15,5	20.5	2.0	5,0	HL Board 06 topline	10	179549 &	179550 &
15,5	25.5	2.0	5,0	HL Board 06 topline	10	179551 &	179552 &
16,4	20.5	2.0	5,0	HL Board 06 topline	10	179553 &	179554 &
16,7	25.9	2.0	5,0	HL Board 06 topline	10	179555 &	179556 &
18,4	18.9	2.0	5,0	HL Board 06 topline	10	179557 &	179558 &
18,4	25.9	2.0	5,0	HL Board 06 topline	10	179559 &	179560 &
18,4	36.3	2.0	5,0	HL Board 06 topline	10	179561 &	179562 &
20,3	20.5	2.0	5,0	HL Board 06 topline	10	179563 &	179564 &
20,3	25.5	2.0	5,0	HL Board 06 topline	10	179565 &	179566 &
20,3	30.4	2.0	5,0	HL Board 06 topline	10	179567 &	179568 &
22,3	25.5	2.0	5,0	HL Board 06 topline	10	179569 &	179570 &
24,3	20.9	2.0	5,0	HL Board 06 topline	10	179571 &	179572 &
24,3	28.4	2.0	5,0	HL Board 06 topline	10	179573 &	179574 &
25,3	25.9	2.0	5,0	HL Board 06 topline	10	179575	179576
25,3	35.3	2.0	5,0	HL Board 06 topline	10	179577 &	179578 &
28,2	25.5	2.0	5,0	HL Board 06 topline	10	179579	179580
28,2	35.3	2.0	5,0	HL Board 06 topline	10	179581 &	179582 &
12,5	20.5	2.0	5,0	HL Solid 60 topline	10	179621 &	179622 &
15,5	20.5	2.0	5,0	HL Solid 60 topline	10	179623 &	179624 &
15,5	25.5	2.0	5,0	HL Solid 60 topline	10	179625 &	179626 &
16,4	20.5	2.0	5,0	HL Solid 60 topline	10	179627 &	179628 &
16,7	25.9	2.0	5,0	HL Solid 60 topline	10	179629 &	179630 &
18,4	18.9	2.0	5,0	HL Solid 60 topline	10	179631 &	179632 &
18,4	25.9	2.0	5,0	HL Solid 60 topline	10	179633 &	179634 &
18,4	36.3	2.0	5,0	HL Solid 60 topline	10	179635 &	179636 &
20,3	20.5	2.0	5,0	HL Solid 60 topline	10	179637 &	179638 &
20,3	25.5	2.0	5,0	HL Solid 60 topline	10	179639 &	179640 &
20,3	30.4	2.0	5,0	HL Solid 60 topline	10	179641 &	179642 &
22,3	25.5	2.0	5,0	HL Solid 60 topline	10	179643 &	179644 &
24,3	20.9	2.0	5,0	HL Solid 60 topline	10	179645 s	179646 s
24,3	28.4	2.0	5,0	HL Solid 60 topline	10	179647 &	179648 &
25,3	25.9	2.0	5,0	HL Solid 60 topline	10	179649 &	179650 &
[mm]	[mm]	[mm]	[mm]		[pc.]		

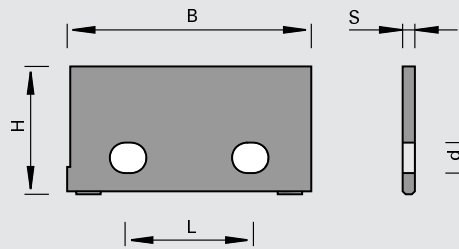
B	H	S	Ø d	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
25,3	35,3	2,0	5,0	HL Solid 60 topline	10	179651 &	179652 &
28,2	25,5	2,0	5,0	HL Solid 60 topline	10	179653 &	179654 &
28,2	35,3	2,0	5,0	HL Solid 60 topline	10	179655 &	179656 &
[mm]	[mm]	[mm]	[mm]				[pc.]

152586 / 152589

3P-Blanks HW (horizontal format)

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for use in LEUCO EcoPro and special cutterheads

Design

- two-point seating surface and point-stop
- optionally topline (polished face)
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods
- HL Solid 60 for soft woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead
- topline design: highest cutting quality and significantly improved cutting edges

Notes

- profile knife can be profiled per customer specifications

B	H	S	Ø d	L	LEUCODUR	PU	Ident-No.
24	20,9	2,0	4,4	10-14	HL Board 06	10	185948
30,2	25,5	2,0	5,0	11,8-13,8	HL Board 06	10	178527
30,2	30,4	2,0	5,0	11,8-13,8	HL Board 06	10	178528
32,2	22,8	2,0	5,0	11,8-13,8	HL Board 06	10	178529
32,2	35,4	2,0	5,0	11,8-13,8	HL Board 06	10	178530
32,8	47,2	2,0	5,0	11,8-13,8	HL Board 06	10	178531
35,2	26	2,0	5,0	11,8-13,8	HL Board 06	10	178532
40,1	20,9	2,0	5,0	21,7-25,5	HL Board 06	10	178533
40,1	30,4	2,0	5,0	21,7-25,5	HL Board 06	10	178534
40,8	36	2,0	5,0	21,7-25,5	HL Board 06	10	178535
42,8	31	2,0	5,0	21,7-25,5	HL Board 06	10	178536
42,8	36	2,0	5,0	21,7-25,5	HL Board 06	10	178537 #
45,8	36	2,0	5,0	21,7-25,5	HL Board 06	10	178538
49,9	20,9	2,0	5,0	21,7-25,5	HL Board 06	10	178539
49,9	33	2,0	5,0	21,7-25,5	HL Board 06	10	178540
49,9	40,2	2,0	5,0	21,7-25,5	HL Board 06	10	178541
60,6	25,8	2,0	5,0	26 - 22	HL Board 06	10	178542
59,8	35,4	2,0	5,0	25,5+43,2	HL Board 06	10	178543
80,6	35,8	2,0	5,0	44	HL Board 06	10	178544
30,2	25,5	2,0	5,0	11,8-13,8	HL Solid 60	10	179527
30,2	30,4	2,0	5,0	11,8-13,8	HL Solid 60	10	179528
32,2	22,8	2,0	5,0	11,8-13,8	HL Solid 60	10	179529
32,2	35,4	2,0	5,0	11,8-13,8	HL Solid 60	10	179530
32,8	47,2	2,0	5,0	11,8-13,8	HL Solid 60	10	179531
35,2	26	2,0	5,0	11,8-13,8	HL Solid 60	10	179532
40,1	20,9	2,0	5,0	21,7-25,5	HL Solid 60	10	179533
40,1	30,4	2,0	5,0	21,7-25,5	HL Solid 60	10	179534
40,8	36	2,0	5,0	21,7-25,5	HL Solid 60	10	179535
42,8	31	2,0	5,0	21,7-25,5	HL Solid 60	10	179536 s
42,8	36	2,0	5,0	21,7-25,5	HL Solid 60	10	179537
45,8	36	2,0	5,0	21,7-25,5	HL Solid 60	10	179538
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]

B	H	S	Ø d	L	LEUCODUR	PU	Ident-No.	
49,9	20.9	2.0	5,0	21,7-25,5	HL Solid 60	10	179539	
49,9	33	2.0	5,0	21,7-25,5	HL Solid 60	10	179540	
49,2	40.2	2.0	5,0	21,7-25,5	HL Solid 60	10	179541	
60,6	25.8	2.0	5,0	26 - 22	HL Solid 60	10	179542 s	
59,8	35.4	2.0	5,0	25,5+43,2	HL Solid 60	10	179543	
80,6	35.8	2.0	5,0	44	HL Solid 60	10	179544 s	
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]	
B	H	S	Ø d	L	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
30,2	25.5	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179583 &	179584 &
30,2	30.4	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179585 &	179586 &
32,2	22.8	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179587 &	179588 &
32,2	35.4	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179589 &	179590 &
32,8	47.2	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179591 &	179592 &
35,2	26	2.0	5,0	11,8-13,8	HL Board 06 topline	10	179593 &	179594 &
40,1	20.9	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179595 &	179596 &
40,1	30.4	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179597 &	179598 &
40,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179599 &	179600 &
42,8	31	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179601 &	179602 &
42,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179603 s	179604 s
45,8	36	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179605 &	179606 &
49,9	20.9	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179607 &	179608 &
49,9	33	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179609 &	179610 &
49,9	40.2	2.0	5,0	21,7-25,5	HL Board 06 topline	10	179611 &	179612 &
60,6	25.8	2.0	5,0	22-26	HL Board 06 topline	10	179613 &	179614 &
59,8	35.4	2.0	5,0	25,5+43,2	HL Board 06 topline	10	179615 &	179616 &
80,6	35.8	2.0	5,0	44	HL Board 06 topline	10	179617 &	179618 &
30,2	25.5	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179657 &	179658 &
30,2	30.4	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179659 &	179660 &
32,2	22.8	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179661 &	179662 &
32,2	35.4	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179663 &	179664 &
32,8	47.2	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179665 &	179666 &
35,2	26	2.0	5,0	11,8-13,8	HL Solid 60 topline	10	179667 &	179668 &
40,1	20.9	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179669 &	179670 &
40,1	30.4	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179671 &	179672 &
40,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179673 &	179674 &
42,8	31	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179675 s	179676 s
42,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179677 &	179678 &
45,8	36	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179679 &	179680 &
49,9	20.9	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179681 &	179682 &
49,9	33	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179683 &	179684 &
49,9	40.2	2.0	5,0	21,7-25,5	HL Solid 60 topline	10	179685 &	179686 &
60,6	25.8	2.0	5,0	22-26	HL Solid 60 topline	10	179687 s	179688 s
59,8	35.4	2.0	5,0	25,5+43,2	HL Solid 60 topline	10	179689 &	179690 &
80,6	35.8	2.0	5,0	44	HL Solid 60 topline	10	179691 s	179692 s
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]	

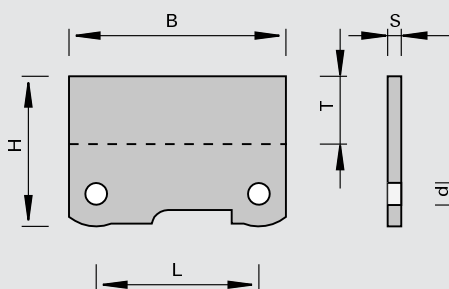
152526 / 152529

SuperProfiler Blanks HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in LEUCO SuperProfiler cutterheads

Design

thickness ground
 optionally topline (polished face)
 cutting material: HW
 HL Board 06 for wood-based panels, plastics and hard woods
 HL Solid 60 for soft woods

Advantages

topline design: highest cutting quality and significantly improved cutting edges

Notes

for concave and convex profiles
 T = maximum profile depth

B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No.
30,6	25.5	1.5	4,0	16-20	13	HL Board 06	10	179114
30,6	25.5	1.5	4,0	16-20	13	HL Solid 60	10	177369
40,6	28.2	1.5	4,0	28	13	HL Board 06	10	179112
40,6	28.2	1.5	4,0	28	13	HL Solid 60	10	177367
40,6	40.6	2.0	5,0	28	20	HL Board 06	10	179115
40,6	40.6	2.0	5,0	28	20	HL Solid 60	10	178844
49,3	33.7	1.5	4,0	35	16	HL Board 06	10	180199
60,8	30.2	1.5	4,0	48	15	HL Board 06	10	179113
60,8	30.2	1.5	4,0	48	15	HL Solid 60	10	177368
60,6	45.6	2.0	5,0	45	25	HL Board 06	10	179999
60,6	45.6	2.0	5,0	45	25	HL Solid 60	10	178845
80,6	45.6	2.0	6,0	65	25	HL Board 06	10	180016
80,6	45.6	2.0	6,0	65	25	HL Solid 60	10	180017
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

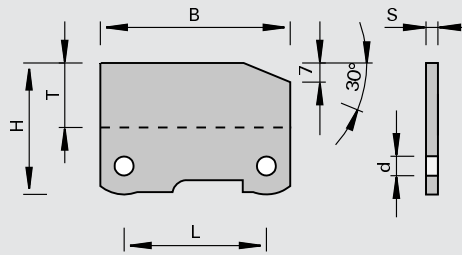
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
30,6	25.5	1.5	4,0	16-20	13	HL Board 06 topline	10	178701 &	178702
30,6	25.5	1.5	4,0	16-20	13	HL Solid 60 topline	10	177789	177790
40,6	28.2	1.5	4,0	28	13	HL Board 06 topline	10	178627	178626
40,6	28.2	1.5	4,0	28	13	HL Solid 60 topline	10	177791	177808
40,6	40.6	2.0	5,0	28	20	HL Board 06 topline	10	180030 &	180031
40,6	40.6	2.0	5,0	28	20	HL Solid 60 topline	10	180032 &	180033
49,3	33.7	1.5	4,0	35	16	HL Board 06 topline	10	180208	180209
60,8	30.2	1.5	4,0	48	15	HL Board 06 topline	10	178643	178628
60,8	30.2	1.5	4,0	48	15	HL Solid 60 topline	10	177809	177810
60,6	45.6	2.0	5,0	45	25	HL Board 06 topline	10	180034	180035
60,6	45.6	2.0	5,0	45	25	HL Solid 60 topline	10	180040 &	180041
80,6	45.6	2.0	6,0	65	25	HL Board 06 topline	10	180042	180043
80,6	45.6	2.0	6,0	65	25	HL Solid 60 topline	10	180044	180045
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

152526 / 152726

SuperProfiler Blanks HW - B=50 mm

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for use in LEUCO SuperProfiler cutterheads

Design

optionally topline (polished face)
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

topline design: highest cutting quality and significantly improved cutting edges

Notes

T = maximum profile depth

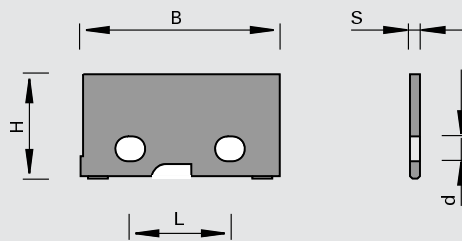
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No.	
49,4 [mm]	44.5 [mm]	2.0 [mm]	5,0 [mm]	35 [mm]	22 [mm]	HL Board 06	10 [pc.]	180218	
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
49,4 [mm]	44.5 [mm]	2.0 [mm]	5,0 [mm]	35 [mm]	22 [mm]	HL Board 06 topline	10 [pc.]	180219 s	180220 s

152536

PolyProfiler- / EcoPro-Blanks HW - B=40 mm

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

two-point seating surface and center stop for axial positioning
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

profile knife can be profiled per customer specifications

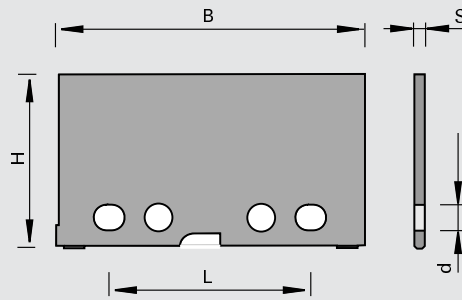
B	H	S	Ø d	L	PU	Ident-No.
41 [mm]	32.5 [mm]	2.0 [mm]	5,0 [mm]	21,7-25,5 [mm]	10 [pc.]	180197

152536 / 152736

PolyProfiler- / EcoPro-Blanks HW - B=60 mm

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

two-point seating surface and center stop for axial positioning
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

profile knife can be profiled per customer specifications

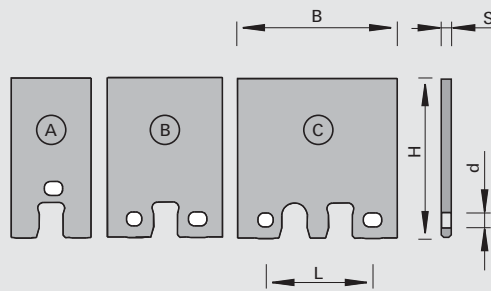
B	H	S	Ø d	L			PU	Ident-No.	
61 [mm]	34 [mm]	2.0 [mm]	5,0 [mm]	41,7-45,5 [mm]			10 [pc.]	180198	
B	H	S	Ø d	L	Tmax	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
61 [mm]	34 [mm]	2.0 [mm]	5,0 [mm]	41,7-45,5 [mm]	13 [mm]	HL Board 06 topline	10 [pc.]	181259	181258

152516

UltraProfiler Blanks HW

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

for use in LEUCO UltraProfiler cutterheads

Design

two-point seating and automatic positioning (axial and radial)
 optionally topline (polished face)
 cutting material: HW
 HL Board 06 for wood-based panels, plastics and hard woods

Advantages

precise and automatic positioning of the blanks for profiling and when changing the knives
 no stop screw necessary
 topline design: highest cutting quality and significantly improved cutting edges

Notes

profile knife can be profiled per customer specifications

B	H	S	Ø d	L	Type	LEUCODUR	PU	Ident-No.	
15	30.4	2.0	3,5		A	HL Board 06	10	183056	
20	40.4	2.0	3,5		A	HL Board 06	10	183057	
25	40.4	2.0	3,5		A	HL Board 06	10	183058	
32	40.4	2.0	3,5	15,8	B	HL Board 06	10	182419	
40	40.4	2.0	3,5	26,8	C	HL Board 06	10	182420	
50	40.4	2.0	3,5	32,8	C	HL Board 06	10	182421	
60	40.4	2.0	3,5	36,8	C	HL Board 06	10	182422	
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]		
B	H	S	Ø d	L	Type	LEUCODUR	PU	Ident-No. [L]	Ident-No. [R]
15	30.4	2.0	3,5		A	HL Board 06 topline	10	183680 o	183680 o
20	40.4	2.0	3,5		A	HL Board 06 topline	10	183681 o	183681 o
25	40.4	2.0	3,5		A	HL Board 06 topline	10	183682 o	183682 o
32	40.4	2.0	3,5	15,8	B	HL Board 06 topline	10	182563 o	182562 o
40	40.4	2.0	3,5	26,8	C	HL Board 06 topline	10	182565 o	182564 o
50	40.4	2.0	3,5	32,8	C	HL Board 06 topline	10	182567	182566
60	40.4	2.0	3,5	36,8	C	HL Board 06 topline	10	182569 o	182568 o
[mm]	[mm]	[mm]	[mm]	[mm]			[pc.]		





Clamping Systems

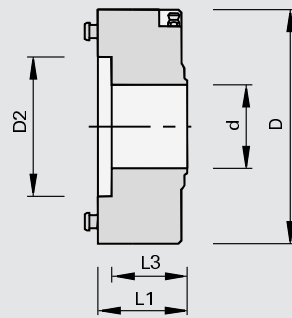
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933011

Clamping Systems Ø 110 mm

Product

Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 110 mm

Design

- | hardened tool mounting area
- | n max = 9,000 min-1

Advantages

- | excellent balance quality
- | long tool life
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No. 997370
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: clamping part incl. cap for attachment on the machine spindle

Ø D	Ø D2	Ø d	L1	L3	DKN	Ident-No.
110	50	30	63	47.5	8x3	172399 &
110	50	30	63	47.5	8x3	Homag, Lehbrink, Torwegge, SPA, Wilmsmeyer 160836
110	50	35	63	47.5	10x4	Spanevello 162599
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

For Ident-No.

Class-No.

PU

Ident-No.

Head Cap Screws	M12x30 DIN EN ISO 4762	172399	995111	10	001917
Lid		172399	997370	1	172397
Lid		160836	997370	1	181802
Lid		162599	997370	1	162602
Spacers	55x23,5x30	172399	955520	1	172398
Pneumatic hose		For all	994200	1	058250
	[mm]			[pc.]	

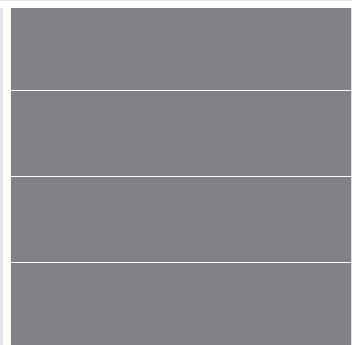
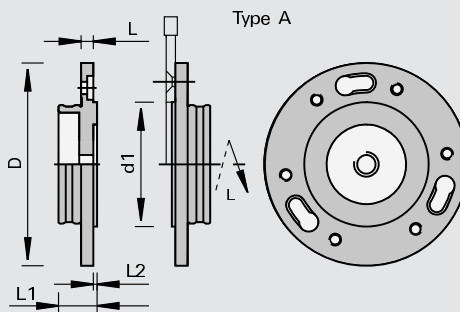
997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=65 mm

Product



Drawing



Machine / Application

for the mounting of saw blades up to Ø 250 mm with bore Ø 65 mm, 6 countersunk holes TK 90 mm for screw M 5

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- for DP circular saw blades the cylindrical head screw Ident-No. 001869 is necessary (to be ordered separately)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	65	2,5	10	27	164770	164758
[mm]	[mm]	[mm]	[mm]	[mm]		

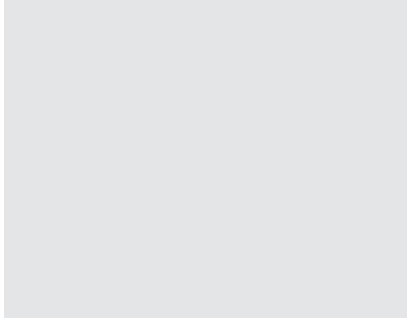
Spare parts	Dimension		Class-No.	PU	Ident-No.
Countersunk Screws	M5x12-5.8 DIN 87	for mounting of saw blade	995122	10	180007
Head Cap Screws	M5x12 DIN 912	for mounting of DP saw blades	995111	10	001869
	[mm]			[pc.]	



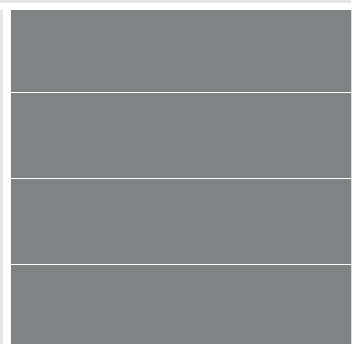
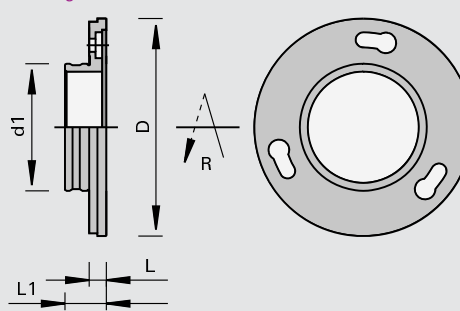
997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=50 mm

Product



Drawing



Machine / Application

for the mounting of saw blades up to Ø 250 mm and saw plate thickness 1.8 - 2.2 mm with bore Ø 50 mm, 3 NL - Ø 22 mm, TK Ø 80 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades

Ø D	Ø d1	L	L1	Ident-No.
107	50	10	26.5	160849
[mm]	[mm]	[mm]	[mm]	

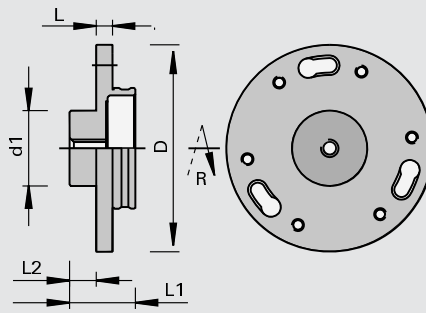
997370

Mounting Flanges for Clamping System Ø 110 mm - tools with bore d=30 mm

Product



Drawing



Machine / Application

for mounting of light tools with bore Ø 30 mm, 6 countersunk holes for M 5, TK Ø 90 mm

Design

Advantages

Notes

for clockwise and counter-clockwise rotation
at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	30	15,5	10	40	163705	163226
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws

M5x12-5.8 DIN 87

995122

10

180007

Head Cap Screws

M5x12 DIN 912

995111

10

001869

[mm]

[pc.]

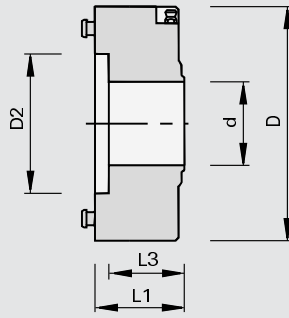
933011

Clamping Systems Ø 140 mm

Product



Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 140 mm

Design

- | n max = 9,000 min-1

Advantages

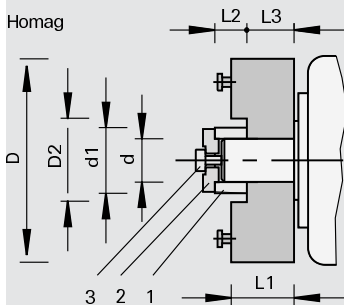
- | excellent balance quality
- | long tool life thanks to hardened tool mounting area
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

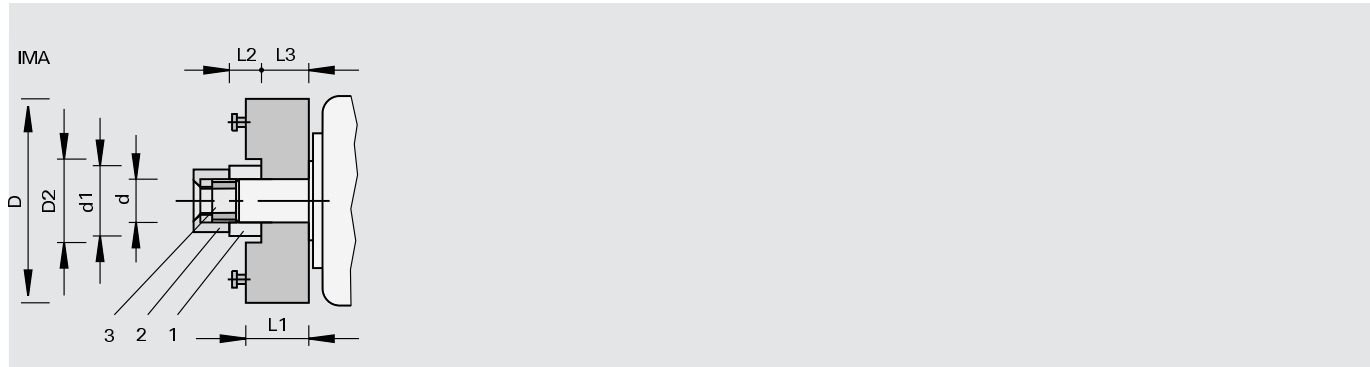
- | for clockwise and counter-clockwise rotation
- | mounting examples (see drawings): shaft with internal thread, shaft with external thread
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No. 997370
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

Ø D	Ø D2	Ø d	L1	L3	DKN	Ident-No.
140	80	35	57	41.5	10x4	Homag, IMA 167451
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	45	35	22	997370	1	180082
Special Nuts	58		M30x1,5	995290	1	170364 s
	[mm]	[mm]	[mm]		[pc.]	



Spare parts	Dimension	Ø D	Ø d1	Ø D	Class-No.	PU	Ident-No.
1 centering adapter				35	997370	1	180540
3 cylindrical head screws for Ød=35	M16x55R				995111	10	80068439
3 cylindrical head screws for Ød=35	M20x35L				995111	10	80068437
2 caps		45	35	22	997370	1	180082
	[mm]	[mm]	[mm]	[mm]		[pc.]	



Spare parts	Ø D	Ø d	Dimension	Class-No.	PU	Ident-No.
1 centering adapter		35		997370	1	180540
2 special nuts			M35x1,5	995290	1	IMA3
3 countersunk flat headed screws				995121	10	IMA4
4 spacers	70	35	Ø70x25xØ35	955520	1	170363 s
	[mm]	[mm]	[mm]		[pc.]	

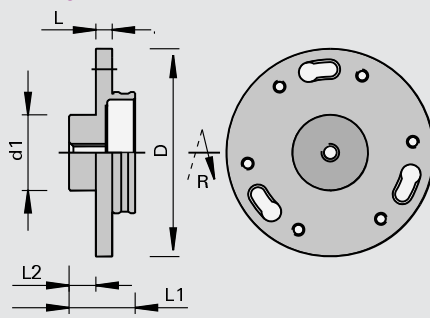
997370

Mounting Flanges for Clamping System Ø 140 mm - tools with bore d=30 mm

Product



Drawing



Machine / Application

for mounting of medium-weight tools with bore Ø 30 mm, 6 countersunk holes for M 8, TK Ø 110 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- for s-System on shaft with internal thread
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

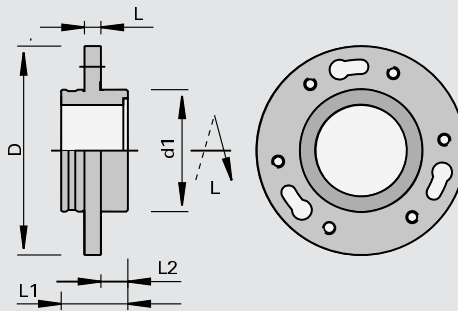
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	30	17,4	10.8	43.4	163946	163945
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System \varnothing 140 mm - tools with bore $d=80$ mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of medium-weight tools with bore \varnothing 80 mm, 6 countersunk holes for M 8, TK \varnothing 110 mm

- for clockwise and counter-clockwise rotation
- for s-System on shafts with external thread
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

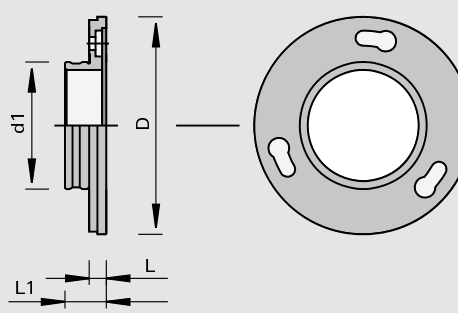
\varnothing D	\varnothing d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	80	17,5	11.8	44.7	168401 s	168400
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System \varnothing 140 mm - saw blades $d=80$ mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for the mounting of saw blades up to \varnothing 400 mm and saw plate thickness 1.8 - 2.2 mm with bore \varnothing 80 mm, 3 NL - \varnothing 22 mm, TK \varnothing 110 mm

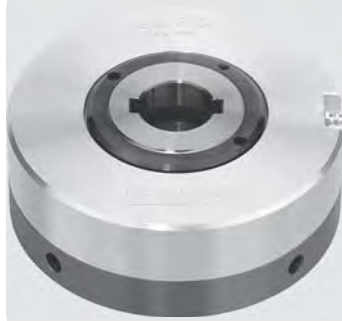
- for clockwise and counter-clockwise rotation

\varnothing D	\varnothing d1	L	L1	Ident-No.
137	80	10	28	177050
[mm]	[mm]	[mm]	[mm]	

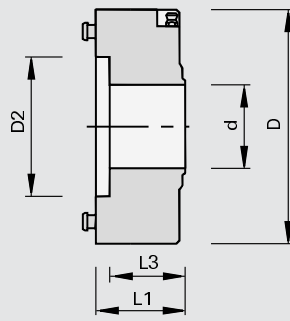
933011

Clamping Systems Ø 160 mm

Product



Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore

Design

- | n max = 9,000 min-1

Advantages

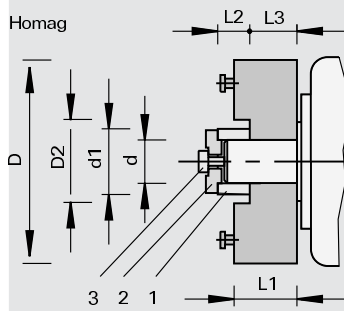
- | excellent balance quality
- | long tool life thanks to hardened tool mounting area
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | mounting examples (see drawing): shaft with internal thread, shaft with external thread
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No. 997370
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

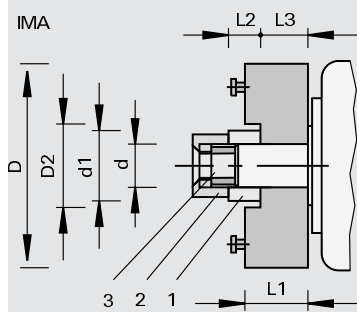
Ø D	Ø D2	Ø d	L1	L3	DKN	Ident-No.
160	80	35	60	44.5	10x4	Homag, IMA
160	80	40	60	44.5	12x4	167463
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	40	30	17	997370	1	181802
Lid	45	35	22	997370	1	180082
Lid	48	40	22	997370	1	180121
Special Nuts	58		M30x1,5	995290	1	170364 s
	[mm]	[mm]	[mm]			



Spare parts	Dimension	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
1 centering adapter				30	997370	1	168457 s
2 caps		40	30	17	997370	1	181802
1 centering adapter				35	997370	1	180540
2 caps		45	35	22	997370	1	180082
	[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
3 cylindrical head screws for Ød=35	M16x55R				995111	10	80068439
3 cylindrical head screws for Ød=35	M20x35L				995111	10	80068437
4 spacers		60		35	955520	1	180647
	[mm]	[mm]	[mm]	[mm]		[pc.]	



Spare parts	Ø D	Ø d	Dimension	Class-No.	PU	Ident-No.
1 centering adapter		35		997370	1	180540
2 special nuts			M35x1,5	995290	1	IMA3
3 countersunk flat headed screws				995121	10	IMA4
4 spacers	70	35	Ø70x25xØ35	955520	1	170363 s
	[mm]	[mm]	[mm]			[pc.]

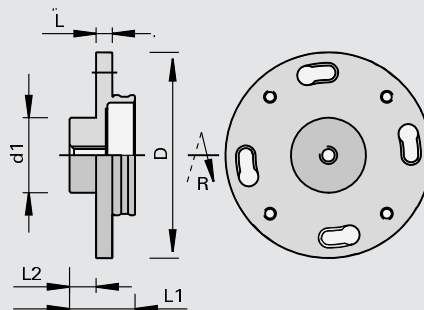
997370

Mounting Flanges for Clamping System Ø 160 mm - tools with bore d=30 mm

Product



Drawing



Machine / Application

! for mounting of heavy tools with bore Ø 30 mm with 4 countersunk holes M 8, TK Ø 130 mm

Design

Advantages

Notes

- ! for s-System on shaft with external thread
- ! for clockwise and counter-clockwise rotation
- ! indicate shaft design when placing an order
- ! at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- ! sense of rotation see drawing

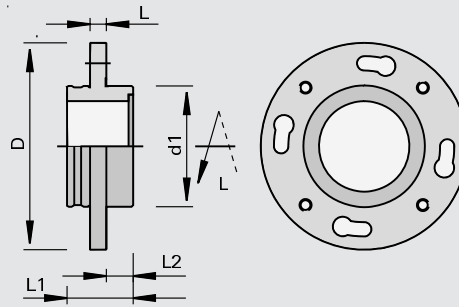
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	30	17,4	10,8	43,4	167465	167464
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System \varnothing 160 mm - tools with bore $d=80$ mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of heavy tools with bore \varnothing 80 mm with 4 countersunk holes M 8, TK \varnothing 130 mm

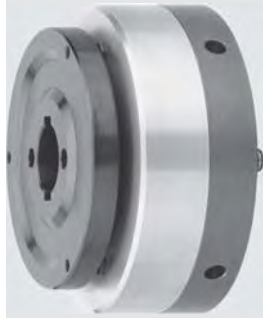
- | for s-System on shaft with external thread
- | for clockwise and counter-clockwise rotation
- | indicate shaft design when placing an order
- | at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- | sense of rotation see drawing

\varnothing D	\varnothing d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	80	18	11.8	45	168399	168398
[mm]	[mm]	[mm]	[mm]	[mm]		

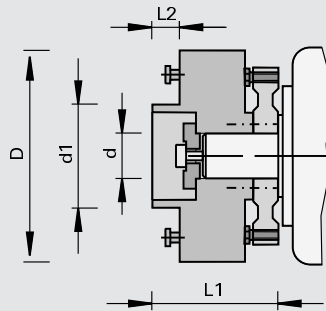
933011

Zeroplan Clamping Systems Ø 160 mm

Product



Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 160 mm

Design

- | n max = 7,200 min-1

Advantages

- | high runout accuracy almost as good as on hydro motors, now available for standard-motor shafts d = 35
- | distinct increase of edge life and quality thanks to precise run-out-adjustment
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar

Ø D	Ø d	Ø d1	L2	L1	DKN		Ident-No.
160	35	60	17,5	95	10x4	Homag	180654
160	35	60	17,5	102	10x4	IMA	180655 #
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Lid (IMA)	45x25x35 DKN	997370	1	180656 o
Engineers Wrenches	SW10/13 DIN 895	985720	1	171060 o
	[mm]		[pc.]	

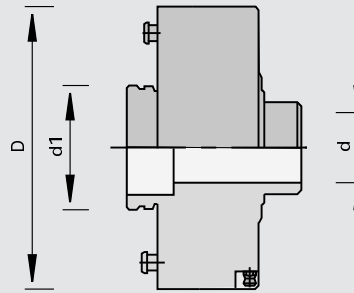


933011

Clamping Systems Ø 192 mm

Product

Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of hogsers with Ø 250 mm

Design

- | n max = 7,200 min-1

Advantages

- | excellent balance quality
- | long tool life thanks to hardened tool mounting area
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

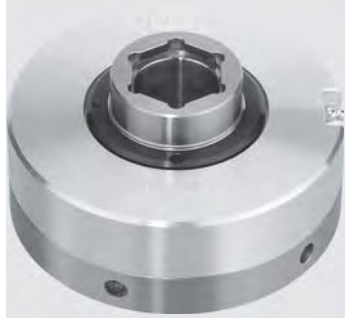
- | for clockwise and counter-clockwise rotation
- | mounting example (see drawing)
- | indicate machine type and shaft design when placing an order
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: see table

Ø D	Ø d	Ø d1	DKN		Ident-No.
192	35	80	10x4	clamping part, spacer ring IMA, B+G, Hüllhorst	161363 s
192	40	80	12x5	clamping part, spacer ring B+G, SCM-Stefani	161365 s
192	35	80	10x4	clamping part, spacer ring, cover disk Danckaert	161367 s
192	35	80	10x4	clamping part Homag, Lehbrink, Torwegge, SPA, Wilmsmeyer	161259
192	40	80	12x5	clamping part, spacer ring, cover disk M+S, Schwabedissen	161251 s
[mm]	[mm]	[mm]	[mm]		

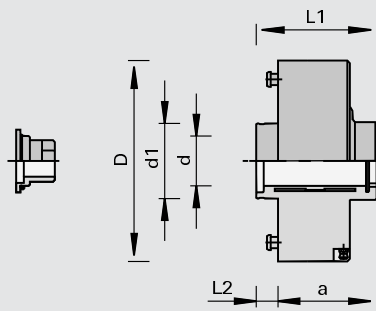
933011

Hydro Clamping System Ø 160 mm - hoggers

Product



Drawing



Machine / Application

| for mounting of tools with bore

Design

| hardened tool mounting area
 | n max = 9,000 min-1
 | closed hydraulic expansion clamping chuck with one clamping zone for tight-tolerance fit on the motor shaft

Advantages

| high cutting quality thanks to distinctly increased runout accuracy and concentricity
 | consistent runout accuracy after each tool change
 | minimization of setup-times thanks to easy and quick tool change
 | maintenance-free

Notes

| for clockwise and counter-clockwise rotation
 | specifically designed for high-precision motors with hexagonal spindle base
 | for changing the tools the pneumatic part Ident-No. 058250 is necessary
 | operational pressure 6 bar
 | included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	L1	a		Ident-No.
160	40	60	17,5	96	78.5	Hoggers	172677
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

	Class-No.	PU	Ident-No.
Lids with O-Rings	997300	1	172679
Head Cap Screws	995111	10	184251
Pneumatic hose	994200	1	058250
Screwdrivers	985730	1	167817
Cranked Wrench Keys	985730	1	177106
		[pc.]	



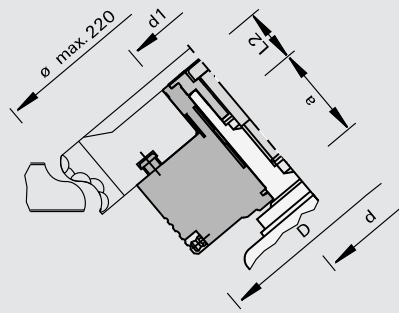
933011

Hydro Clamping System Ø 160 mm - cutters

Product



Drawing



Machine / Application

| for mounting of tools with bore

Design

- | hardened tool mounting area
- | n max = 9,000 min-1
- | closed hydraulic system with two clamping zones
- | clamping zone 1: for tight-tolerance fit on the motor shaft (runout)
- | clamping zone 2: for tight-tolerance fit of milling tools on the clamping element (concentricity)

Advantages

- | high cutting quality thanks to distinctly increased runout accuracy and concentricity
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free

Notes

- | for clockwise and counter-clockwise rotation
- | specifically designed for high-precision motors with hexagonal spindle base
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	a		Ident-No.
160	40	60	35	53	milling tools	176829
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

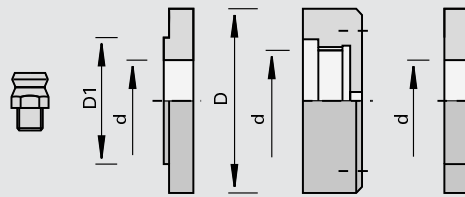
	Class-No.	PU	Ident-No.
Lids with O-Rings	997300	1	172679
Head Cap Screws	995111	10	184251
Pneumatic hose	994200	1	058250
Screwdrivers	985730	1	167817
Cranked Wrench Keys	985730	1	177106
		[pc.]	

Accessories for Quick-Clamping Systems

Product



Drawing



Machine / Application

for engaging or releasing the LEUCO quick-clamping systems

Design

Advantages

Notes

- | anti-twist bolt Ident-No. 160875 for mounting
- | ring Ident-No. 170363 is required for L = 68 mm if no centering adapter is used
- | nut Ident-No. 170364 is required for IMA machines with short shaft
- | the pneumatic hose is required to change the tools; must be ordered separately before first delivery of clamping systems

	Class-No.	Ident-No.
hydraulic connector R 1/8" (old design)	994400	160632
hydraulic connector M10x1 (new design)	994400	180084
fitting	997800	161289
pneumatic hose complete	994200	058250

Spare parts	For s-Sytem Ø D/d	Ø D	Ø D1	Ø d	Class-No.	PU	Ident-No.
Lid	110/140/160/30	40	30	17	997370	1	181802
Lid	110/35	40	35	17	997370	1	162602
Lid	140/160/35	45	35	22	997370	1	180082
Lid	140/160/40	48	40	22	997370	1	180121
Special Nuts	140/160/35	58		M30x1,5	995290	1	170364 s
Spacers	140/160/35	70		35	955520	1	170363 s
Bolts	110/140/160			10x120	995322	10	160875
		[mm]	[mm]	[mm]		[pc.]	



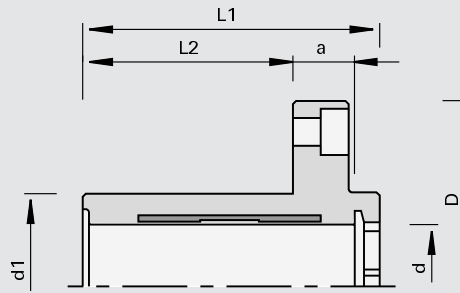
933030

Hydro Clamping Bushings with hexagonal adapter bottom- tools with bore

Product



Drawing



Machine / Application

| for mounting of tools with bore

Design

| hardened tool mounting area
 | with one clamping zone
 | closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
 | n max = 9,000 min-1

Advantages

| optimum cutting quality when milling and hogging
 | maintenance-free and inured to dirt

Notes

| for clockwise and counter-clockwise rotation
 | specifically designed for high-precision motors with hexagonal spindle base
 | included in delivery: hydro clamping bushing without screwdrivers

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	20	4/M8/100	172678
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 40 mm	997300	1	172679
Head Cap Screws	M14x60 DIN 6912 for 172679	995111	10	184251
Screwdrivers	SW6 for hydro pressure build-up	985730	1	167817
Cranked Wrench Keys	SW12 DIN 6911	985730	1	177106
Spacers	119,5x51x60 NL	955520	1	179471

[pc.]

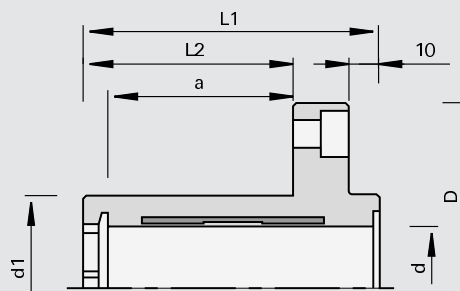
933030

Hydro Clamping Bushings with hexagonal adapter top- tools with bore

Product



Drawing



Machine / Application

| for mounting of tools with bore and for combination with Postforming radius panel raising cutters und LEUCODIA CompactTec hoggers

Design

| hardened tool mounting area
 | with one clamping zone
 | closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
 | n max = 9,000 min-1

Advantages

| excellent cutting quality when milling and hogging
 | maintenance-free

Notes

| for clockwise and counter-clockwise rotation
 | specifically designed for high-precision motors with hexagonal spindle base
 | included in delivery: Hydro Clamping Bushing incl. screwdriver SW 6

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	60	4/M8/100	173724
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 40 mm	997300	1	172679
Head Cap Screws	M14x60 DIN 6912 for 172679	995111	10	184251
Screwdrivers	SW6 for hydro pressure build-up	985730	1	167817
Cranked Wrench Keys	SW12 DIN 6911	985730	1	177106
Spacers	119,5x51x60 NL	955520	1	179471
			[pc.]	

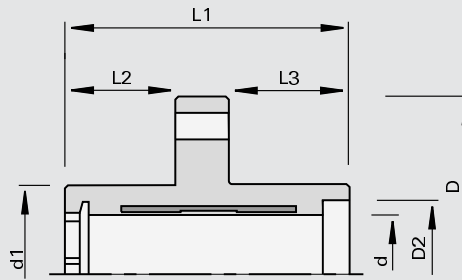
933030

Hydro Clamping Bushings - tools with bore progressively adjustable

Product



Drawing



Machine / Application

for mounting of milling tools with progressive adjustment of the cutting width

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
n max = 9,000 min-1

Advantages

excellent cutting quality when milling
maintenance-free

for clockwise and counter-clockwise rotation
specifically designed for high-precision motors with hexagonal spindle base

Ø D	Ø D2	Ø d	Ø d1	L2	L1	L3	NL	Ident-No.
120	50	40	60	39	101	44	4/M8/100	180181
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

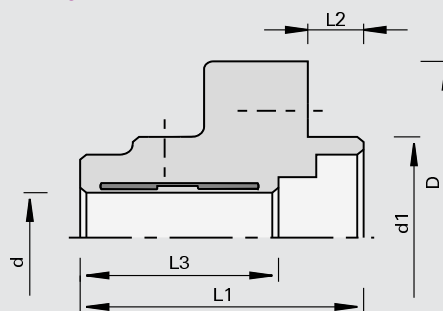
933030

Hydro Clamping Bushings - hoggers

Product



Drawing



Machine / Application

for mounting of tools with bore with LEUCO hoggers Ø 200 mm and Ø 250 mm

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
n max = 9,000 min-1

Advantages

Notes

for clockwise and counter-clockwise rotation
fits conventional motors with shaft 35 mm and keyway

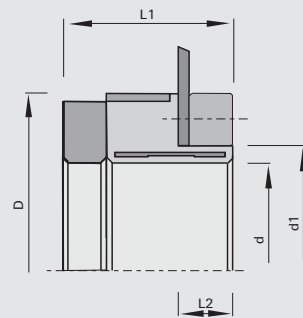
Ø D	Ø d	Ø d1	L2	L1	L3	DKN	NL	Ident-No.
120	35	80	17,7	90	63	10x4	4/M8/100	170264 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933030

Hydro Clamping Bushings - gang-rip saw blades and hoggers (Paul, Homag)

Product

Drawing



Machine / Application

l machines Paul, Homag
l for mounting of of multi-rip saw blades and hoggers

Design

l hardened tool mounting area
l with one clamping zone
l closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft
l n max = 9,000 min-1

Advantages

l high smoothness of running
l short retool-times of panel-widths thanks to quick adjustment of tools
l maintenance-free

Notes

l for clockwise and counter-clockwise rotation
l mounting arrangements: 1. saw blade with spacer, 2. hogger without spacer
l positive locking between machine and sleeve
l tap holes on PCD for fixing of tools

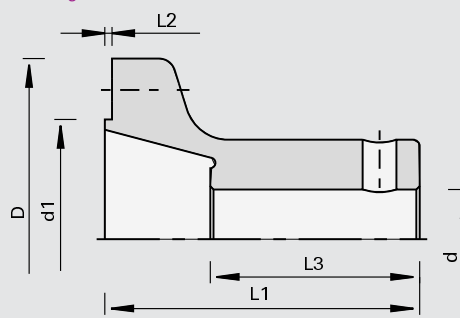
Ø D	Ø d	Ø d1	L2	L1	NL	Ident-No.
145	100	110	18	65.5	4/M8/130	183829
150	100	110	18	49.5	4/M8/130	183821 s
[mm]	[mm]	[mm]	[mm]	[mm]		

997300

Mounting Flanges - scoring saw blades (Homag, Brandt, IMA)

Product

Drawing



Machine / Application

l double end tenoners
l edge banding machines Homag, Brandt, IMA
l for mounting of HW scoring saw blades and DP scoring saw blades

Design

l tempered design
l mating and seating surfaces ground

Advantages

Notes

l for clockwise and counter-clockwise rotation
l for DP circular saw blades the cylindrical head screw Ident-No. 001869 is necessary (to be ordered separately)
l countersink screw included in delivery

Ø D	Ø d	Ø d1	L2	L1	L3	DKN	NL	Ident-No.
109	30	65	2,2	95	63	8x4	6/M5/90	006480
109	35	65	2,2	95	75	10x3,3	6/M5/90	182128
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

	Ø D	Ø D1	Ø d	For Ident-No.	Class-No.	PU	Ident-No.
Lid	40	30	17	006480	997370	1	181802
Lid	45	35	22	182128	997370	1	180082
Countersunk Screws	for mounting of saw blade			For all	995122	10	180007
Head Cap Screws	for mounting of DP saw blades			For all	995111	10	001869
	[mm]	[mm]	[mm]			[pc.]	

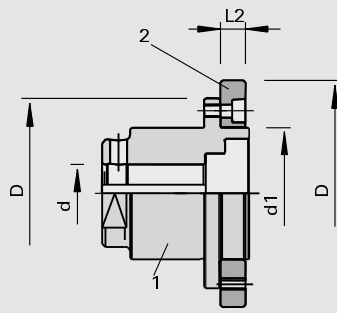
997300

Attachment Sleeves and Flanges - grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Product



Drawing



Machine / Application

for mounting of grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Design

Advantages

Notes

for clockwise and counter-clockwise rotation
 1 = hogger sleeve
 2 = flange
 for horizontally tilted motor when working in small distance to chain track

Ø D	Ø d	Ø d1	L2	L1	DKN	NL	Ident-No.
115	30	80	17,7	96	8x3	8/M8/100	006309
115	35	60	17,7	90	10x3,3	8/M8/100	180062
115	35	80	17,7	90	10x3,3	8/M8/100	055997
115	40	60	17,7	90	12x3,3	8/M8/100	180120
115	40	80	17,7	96	12x3,3	8/M8/100	006308
145	35	110	17	89.4	10x3,3	4/M8/130	189750 s
158	40	80	21	96	12x5	8/M8/130	008507 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Flange

Ø D

B

Ø d

Ø NL

Class-No.

PU

Ident-No.

137

80

15

6/M5/105

997300

1

819300 s

[mm]

[mm]

[mm]

[pc.]

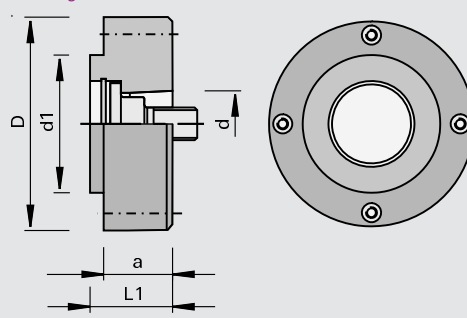
997300

Mounting Flanges - clipping saw blades (Homag, IMA)

Product



Drawing



Machine / Application

edge banding machines
 Homag, IMA
 for mounting of clipping saw blades

Design

machine interface HSK 25R

Advantages

optimum cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

for clockwise and counter-clockwise rotation
 countersunk screw and screwdrivers are not included in delivery

Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
55	HSK 25R	34	22	20	4/M4/44 + 4/M5/42	179025
62	HSK 25R	40	24	20	4/M5/52	177788
66	HSK 25R	40	24	15	4/M5/52	183817
[mm]	[mm]	[mm]	[mm]	[mm]		

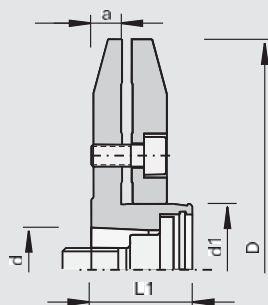
Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
Countersunk Screws	M5x10 T20	995125	10	171236
Screwdrivers	T20x100	985730	1	166092
	[mm]		[pc.]	

997300

Mounting Flanges - clipping saw blades (Homag Power-Line)

Product

Drawing



Machine / Application

l machines Power-Line Homag
l for mounting of clipping saw blades

Design

l machine interface HSK 25R

Advantages

l optimum cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

l for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
105	HSK 25R	30	23	14	4/M5/52	181590
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screws	M10x1,25x32 SW8	995190	1	177780
Shim Rings	18x25x1,0 DIN 988	995440	10	177781
Locking Rings	25x1,2 DIN 472	995460	10	177782
Head Cap Screws	M5x12 DIN 912	995111	10	001869
Screwdrivers	SW4x100	985730	1	166091
	[mm]		[pc.]	

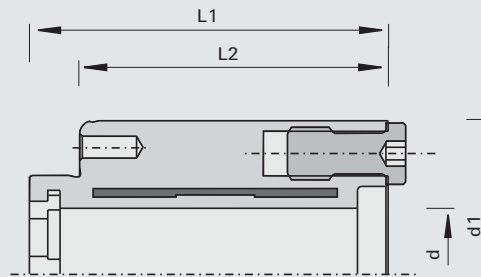
933030

Hydro Clamping Bushings - tools with bore on spindle 30 mm

Product



Drawing



Machine / Application

- for Homag and IMA jointing aggregat with spindle 30 mm and hexagon adapter
- for mounting of tools with bore

Design

- hardened tool mounting area
- with one clamping zone
- axial pressurization
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the 30 mm motor shaft
- $n_{max} = 9,000 \text{ min}^{-1}$

Advantages

- reduced machine downtimes thanks to axial pressurization
- excellent cutting quality when milling and hogging
- maintenance-free

Notes

- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- included in delivery: hydro clamping bushing without screwdrivers

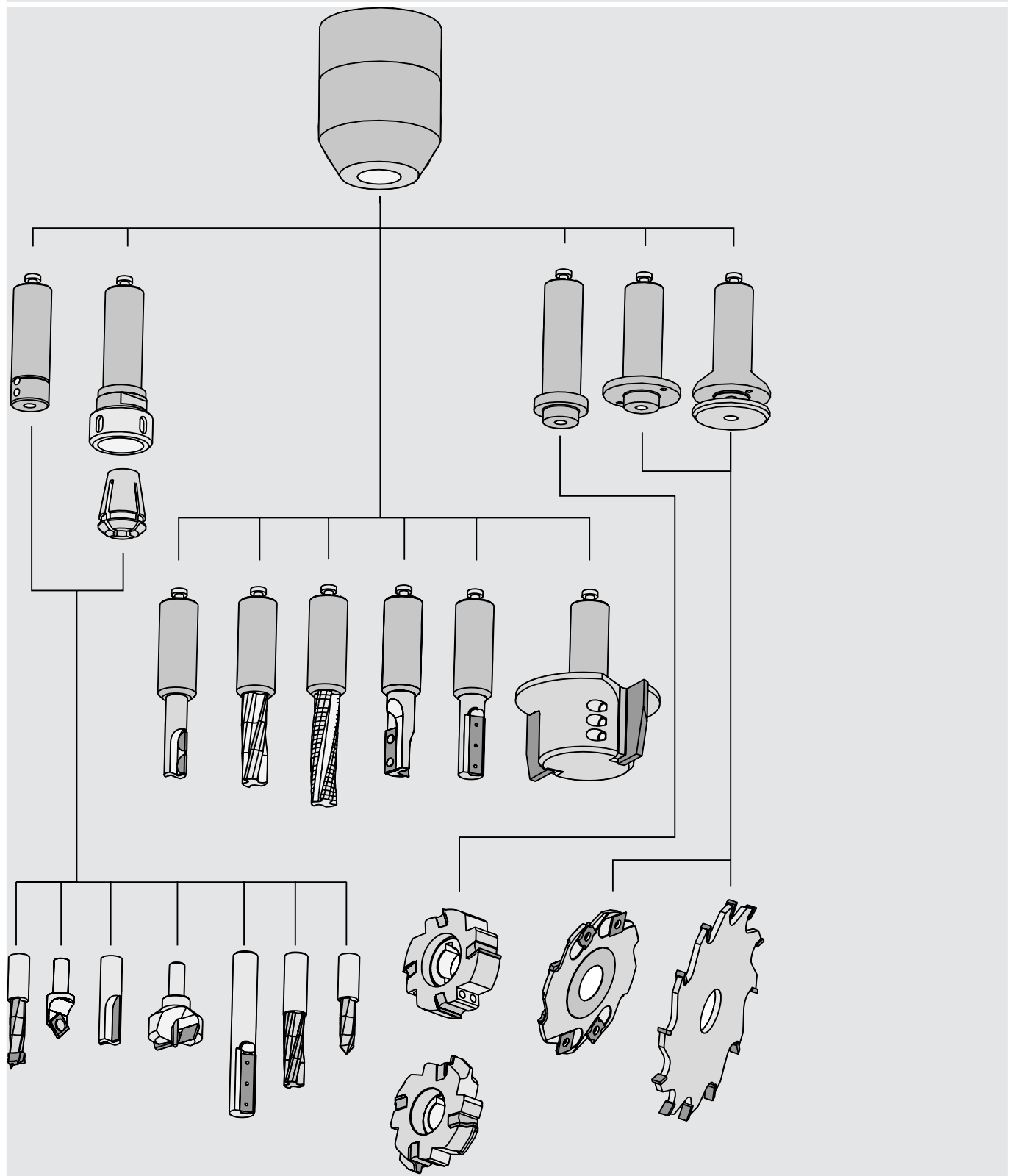
$\varnothing d$	$\varnothing d1$	L2	L1	NL	Ident-No.
30 [mm]	70 [mm]	70,5 [mm]	86 [mm]	6/M6/58	184310

Spare parts

		Class-No.	PU	Ident-No.
Lids with O-Rings	for axial locking or bores 30 mm	997300	1	184317
Head Cap Screws	M10x50 DIN EN ISO 4762 for 184317	995111	10	001909
Screwdrivers	SW6/4 for hydro pressure build-up	985730	1	184707
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	1	009677 s
				[pc.]



Chart Tool Holders machine interface PS 2000-E



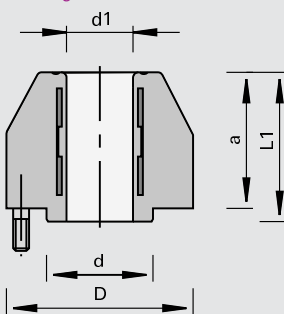
933240

Hydro Clamping Chucks PS 2000-E - tool directly attached by screws

Product



Drawing



LEUCO
CNC

Machine / Application

for precise clamping of shank-type tools with cylindrical shank

Design

n max = 25,000 min -1

Advantages

optimum cutting quality and long tool life thanks to exact radial running accuracy
minimization of setup-times thanks to easy and quick tool change

Notes

for clockwise and counter-clockwise rotation
integral part of machine spindle
initial purchase through the machine manufacturers
axial locking of the tools

Ø D	Ø d	Ø d1	L1	a	Weight	Ident-No.
70	40	25	56	51	1.327	173752
[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Accessories

Safety Screws

Dimension

M8x19
[mm]

Class-No.

997870

PU

1

Ident-No.

172921

[pc.]

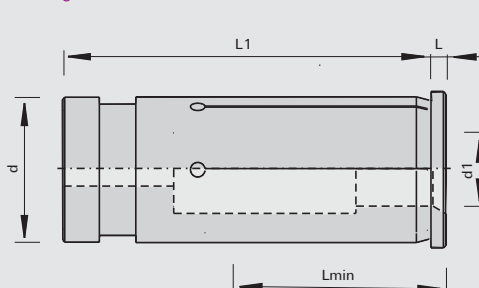
933280

Universal Reducing Bushings

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of shank-type tools in Sino, TRIBOS, ps-System

Design

shank diameter tolerance h7 or g7

Advantages

Notes

Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
3		27	12	45	2.0	183022 o
4		27	12	45	2.0	183023 o
5		27	12	45	2.0	183024 o
6		27	12	45	2.0	183025
8		27	12	45	2.0	183026
8		27	16	47.5	2.5	186099
10		32	16	47.5	2.5	186100
12		37	16	47.5	2.5	186101
3		27	20	50.5	2.0	183027 o
4		27	20	50.5	2.0	183028 o
5		27	20	50.5	2.0	183029 o
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
6		27	20	50.5	2.0	183030
8		27	20	50.5	2.0	183032
10		32	20	50.5	2.0	183034
12		37	20	50.5	2.0	183036
14		37	20	50.5	2.0	183038
16		38	20	50.5	2.0	183040
6		27	25	54.5	3.0	182304
8		27	25	54.5	3.0	182305
10		32	25	54.5	3.0	182306
12		37	25	54.5	3.0	182307
14		37	25	54.5	3.0	182308
16		38	25	54.5	3.0	182309
18		38	25	54.5	3.0	182310
20		42	25	54.5	3.0	182311
	1/2"	37	25	54.5	3.0	182653
	3/4"	42	25	54.5	3.0	182655
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

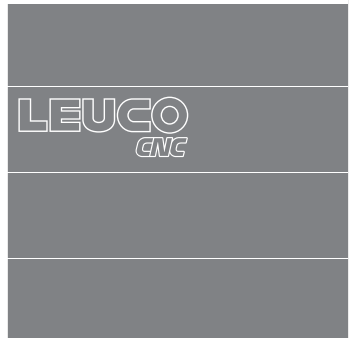
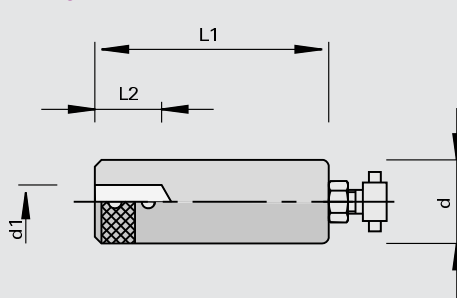
933243

Adapters with cylindrical shank - shank-type tools

Product



Drawing



Machine / Application

for mounting of shank-type tools in PS 2000-E for shank diameter 6 - 12 mm

Design

Advantages

Notes

- the tool shanks must feature a flat clamping area
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- with length adjusting screw for ps-System Ø 16 mm Ident-No. 172115, Ø 25 mm Ident-No. 172113

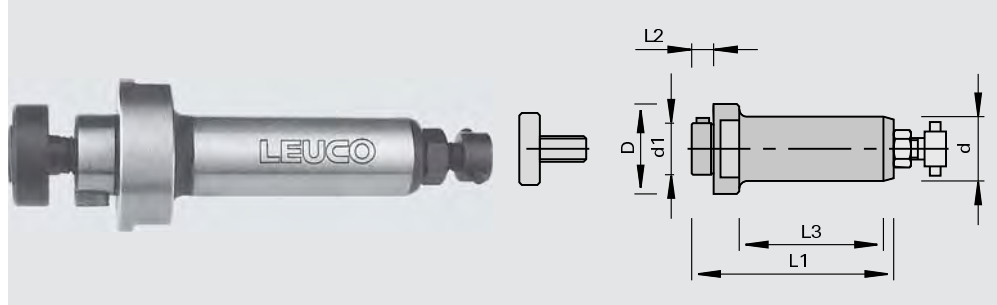
Ø d	Ø d1	L2	L1	Ident-No.
16	8	20	61	172117
16	10	20	61	172119
25	6	20	70	172103
25	8	20	70	172104
25	10	20	70	172101
25	12	20	70	172102
[mm]	[mm]	[mm]	[mm]	

997300

Adapters with cylindrical shank - tools with bore

Product

Drawing

LEUCO
GNC

Machine / Application

for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

tool held in place by set screws

Advantages

Notes

for clockwise and counter-clockwise rotation
length adjusting screw Ident-No. 172921 is required for PS 2000-E
included in delivery: mounting arbor, set screws and length adjusting screw for ps-System for shank \varnothing 16 Ident-No. 172115, shank \varnothing 25 Ident-No. 172113

$\varnothing D$	$\varnothing d$	$\varnothing d1$	L2	L1	L3	Ident-No.
35	16	20	8,5	68	43	171389 s
35	25	20	8,5	78,5	55	171391 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

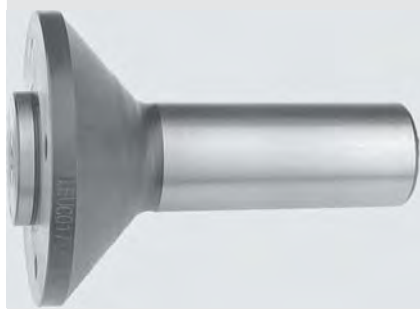
Cutter Retaining Bolts	M8x23x \varnothing 20	995190	1	171393 s
Cutter Retaining Bolts	M10x26x \varnothing 28	995190	1	171392
Engineers Wrenches	24x27 DIN 3110	985730	1	009193 o
	[mm]		[pc.]	



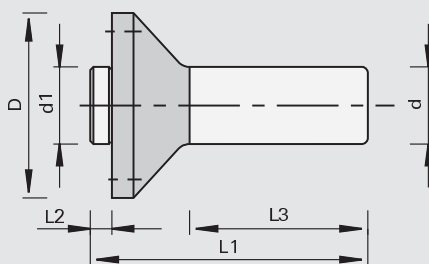
997300

Adapters with cylindrical shank - saw blades, grooving cutters and cutters

Product



Drawing



LEUCO
CNC

Machine / Application

for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

tool attached and secured against rotation with screws

Advantages

Notes

- for right-hand and left-hand rotation
- for PS 2000-E, the length adjusting screw ID no. 172921 is required
- clamping length L2 = 30 and 36 mm for one-piece and multi-piece cutters and cutterheads
- clamping length L2 = 4 and 5 mm for circular saw blades and grooving tools
- Scope of delivery: Adapter for Lamello Clamex P® including 4 countersunk screws, all other adapters without countersunk screws. Screws of the required length must be ordered separately depending on the application.

Ø D	Ø d	Ø d1	L2	L1	L3	NL	Ident-No.
50	16	22	4,0	68	45	4/M5/34 + 4/M4/36	184277
50	25	22	4,0	92	60	4/M5/34 + 4/M4/36	184276
60	16	30	4,0	80	60	4/M6/48 Lamello Clamex P®	184304
60	25	30	4,0	90	70	4/M6/48 Lamello Clamex P®	184305
60	25	25	30	111	60	6/M6/48	168814
60	25	30	36	117	60	6/M6/48	168815
66	25	30	5,0	92	60	4/M5/48	171386
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Countersunk Screws	M6x10 T20	184304, 184305	995125	10	181244
Screwdrivers	T20x100	184304, 184305	985730	1	166092
	[mm]			[pc.]	

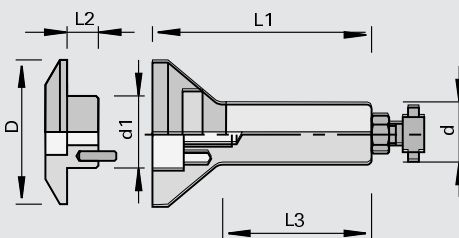
933069

Adapters with cylindrical shank - saw blades and grooving cutters

Product



Drawing

LEUCO
GNC

Machine / Application

for PS 2000-E and draw-in collet chuck for mounting of circular saw blades and grooving cutters

Design

secured against rotation with drive pin

Advantages

Notes

for clockwise and counter-clockwise rotation
length adjusting screw Ident-No. 172921 is required for PS 2000-E
included in delivery: clamping arbor, clamping flange, cap screw and length adjusting screw for ps-System for shank \varnothing 16 Ident-No. 172115, shank \varnothing 25 Ident-No. 172113

\varnothing D	\varnothing d	\varnothing d1	L2	L1	L3	Ident-No.
60	16	30	8,0	78	43	for plate thickness max. 6 mm 171394
60	25	30	9,0	94	55	for plate thickness max. 8 mm 167826
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

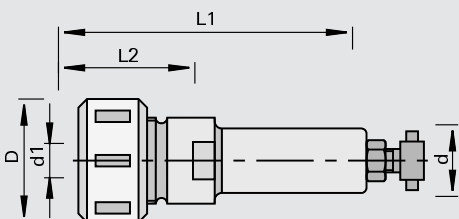
933250

Draw-In Collet Chucks with cylindrical shank

Product



Drawing

LEUCO
GNC

Machine / Application

for mounting of shank-type tools in PS 2000-E

Design

for shank diameter 2-16 mm
collet chucks DIN 6388 Type 415E/OZ16
lock nut with sleeve bearing

Advantages

Notes

for clockwise and counter-clockwise rotation
length adjusting screw Ident-No. 172921 is required for PS 2000-E
included in delivery: collet chuck adapter with nut and length adjusting screw for ps-System for shank \varnothing 16 Ident-No. 172115, shank \varnothing 25 Ident-No. 172113

\varnothing D	\varnothing d	\varnothing d1	L2	L1	Ident-No.
43	16	2-16	50	95	170181
43	25	2-16	50	105	170182
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Clamping Nuts	M30x1,5R	995290	1	178763
Hook Wrenches	40/42 DIN 1810	985720	1	169298
Hook wrenches adapter	40/43 DIN 1810	985300	1	186466 o
Engineers Wrenches	24x27 DIN 3110	985730	1	009193 o
Torque wrench	40-200 Nm	985300	1	184890
	[mm]		[pc.]	

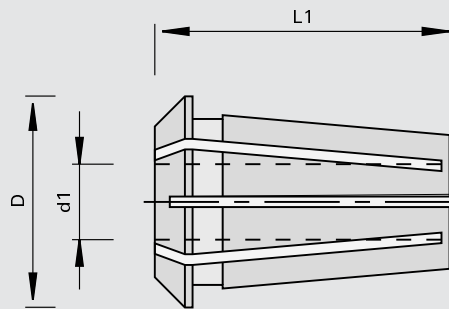
933280

Precision collets - 415E/OZ16

Product



Drawing



LEUCO
GNC

Machine / Application

for use in draw-in collet chucks
Type 415E/OZ16

Design

slotted from top and bottom
clamping tolerance 0.5 mm
according to DIN 6388 415E/
OZ16

Advantages

Notes

for Ident-No. 170181,
170182

Ø D	Ø d1	L1	Ident-No.
25.5	2,5	40	820753 o
25.5	3	40	820754 o
25.5	4	40	820494 o
25.5	4,5	40	830236 o
25.5	5	40	820495 o
25.5	6	40	170779 o
25.5	6,35	40	821421 o
25.5	7	40	829692 o
25.5	8	40	170780
25.5	9	40	825190 o
25.5	9,5	40	168739 o
25.5	10	40	170781
25.5	12	40	168740
25.5	12,7	40	830156 o
25.5	13	40	821221 o
25.5	16	40	168741
[mm]	[mm]	[mm]	

933250

StarterKit for Weeke BHX series

Product

Drawing



Machine / Application

- | for use in hydro expansion chuck on WEEKE BHX machines, especially BHX 050/055 series
- | for tools with shank diameter up to 1-16 mm

Design

- | adapters with high-precision collet chucks, especially adapted to the hydro clamping system of the BHX milling spindle
- | with internal lock nut

Advantages

- | flexible, quick clamping
- | low building height
- | individual tool pre-setting outside of the machine is possible
- | time saving tool changes

Notes

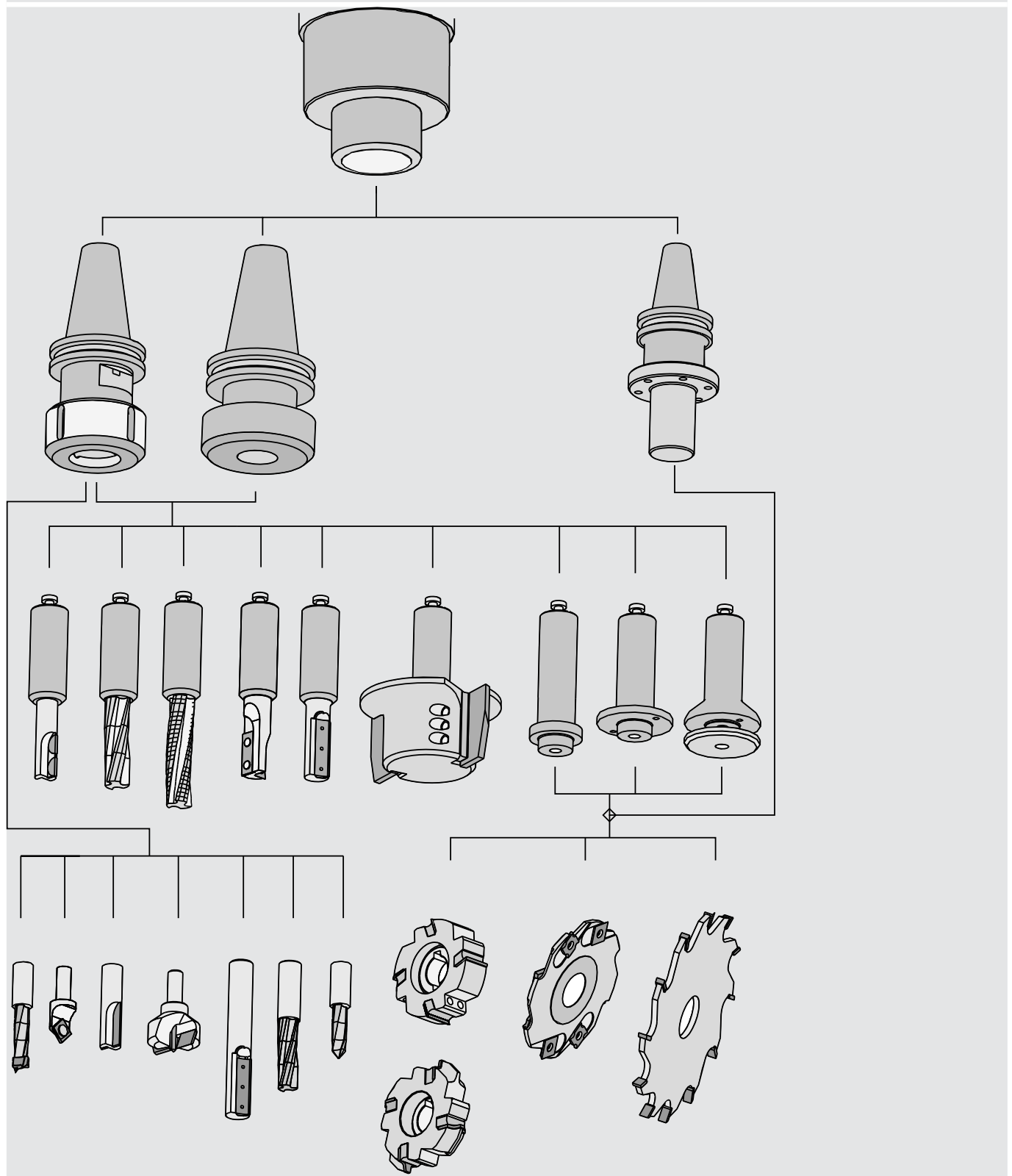
- | for Weeke BHX machines grooving cutters HW "g5-System" are also available
- | torque: 90 Nm (74 Lbf.ft)

		Ident-No.
StarterKit SET1	[d]+[f] 3 clamping adapter incl. lock nuts [e] 3 collet chucks (8, 10, 12 mm) [c] 1 mounting device [a] 1 hook wrench [g] 1 wrench	184359 o
StarterKit SET2	[d]+[f] 5 clamping adapter incl. lock nuts [e] 5 collet chucks (6, 8, 10, 12, 16 mm) [c] 1 mounting device [a] 1 hook wrench [b] 1 wrench socket	184360 o

Spare parts	Content StarterKit	Dimension	Class-No.	PU	Ident-No.
[f]+[d] clamping adapter incl. lock nut	For all	ØD25x16	933250	1	184362 o
[c] mounting devices	For all		985202	1	184363 o
[a] Hook Wrench	For all	ØD=25, L=200	985720	1	184364 o
[g] Wrench	184359	ØD=30, SW27, H20	985720	1	184365 o
[b] Wrench Socket	184360	ØD=30, SW22, H96	985720	1	184366
[e] collet chucks	184360	4 11E ØD=6	933280	1	184372
[e] collet chucks	For all	4 11E ØD=8	933280	1	184373
[e] collet chucks	For all	4 11E ØD=10	933280	1	184374
[e] collet chucks	For all	4 11E ØD=12	933280	1	184375
[e] collet chucks	184360	4 11E ØD=16	933280	1	184376
		[mm]			[pc.]

Accessories	Dimension	Class-No.	PU	Ident-No.
[e] collet chucks	4 11E ØD=1	933280	1	184367 o
[e] collet chucks	4 11E ØD=2	933280	1	184368 o
[e] collet chucks	4 11E ØD=3	933280	1	184369 o
[e] collet chucks	4 11E ØD=4	933280	1	184370 o
[e] collet chucks	4 11E ØD=5	933280	1	184371 o
[e] collet chucks	4 11E ØD=6	933280	1	184372
[e] collet chucks	4 11E ØD=16	933280	1	184376
[d] Clamping Nuts	M32x1,5	995290	1	184378
	[mm]			[pc.]

Chart Tool Holders machine interface SK- and BT-Mounting



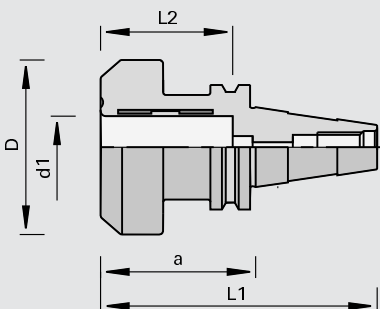
933240

Hydro Clamping Chucks PS 2000-E - tool changer

Product



Drawing

LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | n max = 25,000 min⁻¹
- | quick-release taper BT 30 and quick-release taper BT 35 with retaining bolt according to standard MAS 403
- | quick-release taper SK 30 according to DIN ISO 7388 (without retaining bolt - must be ordered separately)
- | quick-release taper SK 30 and SK 40 according to DIN ISO (with retaining bolt)

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	Weight	Ident-No.	
70	SK 30 (DIN ISO)	25	55	111	63	1.1	IMA, Maka, Biesse, Reichenbacher, Weeke, CMS	173754 o
70	SK 40 (DIN ISO)	25	55	128	60	1.39	IMA, Maka, Reichenbacher, Stegherr	173756 o
70	BT 35	25	55	120	63	1.25	Heian	175796 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		

Retaining Bolts

Mach.

Class-No.

PU

Ident-No.

for SK 30	IMA, Maka, Reichenbacher, Weeke	997870	1	169293
for SK 40	IMA, Reichenbacher, Stegherr	997870	1	169294 o
for SK 30	CMS, Masterwood	997870	1	177021
for SK 30	Rover old, Biesse up to 08/92	997870	1	175637 o
for SK 30	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	997870	1	173641
for SK 30	Alberti	997870	1	177020 o
for BT 35	Heian	997870	1	176103

[pc.]

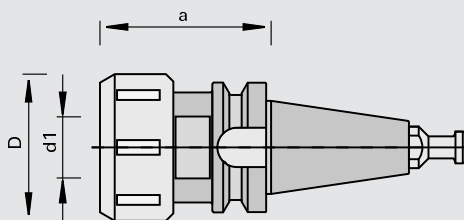
933289

Draw-In Collet Chucks with SK shank

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- | BT quick-release taper according to Japanese standard MAS - 403 (for Ident-No. 176102)
- | lock nut with sleeve bearing (except for Ident-No. 177304 with ball bearing)

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | included in delivery: collet chuck, clamping nut and retaining bolt

Ø D	Ø d	Ø d1	a	Norm number	Ident-No.	
43	SK 30 (DIN ISO)	2-16	55	415E/OZ16 SW 41	Weeke	177304 o
60	SK 30 (DIN ISO)	2-25	70	462E/OZ25 SW 41	IMA, Maka, Reichenbacher	173794
50	SK 30 (DIN ISO)	2-20	58	470E/ER32 SW 41	CMS	180360 o
60	SK 40 (DIN ISO)	2-25	70	462E/OZ25 SW 46	IMA, Maka, Stegherr, Reichenbacher	173795
60	BT 35	2-25	70	462E/OZ25 SW 41	Heian	176102
[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.	
Clamping Nuts	M30x1,5R	177304	995290	1	178763
Clamping Nuts	M48x2R	173794, 173795, 176102	995290	1	178764
Retaining Bolts		173794, 177304	997870	1	169293
Retaining Bolts		173795	997870	1	179339
Retaining Bolts		180360	997870	1	177021
Retaining Bolts		176102	997870	1	176103
Single-Head Engineers Wrenches	SW41 DIN 894	177304	985720	1	169297 s
Single-Head Engineers Wrenches	SW46x10 DIN 894	173794, 173795, 176102	985720	1	178760
Hook Wrenches	40/42 DIN 1810	177304	985720	1	169298
Hook Wrenches	58/62 DIN 1810	173794, 173795, 176102	985720	1	169299
Hook wrenches adapter	40/43 DIN 1810	177304	985300	1	186466 o
Hook wrenches adapter	58/62 DIN 1810	173794, 173795, 176102	985300	1	186765
Torque wrench	40-200 Nm	173794, 173795, 176102, 177304	985300	1	184890
	[mm]				[pc.]

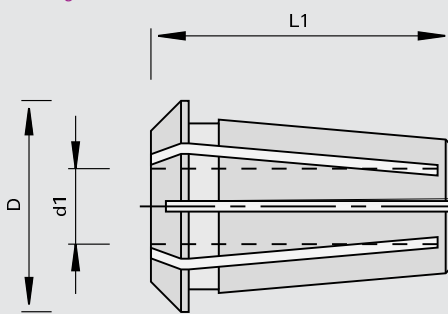
933280

Precision collets - 462E/OZ25

Product



Drawing



LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 462E/OZ25

Design

clamping tolerance 0.5 mm
according to DIN 6388 Type
462E/OZ25

Advantages

optimum transmission of clamp-
ing force thanks to 12 slots from
top and bottom

Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4"	35.05	52	175815
7		35.05	52	183807
8		35.05	52	180358
9,5		35.05	52	175817
	3/8"	35.05	52	185275
10		35.05	52	170782
12		35.05	52	168742
	1/2"	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8"	35.05	52	175823
15		35.05	52	183808
16		35.05	52	168743
18		35.05	52	180216
	3/4"	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	



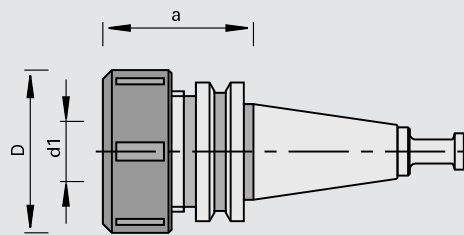
933289

Draw-In Collet Chucks with SK shank - Biesse, CMS

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- | lock nut with sleeve bearing

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | collet chucks according to Type 470E/ER32 Ø 2..20 mm
- | collet chucks according to Type 472E/ER40 Ø 4..25 mm
- | included in delivery:collet chuck, clamping nut and retaining bolt (Biesse 173641)

Ø D	Ø d	Ø d1	a	Type		Ident-No.
50	SK 30 (DIN ISO)	2-20	50	470E/ER32	Biesse	173639
63	SK 30 (DIN ISO)	4-25	57	472E/ER40	Biesse	175790
63	SK 30 (DIN ISO)	4-25	64	472E/ER40	CMS	180361
[mm]	[mm]	[mm]	[mm]			

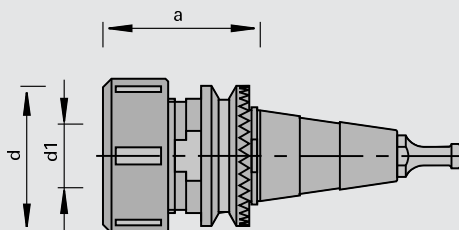
Spare parts	Dimension		Class-No.	PU	Ident-No.
Clamping Nuts	M40x1,5R	for Ø D = 50	995290	1	178761
Clamping Nuts	M50x1,5R	for Ø D = 63	995290	1	178762 o
Retaining Bolts		HSD motor for Biesse as from 09/92	997870	1	173641
Retaining Bolts		for Biesse up to 08/92	997870	1	175637 o
Retaining Bolts		for CMS	997870	1	177021
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	985720	1	175851
Hook Wrenches	58/62 DIN 1810	for Ø D = 63	985720	1	169299
Hook wrenches adapter	45/50 DIN 1810	for Ø D = 50	985300	1	186467 o
Hook wrenches adapter	58/62 DIN 1810	for Ø D = 63	985300	1	186765
Torque wrench	40-200 Nm		985300	1	184890
	[mm]			[pc.]	

933289

Draw-In Collet Chucks with SK shank with ring gear

Product

Drawing


LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to SK 30 with ring gear
- | lock nut with sleeve bearing

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | replaceable retaining bolt
- | collet chucks according to Type 462E/OZ25 Ø 4..25 mm
- | collet chucks according to Type 470E/ER32 Ø 2..20 mm
- | included in delivery:collet chuck, clamping nut and retaining bolt

Ø D	Ø d	Ø d1	a	Type		Ident-No.
50	SK 30	2-20	55	470E/ ER32	SCM, Morbidelli	173644
60	SK 30	4-25	72	462E/ OZ25	SCM, Morbidelli	175792
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Clamping Nuts with sleeve bearing M40x1,5R		for Ø D = 50	995290	1	178761
Clamping Nuts with sleeve bearing M48x2R		for Ø D = 60	995290	1	178764
Retaining Bolts	Ø8,5		997870	1	173646
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	985720	1	175851
Hook Wrenches	58/62 DIN 1810	for Ø D = 60	985720	1	169299
Single-Head Engineers Wrenches	SW36 DIN 894	for Ø D = 50	985720	1	169296
Single-Head Engineers Wrenches	SW46x10 DIN 894	for Ø D = 60	985720	1	178760
	[mm]			[pc.]	



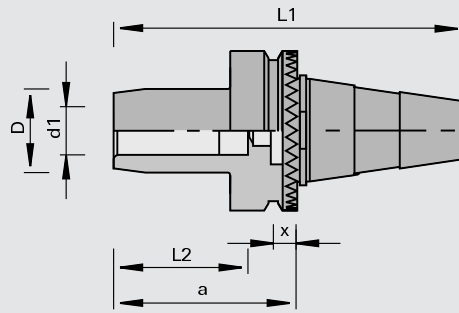
933299

TRIBOS Power Shrink Chucks with SK shank

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l quick-release taper according to SK 30 with ring gear
- l n max = 40,000 min-1

Advantages

- l low weight is easy on machine bearing
- l suitable for high RPM 's
- l optimum chip extraction thanks to slim design
- l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- l for clockwise and counter-clockwise rotation
- l different diameters upon request
- l allowed projection: clamping of the tools by means of the clamping device
- l can also be done at LEUCO upon request
- l delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
25	55	SK 30	35	127.85	80	10	0.7	180898 #
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Spare parts

	Class-No.	PU	Ident-No.
Mounting Devices (manual)	985201	1	180261
Mounting Devices (automatic)	985201	1	181159 o
Reducing inserts for Mounting Device for Ø d = 20	955530	1	180264
Reducing inserts for Mounting Device for Ø d = 25	955530	1	180711
Length Adjustment Gauge TRIBOS system without interface cable	985300	1	180828 o
Interface Cables for Adjusting Gauges for RS 232C interface	985300	1	180829 o
			[pc.]

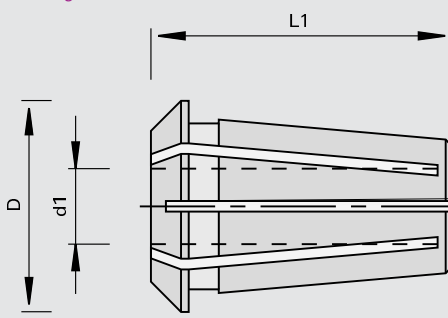
933280

Precision collets - 430E/ER25, 470E/ER32, 472E/ER40

Product



Drawing


LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 430E/ER25, 470E/ER32,
472E/ER40

Design

slotted from top and bottom
clamping tolerance 1 mm

Advantages

Notes

Type 430E/ER25 Ø 6 - 16
mm for special chuck
Type 470E/ER32 Ø 3 - 20
mm
Type 472E/ER40 Ø 6 - 25
mm

Ø D	Ø d1	Ø d1	L1	Type	Ident-No.
33	3		40	470E/ER32	173647 o
33	4		40	470E/ER32	173648 o
33	5		40	470E/ER32	173649 o
33	6		40	470E/ER32	173650
33	7		40	470E/ER32	173651 o
33	8		40	470E/ER32	173652
33	10		40	470E/ER32	173653
33	12		40	470E/ER32	173654
33	13		40	470E/ER32	173655 o
33	14		40	470E/ER32	173656 o
33	16		40	470E/ER32	173657
33	18		40	470E/ER32	173658 o
33	19		40	470E/ER32	173659 o
33	20		40	470E/ER32	173660
33		1/4"	40	470E/ER32	175829
33		1/2"	40	470E/ER32	175830
33		5/8"	40	470E/ER32	175831 o
33		3/4"	40	470E/ER32	175832 o
41	6		46	472E/ER40	180912 o
41	8		46	472E/ER40	180913
41	10		46	472E/ER40	180914 o
41	12		46	472E/ER40	175833
41	16		46	472E/ER40	175834
41	18		46	472E/ER40	175835 o
41	20		46	472E/ER40	175836
41	25		46	472E/ER40	175837
41		1/4"	46	472E/ER40	175838 o
41		1/2"	46	472E/ER40	175839 o
41		5/8"	46	472E/ER40	175840 o
41		3/4"	46	472E/ER40	175841 o
41		1"	46	472E/ER40	175842 o
26	6		34	430E/ER25	181986 o
26	8		34	430E/ER25	181987
26	10		34	430E/ER25	181988
26	12		34	430E/ER25	181989
26	14		34	430E/ER25	181990 o
26	16		34	430E/ER25	181991
[mm]	[mm]	[inch]	[mm]		

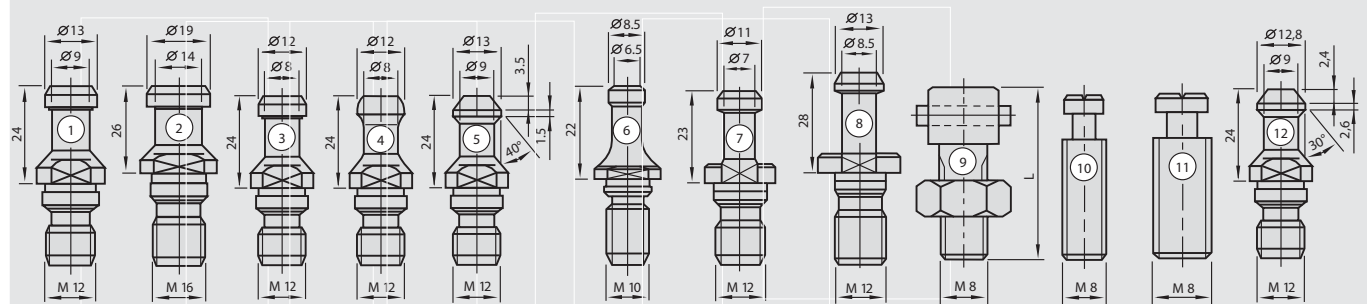


997870

Retaining Bolts

Product

Drawing



Machine / Application

Design

Advantages

Notes

I for use in Hydro clamping chuck PS 2000-E, adapter and draw-in collet chuck with SK + BT-shank

I attachment screw for tools with shank diameter 25 mm

	Type		Ident-No.
for SK 30	1	IMA, Maka, Reichenbacher, Weeke	169293
for SK 40 with ventilation	2	IMA, Reichenbacher, Stegherr	169294 o
for SK 40	2	IMA, Reichenbacher, Stegherr, Maka	179339
for SK 30	3	Rover old, Biesse up to 08/92	175637 o
for SK 30	4	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	173641
for SK 30	5	Alberti	177020 o
for CMS	12	CMS, Masterwood	177021
Retaining Bolt Ø 8.5 mm	6	Morbidelli, SCM	173646
for BT 30	7	Shoda	176200 o
for BT 35	8	Heian	176103
for ps-System 25 mm Ident-No. 173752	9	ps-System	172113
for PS-2000 E Ident-No. 173352	10	PS 2000-E	172921
stop screw	11	draw-in collet chuck	172828

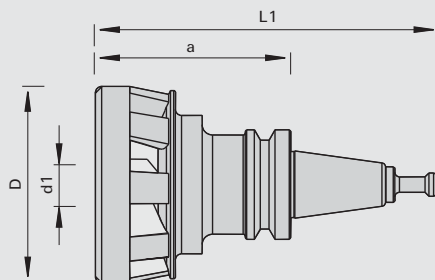
933285

AEROTECH-System with SK30 (DIN ISO) with hydro expansion clamping

Product



Drawing



Machine / Application

- | CNC machining centers
- | for clamping of shank-type tools and simultaneous chip guide when working
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processes e.g. with Nesting applications

Design

- | monolithic tool clamping system
- | 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- | tool mounting by means of hydro expansion clamping technology
- | balance quality G<2,5

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance
- | minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- | high cutting quality and long edge lives thanks to high concentricity
- | optimum torque transfer

Notes

- | sufficient vacuum performance is necessary
- | pressurization via hexagonal screwdriver (included in delivery)
- | delivery with retaining bolts for Biesse Ident-No. 173641
- | retaining bolt Ident-No. 169293 for IMA, Maka, Reichenbacher and Weeke must be ordered separately
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
20	SK 30 (DIN ISO)	95	143.2	92.2	9 wings	185153
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers with sliding handle for hexagon socket SW4x100		985730	1	166091
	[mm]		[pc.]	



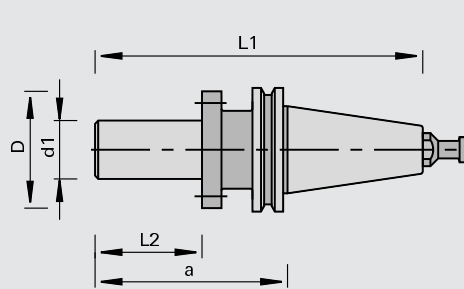
997300

Adapters with SK shank

Product



Drawing



LEUCO
CNC

Machine / Application

- for CNC machining centers with automatic tool changer
- for precise mounting of tools with bore

Design

- clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- quick-release taper according to DIN ISO 7388 (without dog and locating grooves)
- tool attached and secured against rotation with screws

Advantages

Notes

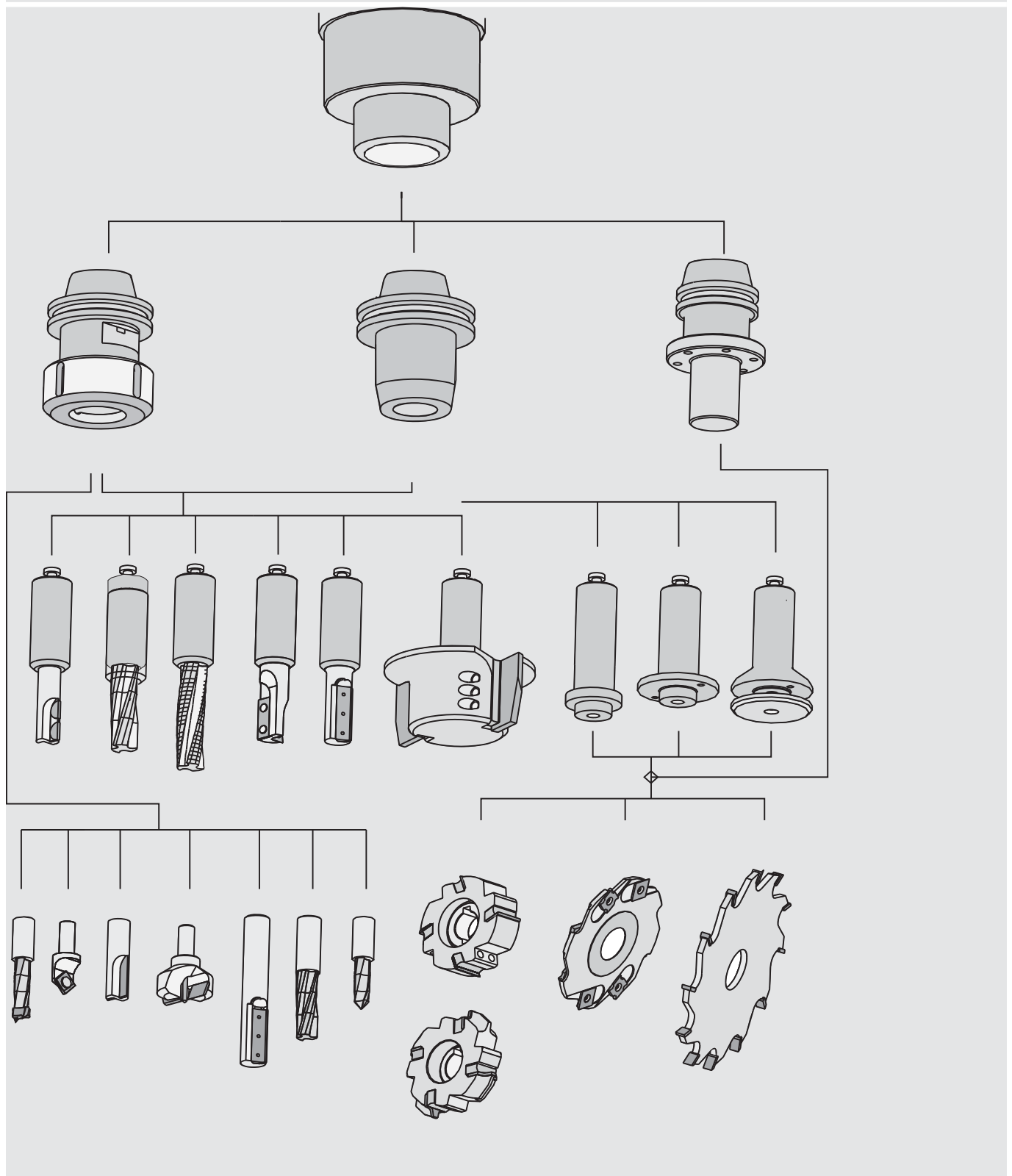
- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
60	SK 30	30	55	147.8	100	2/M6/48 + 2/6/48	182167 o
60	SK 40	30	55	168.4	100	2/M6/48 + 2/6/48	182168 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

		Class-No.	PU	Ident-No.
Retaining Bolts	for SK 30	997870	1	169293
Retaining Bolts	for SK 40	997870	1	179339
			[pc.]	

Chart Tool Holders machine interface HSK-Mounting



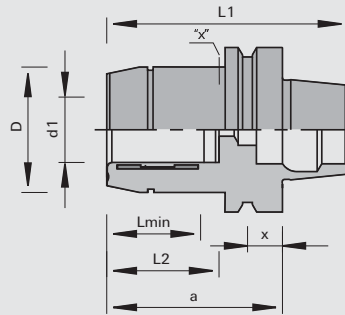
933240

Hydro Clamping Chuck ps-System with HSK 63F

Product



Drawing



LEUCO
PS(system)

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l n max = 30,000 min -1
- l interface DIN 69893 HSK 63 F

Advantages

- l minimization of setup-times thanks to easy and quick tool change
- l high cutting quality and long edge lives thanks to high concentricity
- l optimum torque transfer

Notes

- l for right- and lefthand rotation
- l with bore for installation of micro chips for electronic tool detection
- l x = pressurization by means of screwdriver
- l hexagonal screwdriver is not included in delivery
- l Lmin minimum clamping length = minimum shaft length

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
10	31	41	HSK 63F	30	105	80	18	1.2	184725
12	36	46	HSK 63F	32	105	80	18	1.16	184306
16	39	49	HSK 63F	38	105	80	18	1.20	184307
20	41	51	HSK 63F	52.5	105	80	18	1.30	184308
25	47	57	HSK 63F	52.5	109	84	18	1.28	184309
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
3/8"	31	41	HSK 63F	30	105	80	18	1.2	184724
1/2"	36	47,5	HSK 63F	32	105	80	18	1.2	184726
[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Suitable for	Class-No.	PU	Ident-No.
Screwdrivers	SW4x100	184306, 184724, 184725, 184726	985730	1	166091
Screwdrivers	SW5x150	184307, 184308, 184309	985730	1	168703
	[mm]				[pc.]

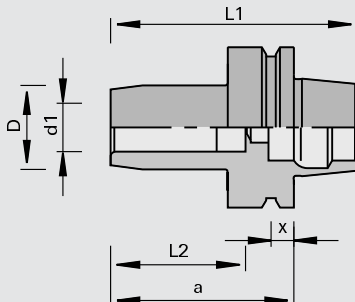
933299

TRIBOS Power Shrink Chucks

Product



Drawing

LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l n max = 40,000 min-1

Advantages

- l low weight is easy on machine bearing
- l suitable for high RPM's
- l optimum chip extraction thanks to slim design
- l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- l for right- and lefthand rotation
- l different diameters upon request
- l allowed projection: 4 x d1
- l clamping of the tools by means of the clamping device
- l can also be done at LEUCO upon request
- l TRIBOS chuck with reinforced design especially for heavy roughing can be delivered upon request
- l delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
12	48,5	HSK 63F	19	100	75	18	0.69	180257
16	48,5	HSK 63F	26	100	75	18	0.74	180899
20	52,9	HSK 63F	30	100	75	18	0.77	180258
25	55	HSK 63F	35	100	75	18	0.79	180710
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	Ident-No.
20	55	SK 30 (DIN)	30	127	80	180888
25	55	SK 30 (DIN)	35	127	80	180836
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

	Class-No.	PU	Ident-No.
Mounting Devices (manual)	985201	1	180261
Mounting Devices (automatic)	985201	1	181159 o
Reducing inserts for Mounting Device for Ø d = 6	955530	1	183719 o
Reducing inserts for Mounting Device for Ø d = 8	955530	1	183720 o
Reducing inserts for Mounting Device for Ø d = 10	955530	1	183721 o
Reducing inserts for Mounting Device for Ø d = 12	955530	1	180263
Reducing inserts for Mounting Device for Ø d = 16	955530	1	180902
Reducing inserts for Mounting Device for Ø d = 20	955530	1	180264
Reducing inserts for Mounting Device for Ø d = 25	955530	1	180711
Length Adjustment Gauge TRIBOS system without interface cable	985300	1	180828 o
Interface Cables for Adjusting Gauges for RS 232C interface	985300	1	180829 o

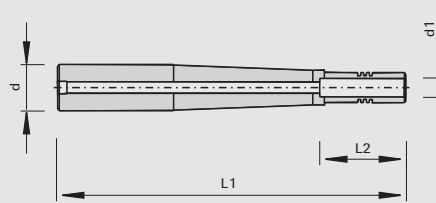
[pc.]

933299

TRIBOS extension

Product

Drawing



LEUCO
CNC

Machine / Application

for mounting of shank-type tools with cylindrical shank in Sino, TRIBOS, PS 2000-E

Design

shank diameter tolerance h7 or g7

Advantages

Notes

minimum clamping length = L2
clamping and unclamping of the tools with TRIBOS clamping device

Ø d1	L2	Ø d	L1	Ident-No.
6	27	20	100	182800 o
8	27	20	100	182801 o
10	32	20	100	182802 o
12	37	20	100	182803 o
6	27	20	150	182804 o
8	27	20	150	182805 o
10	32	20	150	182806 o
12	37	20	150	182807 o
6	27	20	250	182808 o
8	27	20	250	182809 o
10	32	20	250	182810 o
12	37	20	250	182811 o
[mm]	[mm]	[mm]	[mm]	

Spare parts

Class-No.

PU

Ident-No.

Reducing inserts for Mounting Device	for Ø d = 6	955530	1	183719 o
Reducing inserts for Mounting Device	for Ø d = 8	955530	1	183720 o
Reducing inserts for Mounting Device	for Ø d = 10	955530	1	183721 o
Reducing inserts for Mounting Device	for Ø d = 12	955530	1	180263
				[pc.]

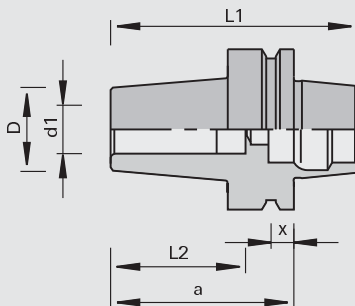
933297

Heat-Shrinking Chucks

Product



Drawing

LEUCO
CNC

Machine / Application

l CNC machining centers with automatic tool changer
l for precise clamping of shank-type tools with cylindrical shank

Design

l n max = 30,000 min-1
l interface DIN 69893 HSK 63 F
l from high-quality hot work tool steel

Advantages

l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

l for clockwise and counter-clockwise rotation
l can be clamped and unclamped with all conventional shrinking devices

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
6,0	36	HSK 63F	20	100	75	18	0.797	186684
8,0	36	HSK 63F	20	100	75	18	0.790	186685
10	41	HSK 63F	26	100	75	18	0.840	183081
12	47	HSK 63F	28	100	75	18	0.830	183082
14	47	HSK 63F	28	100	75	18	0.870	183083
16	51	HSK 63F	28	100	75	18	0.850	183084
18	51	HSK 63F	30	100	75	18	0.960	183085
20	51	HSK 63F	30	100	75	18	0.930	183086
25	51	HSK 63F	30	100	75	18	0.860	183087
25	134	HSK 63F	36	185	160	18	1.943	185520
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	



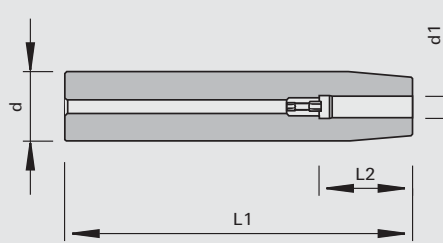
933297

Heat-shrinking chuck extensions CELSIO

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers
- l for milling applications with difficult to reach workpiece areas

Design

- l hot work tool steel with special surface treatment process for particularly long tool life, temperature resistance and form stability
- l run-out accuracy < 0.003 measured in the clamping diameter
- l with adjusting screw for length adjustment

Advantages

- l also shanks with Weldon or Whistle notch can be used
- l best clamping results are achieved with fully cylindrical shanks with tolerance h6
- l slim construction according to DIN 69882-8
- l shrinking of HW and HS tools with shank tolerance h6

Notes

- l clamping elements: we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Ø d1	L2	Ø d	L1	Ident-No.
8	34	25	160	185243 o
10	42	25	160	185244 o
12	47	25	160	185245 o
16	50	25	160	185246 o
[mm]	[mm]	[mm]	[mm]	

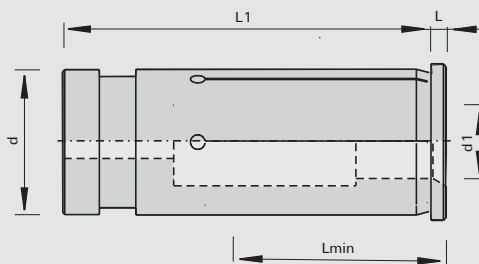
933280

Universal Reducing Bushings

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of shank-type tools in Sino, TRIBOS, ps-System

Design

shank diameter tolerance h7 or g7

Advantages

Notes

Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
3		27	12	45	2.0	183022 o
4		27	12	45	2.0	183023 o
5		27	12	45	2.0	183024 o
6		27	12	45	2.0	183025
8		27	12	45	2.0	183026
8		27	16	47.5	2.5	186099
10		32	16	47.5	2.5	186100
12		37	16	47.5	2.5	186101
3		27	20	50.5	2.0	183027 o
4		27	20	50.5	2.0	183028 o
5		27	20	50.5	2.0	183029 o
6		27	20	50.5	2.0	183030 o
8		27	20	50.5	2.0	183032
10		32	20	50.5	2.0	183034
12		37	20	50.5	2.0	183036
14		37	20	50.5	2.0	183038 o
16		38	20	50.5	2.0	183040
6		27	25	54.5	3.0	182304
8		27	25	54.5	3.0	182305
10		32	25	54.5	3.0	182306
12		37	25	54.5	3.0	182307
14		37	25	54.5	3.0	182308
16		38	25	54.5	3.0	182309
18		38	25	54.5	3.0	182310
20		42	25	54.5	3.0	182311
	1/2"	37	25	54.5	3.0	182653
	3/4"	42	25	54.5	3.0	182655
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	



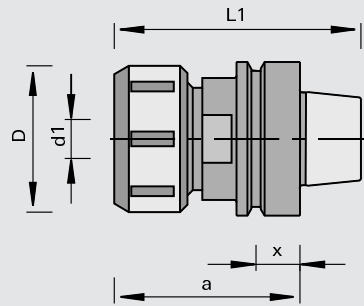
933289

Draw-In Collet Chucks with HSK shank

Product



Drawing

LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l interface according to DIN 69893 HSK 50F, HSK 63F and HSK 63E
- l lock nut with sleeve bearing

Advantages

- l flexible utilization by collet chucks

Notes

- l for right- and lefthand rotation
- l Ident-No. 175795 for IMA (up to 12/94) similar to DIN 69893
- l $\varnothing d1$ = collet chuck diameter 2 - 25 mm
- l collet chucks according to DIN 6388: 1) type 462E/OZ25/2) type 472E/ER40
- l included in delivery: collet chuck, clamping nut without spanner wrench
- l attention: different interfaces in case of CMS machines, according to spindle performance (KW)

$\varnothing d1$	$\varnothing d$	$\varnothing D$	L1	a	x	Type	Ident-No.	
2-25	HSK 63F	60	101	76	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, SCM, CMS (12+15 KW)	173293
2-25	HSK 63E	63	103	78	18	2	CMS (18 KW)	180359
2-25	HSK 63F	60	101	76	9.0	1	IMA up to 12/94	175795
2-25	HSK 63F	60	140	115	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, CMS (12+15 KW)	179170
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

PU

Ident-No.

Clamping Nuts	M48x2R	995290	1	178764
Hook Wrenches	58/62 DIN 1810	985720	1	169299
Hook wrenches adapter	58/62 DIN 1810	985300	1	186765
Torque wrench	40-200 Nm	985300	1	184890
Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	1	178760
Blind plug with screw	11,9x6,9xM5	995300	1	185610
	[mm]			[pc.]

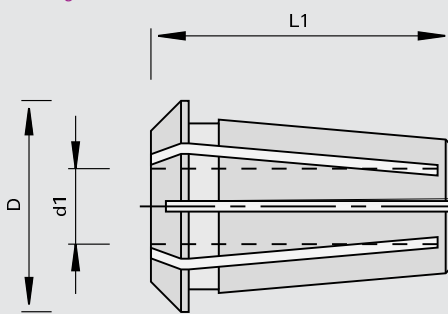
933280

Precision collets - 462E/OZ25

Product



Drawing



LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 462E/OZ25

Design

clamping tolerance 0.5 mm
according to DIN 6388 Type
462E/OZ25

Advantages

optimum transmission of clamp-
ing force thanks to 12 slots from
top and bottom

Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 o
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4"	35.05	52	175815
7		35.05	52	183807 o
8		35.05	52	180358
9,5		35.05	52	175817
	3/8"	35.05	52	185275
10		35.05	52	170782
12		35.05	52	168742
	1/2"	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8"	35.05	52	175823
15		35.05	52	183808 o
16		35.05	52	168743
18		35.05	52	180216
	3/4"	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	



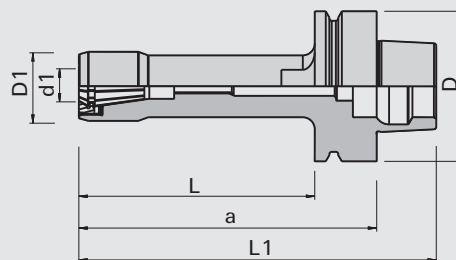
933289

Draw-in collet chuck system 426E/ER16 with HSK 63F - clamping zone Ø 1-10 mm

Product



Drawing



Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 24,000 min-1

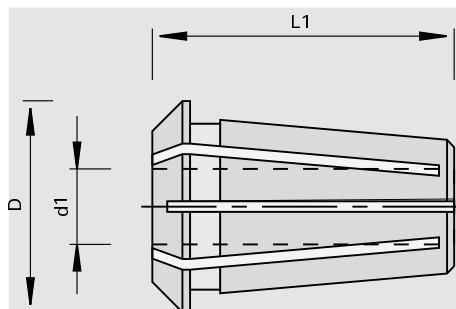
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 426E/ER16: 50 Nm (44 Lbf.ft)

Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
1-10	29	HSK 63F	63	50	101	76	184847
1-10	29	HSK 63F	63	74	125	100	184848
1-10	29	HSK 63F	63	99	150	125	184849
1-10	29	HSK 63F	63	124	175	150	184850
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 426E / ER 16

Ø d1	Ø D	L1	Ident-No.
1	17.25	27.5	184865 o
2	17.25	27.5	184866 o
3	17.25	27.5	184867 o
4	17.25	27.5	184868 o
5	17.25	27.5	184869 o
6	17.25	27.5	184870
7	17.25	27.5	184871 o
8	17.25	27.5	184872
9	17.25	27.5	184873 o
10	17.25	27.5	184874
[mm]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184875
[b] Hand Spanner		985720	1	184878
[c] Torque Nut		985720	1	184884
[d] Screw-in aid		985720	1	184881
[e] torque adapter		985300	1	184887
[f] torque wrench	40-200 Nm [mm]	985300	1	184890
			[pc.]	



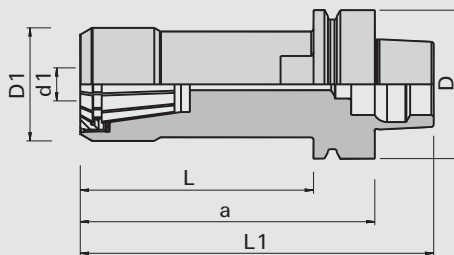
933289

Draw-in collet chuck system 470E/ER32 with HSK 63F - clamping zone Ø 2-20 mm

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 24,000 min-1

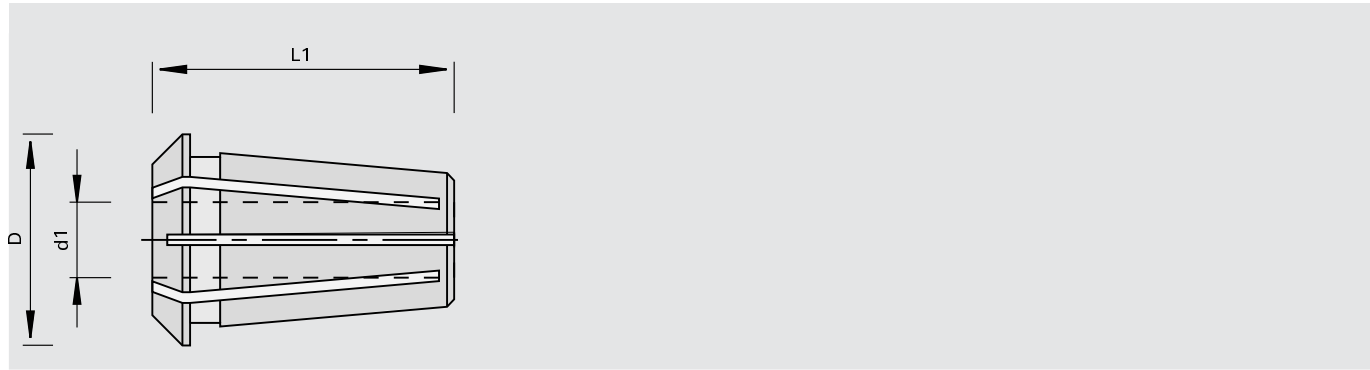
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torque: 470E/ER32:130 Nm (96 Lbf.ft)

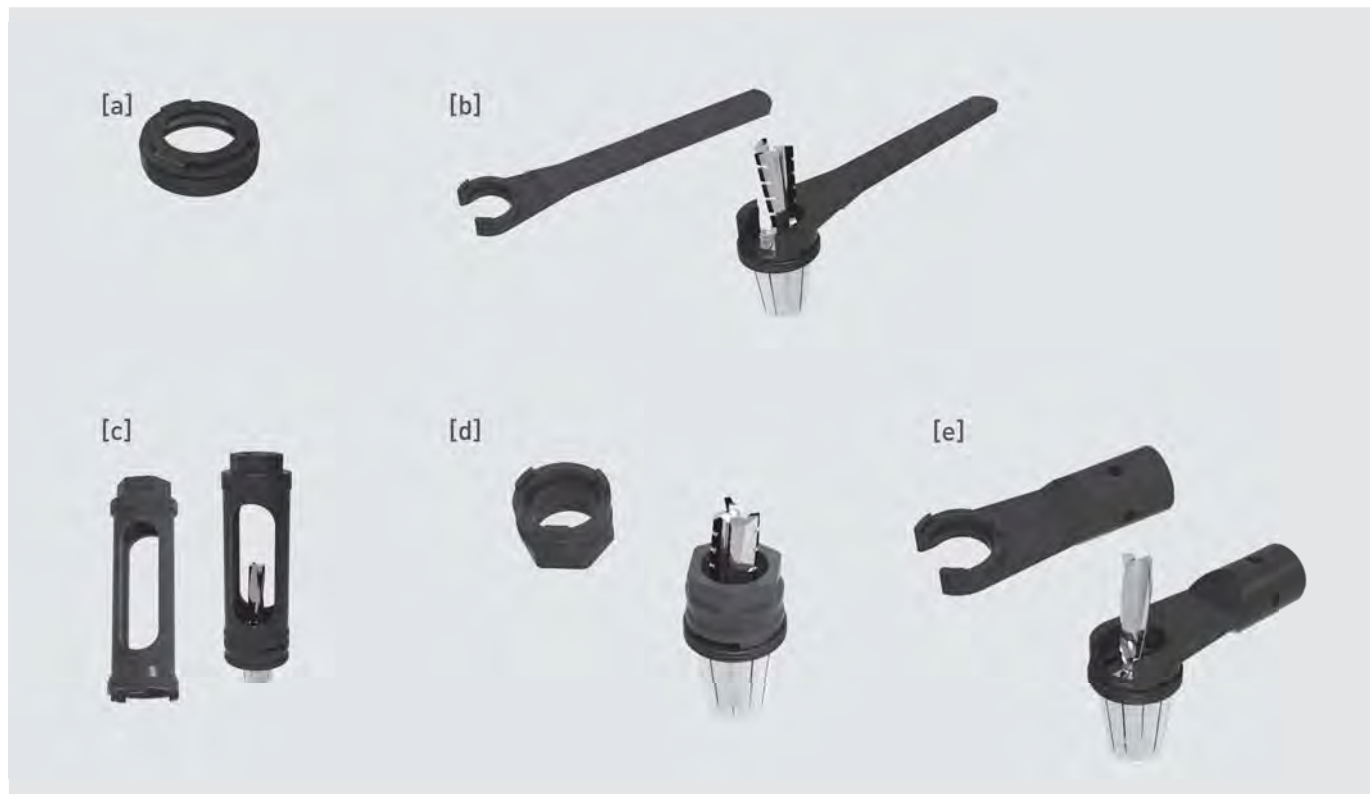
Ø d1	Ø D1	Ø d	Ø D	L	L1	a	Ident-No.
2-20	48	HSK 63F	63	34	85	60	184851
2-20	48	HSK 63F	63	44	95	70	184852 o
2-20	48	HSK 63F	63	89	140	115	184853
2-20	48	HSK 63F	63	99	150	125	184854
2-20	48	HSK 63F	63	124	175	150	184855 o
2-20	48	HSK 63F	63	154	205	180	184856
2-20	48	HSK 63F	63	174	225	200	184857
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 470E / ER 32

Ø d1	Ø D	L1	Ident-No.
3	33	40	173647 o
4	33	40	173648 o
5	33	40	173649 o
6	33	40	173650
7	33	40	173651 o
8	33	40	173652
10	33	40	173653
12	33	40	173654
13	33	40	173655 o
14	33	40	173656 o
16	33	40	173657
18	33	40	173658 o
19	33	40	173659 o
20	33	40	173660
[mm]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184876
[b] Hand Spanner		985720	1	184879
[c] Torque Nut		985720	1	184885
[d] Screw-in aid		985720	1	184882
[e] torque adapter		985300	1	184888
[f] torque wrench	40-200 Nm	985300	1	184890
	[mm]		[pc.]	



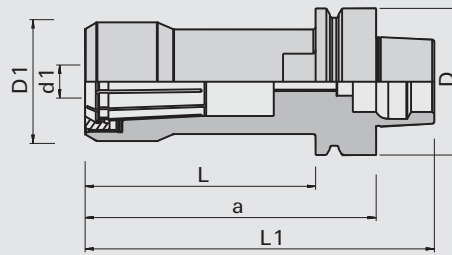
933289

Draw-in collet chuck system 462E/OZ25 with HSK 63F - clamping zone \varnothing 2-25 (1") mm

Product



Drawing


LEUCO
CNC
Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 24,000 min-1

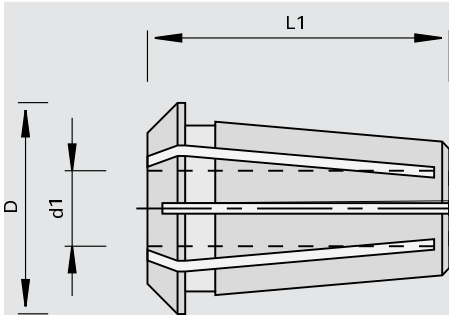
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 462E/OZ25: 150 Nm (110 Lbf.ft)

\varnothing d1	\varnothing D1	\varnothing d	\varnothing D	L	L1	a	Ident-No.
2-25	51	HSK 63F	63	50	101	76	184858
2-25	51	HSK 63F	63	89	140	115	184860
2-25	51	HSK 63F	63	124	175	150	184861 o
2-25	51	HSK 63F	63	149	200	175	184862 o
2-25	51	HSK 63F	63	174	225	200	184863 #
2-25	51	HSK 63F	63	199	250	225	184864
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

**HSK-F63 Collet chucks 462E / OZ 25 /**

\varnothing d1	\varnothing d1	\varnothing D	L1	Ident-No.
2		35.05	52	183803 o
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4"	35.05	52	175815
7		35.05	52	183807 o
8		35.05	52	180358
9,5		35.05	52	175817
10		35.05	52	170782
12		35.05	52	168742
	1/2"	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8"	35.05	52	175823
15		35.05	52	183808 o
[mm]	[inch]	[mm]	[mm]	

HSK-F63 Collet chucks 462E / OZ 25 /

$\varnothing d1$	$\varnothing d1$	$\varnothing D$	L1	Ident-No.
16		35.05	52	168743
18		35.05	52	180216
	3/4"	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	

Accessories	Dimension	Class-No.	PU	Ident-No.
[a] Clamping Nuts		995290	1	184877
[b] Hand Spanner		985720	1	184880
[c] Torque Nut		985720	1	184886
[d] Screw-in aid		985720	1	184883
[e] torque adapter		985300	1	184889
[f] torque wrench	40-200 Nm [mm]	985300	1	184890
			[pc.]	



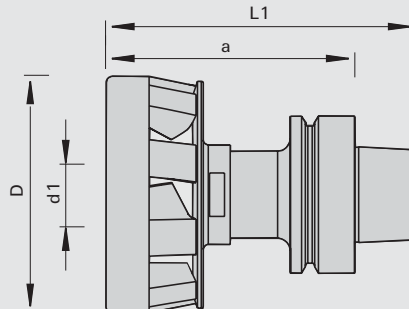
933285

AEROTECH-System Uni-T with HSK 63F with collet chuck adapter

Product



Drawing


Machine / Application

- | CNC machining centers
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production process e.g. with Nesting applications
- | for tools with shank diameter up to 16 mm

Design

- | tool adapter with internal clamping nut
- | 9 wing design for the processing of particle board, MDF, OSB, hard wood etc.
- | tool mounting by means of a wrench socket and of a torque wrench
- | design: standard or FacePlate
- | FacePlate special for Nesting applications

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance

Notes

- | balance quality G=2.5
- | n max. = 24,000 rpm
- | sufficient vacuum performance is necessary for Nesting
- | please observe the information in the operating instructions
- | torque: 80 Nm

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	125	100	Standard	186107
6-16	HSK 63F	95	125	100	FacePlate	186108
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Collet Chucks	4 11E ØD=1	933280	1	184367 o
Collet Chucks	4 11E ØD=2	933280	1	184368 o
Collet Chucks	4 11E ØD=3	933280	1	184369 o
Collet Chucks	4 11E ØD=4	933280	1	184370 o
Collet Chucks	4 11E ØD=5	933280	1	184371 o
Collet Chucks	4 11E ØD=6	933280	1	184372
Collet Chucks	4 11E ØD=8	933280	1	184373
Collet Chucks	4 11E ØD=10	933280	1	184374
Collet Chucks	4 11E ØD=12	933280	1	184375
Collet Chucks	4 11E ØD=16	933280	1	184376
Clamping Nuts	M32x1,5	995290	1	184378
Ratchet	12Zx1/2"	985720	1	186109
Wrench socket	ØD=30, SW22, H96	985720	1	184366
Torque wrench	40-200 Nm	985300	1	184890
	[mm]		[pc.]	

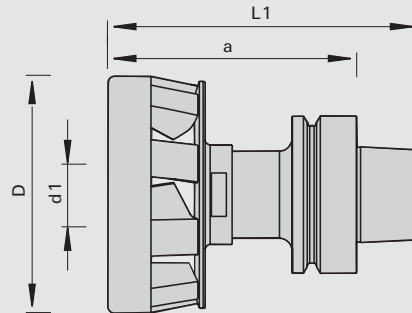
933285

AEROTECH-System with HSK 63F with hydro expansion clamping

Product



Drawing



Machine / Application

- | CNC machining centers
- | for clamping of shank-type tools and simultaneous chip guide when working
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processes e.g. with Nesting applications

Design

- | Monolithic tool clamping system
- | 7-wing design for machining of low-density wood and wood-based materials
- | 9-wing design for machining of particle boards, MDF, OSB, hard wood, etc.
- | Tool mounting by means of hydro expansion clamping technology
- | Balance quality $G < 2.5$

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance
- | minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- | high cutting quality and long edge lives thanks to high concentricity
- | optimum torque transfer

Notes

- | sufficient vacuum performance is necessary
- | pressurization via hexagonal screwdriver (included in delivery)
- | Ident-No. 184757: clamping of smaller shank diameters is possible by means of LEUCO universal reducing sleeves
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	122.6	97.6	9 wings	185018
6-25	HSK 63F	105	131	106	7 wings	186517
6-25	HSK 63F	105	131	106	9 wings	184757
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Screwdrivers with sliding handle for hexagon socket SW4x100
[mm]

985730

1

166091

[pc.]

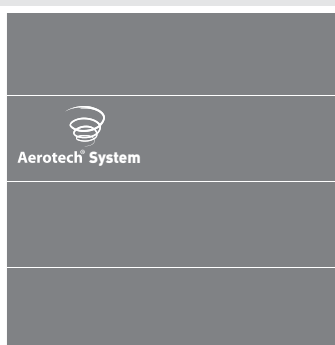
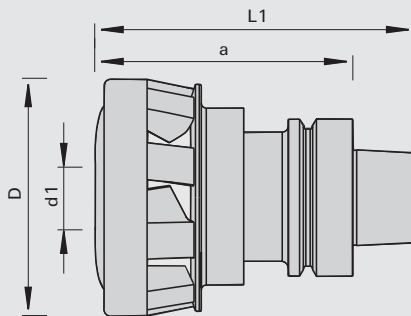
933285

AEROTECH-System FacePlate with HSK 63F with hydro expansion clamping

Product



Drawing



Machine / Application

- | CNC machining centers
- | AEROTECH versions also permitted for new HOMAG machines
- | can be used on all machine brands
- | for clamping of shank-type tools and simultaneous chip guide when working
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processes e.g. with Nesting applications

Design

- | AEROTECH-System FacePlate: particularly for nesting applications
- | patented monolithic tool clamping system
- | 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- | tool mounting by means of hydro expansion clamping technology
- | balance quality G<2.5

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance
- | drawn-in, loose debris can not be trapped in the wing openings
- | this reduces the risk that the turbine is clogged which would lead to an imbalance

Notes

- | sufficient vacuum performance is necessary
- | pressurization via hexagonal screwdriver (included in delivery)
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	127	102	9 wings	185551 o
6-25	HSK 63F	105	135	110	9 wings	185550 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Screwdrivers with sliding handle for hexagon socket SW4x100		985730	1	166091
	[mm]		[pc.]	



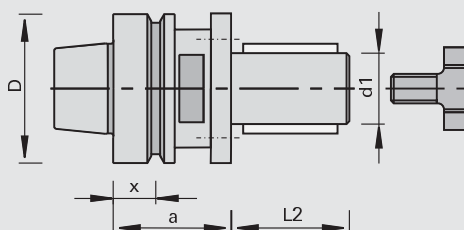
933069

Mounting Arbors with HSK shank

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise mounting of tools with bore with double keyway

Design

- | with 6 pin holes M6 - 8 mm deep TK 48 mm
- | interface DIN 69893 HSK 63 F
- | clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- | secured against rotation with double key

Advantages

- | high feed rates thanks to optimum torque transfer

Notes

- | for clockwise and counter-clockwise rotation
- | spacer ring Ident-No. 181193 consists of: 1 piece 20 mm thick, 1 piece 10 mm thick, 3 piece 5 mm thick, 2 piece 2 mm thick, 1 piece 1 mm thick
- | spacer ring set Ident-No. 181194 additionally 1 piece 20 mm thick, 1 piece 10 mm thick
- | tool attached with retaining bolt
- | included in delivery: clamping arbor with retaining bolt

Ø D	Ø d	Ø d1	L2	a	x	DKN	Weight	Ident-No.	
63	HSK 63F	30	50	45	18	8 x 3	1.4	Homag, IMA from 01/95	183748
63	HSK 63F	30	80	45	18	8 x 3	1.5	Homag, IMA from 01/95, HOLZ-HER	183749
63	HSK 63F	30	110	45	18	8 x 3	1.8	Homag, IMA from 01/95, HOLZ-HER	183747
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	1	178760
Spacer Sets	60x50x30	955521	1	181193
Spacer Sets	60x80x30	955521	1	181194
Cutter Retaining Bolts with centering ring	M16x38xØ48	995190	1	184061
	[mm]		[pc.]	

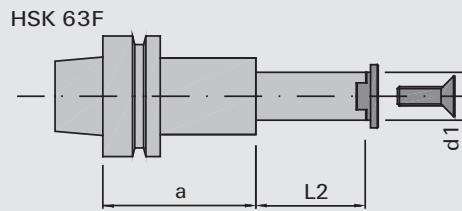
997300

Mounting Arbors HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

l CNC machining centers with automatic tool changer
l for mounting of Modula sets or single cutters

Design

l interface DIN 69893 HSK 63 F
l secured against rotation with double key

Advantages

Notes

l for right- and lefthand rotation
l included in delivery: mounting arbor with cover and countersunk screw

Ø d	Ø d1	L2	a	Weight	Ident-No.
HSK 63F	25	37	45	1.1	183768
HSK 63F	25	85	45	1.2	183769
HSK 63F	25	37	80	1.3	183770 s
HSK 63F	25	75	80	1.5	183771
[mm]	[mm]	[mm]	[mm]	[kg]	

Accessories

Dimension

Class-No.

PU

Ident-No.

Spacers	Ø40x0,1xØ25	955520	1	183756
Spacers	Ø40x0,2xØ25	955520	1	183757
Spacers	Ø40x0,5xØ25	955520	1	183758
Spacers	Ø40x1,0xØ25	955520	1	183759
Spacers	Ø40x2,0xØ25	955520	1	183760
Spacers	Ø40x4,0xØ25	955520	1	183761
Spacers	Ø40x6,0xØ25	955520	1	183762
Spacers	Ø40x10xØ25	955520	1	183763 s
Spacers	Ø40x20xØ25	955520	1	183764
	[mm]		[pc.]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Lid	33x11x25	997300	1	183772 o
Countersunk Screws	M10x30 DIN EN ISO 10642	995121	10	183773 o
Screwdrivers	SW6x200	985730	1	167817
	[mm]		[pc.]	

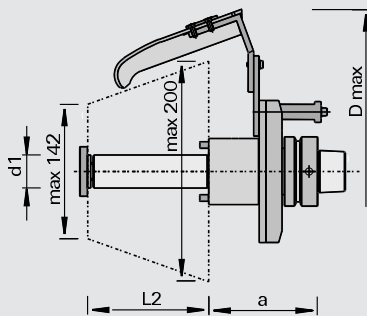
933069

Milling Assemblies with chip directing steel sheet

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC-machining centers with C-axis Homag
- l for precise mounting of tools with bore

Design

- l milling aggregate with integrated chip guiding plate
- l Ident-No. 182049 and 182050 with double keyway
- l Ident-No. 182075 and 182076 with lid and retaining bolt; 2 carrier pins Ø6 TK 48
- l n max = 11,000 min-1 (stock design)
- l shank 30 mm, shank length 105 mm

Advantages

- l optimized chip removal

Notes

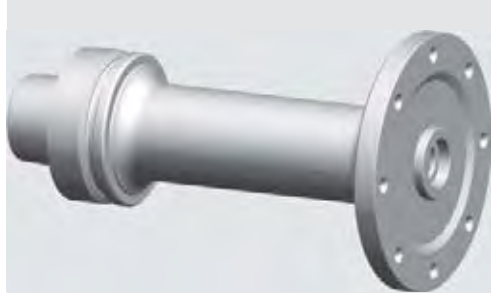
- l weight of the component approx. 2 kg (depending on design)
- l max. weight of the clamped tool 3,8 kg

Ø Dmax	Ø d	Ø d1	L2	a	DKN		Ident-No. [L]	Ident-No. [R]
300	HSK 63F	30	105	80	8 x 4	Homag	182049 o	182050 o
300	HSK 63F	30	105	80		Homag	182075 o	182076 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

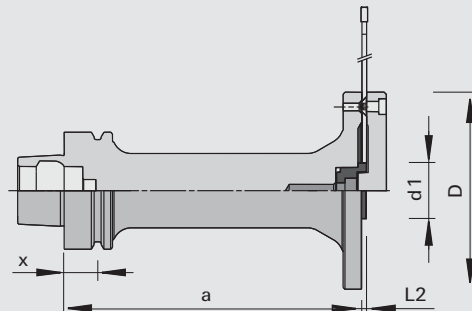
933061

CNC Combi Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise mounting of circular saw blades

Design

- l interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

- l exchangeable centering adapter can be obtained separately; thus saw blades with different bore diameters can be used on the same mounting device
- l the mounting of the saw blade can be made with or without lid
- l adapter available with different a measures

Notes

- l for right- and lefthand rotation
- l mounting of the saw directly by means of countersunk screws or lid by means of cylinder head screw
- l included in delivery: lid, countersunk screws, cylinder head screws and centering adapter for saw blade bore Ø 30 mm with retaining ring

Ø D	Ø d	Ø d1	L2	a	x	NL	Ident-No.
106	HSK 63F	30	2,5	40	18	8/M5/90	184835
106	HSK 63F	30	2,5	50	18	8/M5/90	184836
106	HSK 63F	30	2,5	100	18	8/M5/90	184837
106	HSK 63F	30	2,5	130	18	8/M5/90	184838
106	HSK 63F	30	2,5	160	18	8/M5/90	184839
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Options	Dimension	Class-No.	PU	Ident-No.
Lid	106x15x20	997300	1	184845
Adapter for body thickness 2.0 or 2.2 mm	Ø30	997300	1	185666
Adapter	Ø30	997300	1	184840
Adapter	Ø31,75	997300	1	184841
Adapter	Ø32	997300	1	184842
Adapter	Ø35	997300	1	184843
Adapter	Ø40	997300	1	184844
	[mm]		[pc.]	
Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x12 T20	995125	10	166709
Head Cap Screws	M5x16 DIN EN ISO 4762	995111	10	001870
Head Cap Screws for adapters	M8x12 DIN 7984	995111	10	184846
Locking Rings	8/13x8,4x0,7	995460	1	185497
	[mm]		[pc.]	

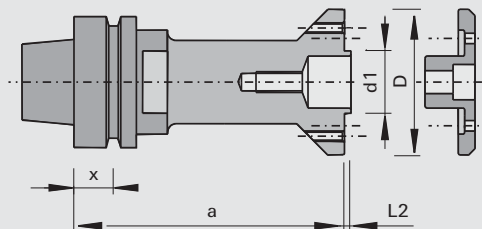
933061

Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

- for CNC machining centers with automatic tool changer
- for precise mounting of circular saw blades and grooving cutters

Design

- interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

Notes

- for clockwise and counter-clockwise rotation
- mounting of the saw directly by means of countersunk screw or lid 183310 by means of cylinder head screw
- included in delivery:
 - adapter with countersunk screws
 - lid with cylinder head screws to be ordered separately

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
70	HSK 63F	30	1,8	70	8/M5/52 + 2/6/42	186083
70	HSK 63F	30	1,8	130	8/M5/52 + 2/6/42	186432
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

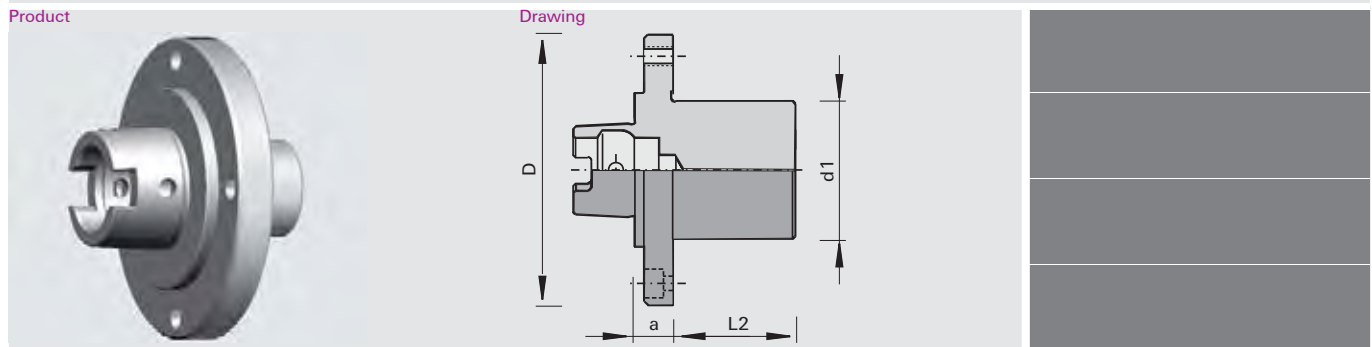
Dimension	Class-No.	PU	Ident-No.	
Countersunk Screws	M5x8 T20	995125	10	164005
	[mm]		[pc.]	

Accessories

Dimension	Class-No.	PU	Ident-No.	
Lid with cylinder head screws	70x24x8 (2/6/42)	997300	1	183310
	[mm]		[pc.]	

933061

Mounting Arbors HSK 63F modified - without gripper groove

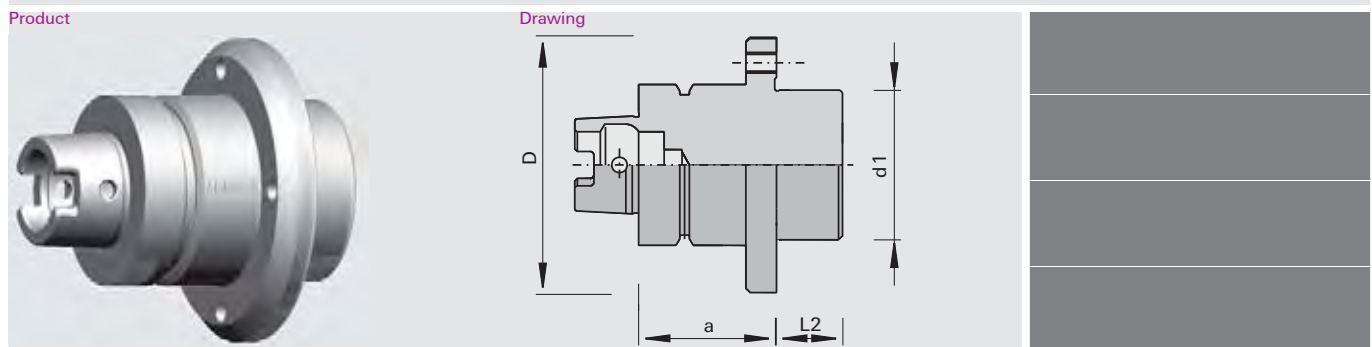


Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> through-feed machines with tool changer Homag d1=30 mm especially for Homag and IMA jointing aggregates d1=60 mm especially for flooring manufacturing for precise clamping of tools with bore 	<ul style="list-style-type: none"> interface DIN 69893 HSK 63 F modified for highly precise mounting on the machine spindle 	<ul style="list-style-type: none"> quick tool change maintenance-free 	<ul style="list-style-type: none"> for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
94	HSK 63F	30	25	16	4/M8/80	furniture 184787
120	HSK 63F	60	68	20	4/M8/100 + 4/9/100	Flooring 183616
[mm]	[mm]	[mm]	[mm]	[mm]		

933061

Mounting Arbors HSK 63F modified - with gripper groove



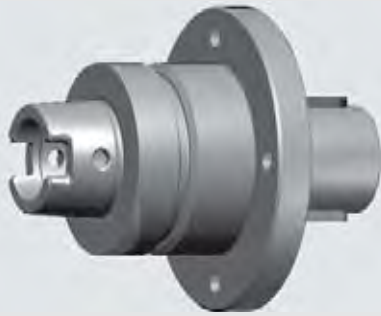
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> through-feed machines with tool changer Homag for precise clamping of tools with bore 	<ul style="list-style-type: none"> with pulling grooves flange with fastening screw thread interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle 	<ul style="list-style-type: none"> quick tool change 	<ul style="list-style-type: none"> for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
115	HSK 63F	60	23,5	54	4/M8/80 + 4/M8/100	183615
[mm]	[mm]	[mm]	[mm]	[mm]		

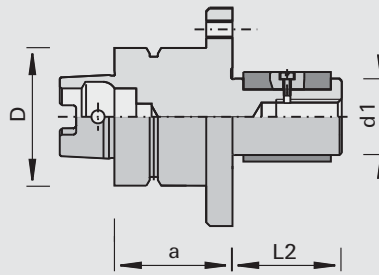
933061

Mounting Arbors HSK 63F modified - 35 DKN, with lid and screws

Product



Drawing



Machine / Application

- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design

- with pulling grooves
- flange with fastening screw thread
- interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle

Advantages

- quick tool change

Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
63	HSK 63F	35	40	54	8/M8/80	182689
63	HSK 63F	35	50	54	8/M8/80	182124
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Head Cap Screws	M16x30	995111	10	182126 o
Lid	60x15x17 [mm]	997370	1	182127 o
			[pc.]	

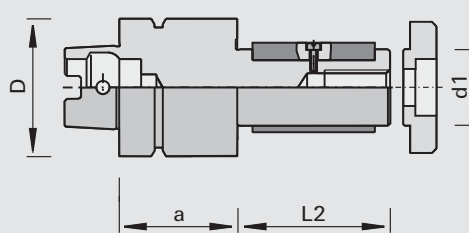
933069

Mounting Arbors HSK 63F modified - 35 DKN, tool directly attached by screws

Product



Drawing



Machine / Application

- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design

- with pulling grooves
- with lid and screw (included in delivery)
- interface DIN 69893 HSK 63 F modified for high-precision adapter to the machine spindle

Advantages

- quick tool change

Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	a	Ident-No.
63	HSK 63F	35	40	54	182123
63	HSK 63F	35	70	54	182125 #
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

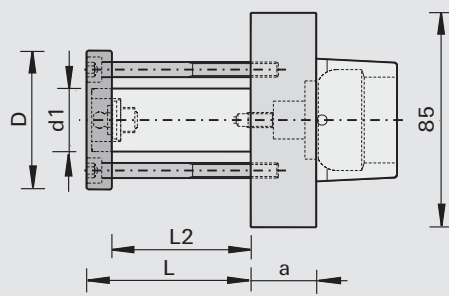
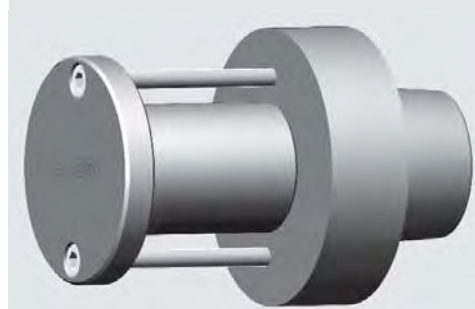
Head Cap Screws	M16x30	995111	10	182126 o
Lid	60x15x17 [mm]	997370	1	182127 o
			[pc.]	

997300

Hydro Tensile Spindles Weinig HSK - clamping length 40-55 mm

Product

Drawing



Machine / Application

- planing machines Weinig Powermat
- for precise clamping of tools with bore

Design

- with hydro-tensile spindle
- n max = 6,000 min-1

Advantages

- precise mounting of tools with bore thanks to hydro-tensile spindle

Notes

- for clockwise and counter-clockwise rotation
- accessories: dummy piece for covering the HSK-interface on spindles not used

Ø D	Ø d	Ø d1	L2	a	Ident-No.
85	Weinig HSK	30	40	26	181872 o
85	Weinig HSK	30	55	26	181873 o
85	Weinig HSK	40	55	26	181874 o
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

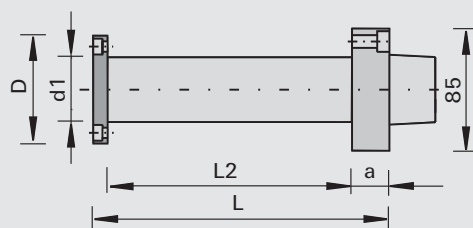
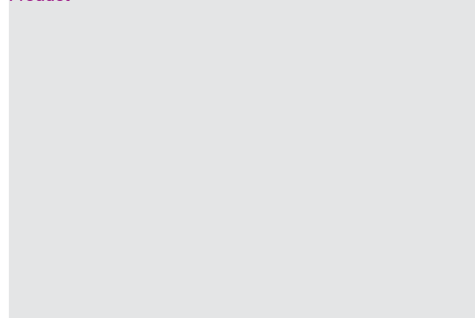
	Class-No.	PU	Ident-No.
Dummy Pieces (cover)	997300	1	182286 o
		[pc.]	

997300

Hydro Tensile Spindles Weinig HSK - clamping length 170-210 mm

Product

Drawing



Machine / Application

- planing machines Weinig Powermat
- for precise clamping of tools with bore

Design

- with hydro-tensile spindle

Advantages

- precise mounting of tools with bore thanks to hydro-tensile spindle

Notes

- for clockwise and counter-clockwise rotation
- accessories: dummy piece for covering the HSK-interface on spindles not used

Ø D	Ø d	Ø d1	L2	a	Ident-No.
85	Weinig HSK	40	170	26	181875 o
85	Weinig HSK	50	170	26	181877 o
85	Weinig HSK	50	210	26	181973 o
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

	Class-No.	PU	Ident-No.
Dummy Pieces (cover)	997300	1	182286 o
		[pc.]	

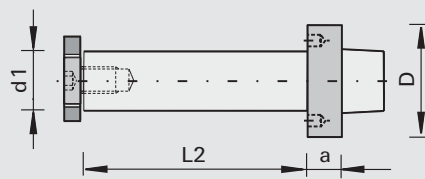
997300

Mounting Arbors Weinig HSK

Product



Drawing



Machine / Application

l profile machines Weinig
Powermat
l for mounting of tools with bore

Design

Advantages

Notes

l for right- and lefthand rotation
l other dimensions on request
l for permissible RPM please refer to diagram
l attention: please observe the recommended tightening torque 80 Nm!

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	30	40	26	2/6/48 + 2/M6/48	1.7	182056
85	Weinig HSK	30	60	26	2/6/48 + 2/M6/48	1.8	182057
85	Weinig HSK	30	80	26	2/6/48 + 2/M6/48	1.9	182058 o
85	Weinig HSK	30	130	26	2/6/48 + 2/M6/48	2.2	182059 o
85	Weinig HSK	30	170	26	2/6/48 + 2/M6/48	2.4	182060 o
85	Weinig HSK	30	240	26	2/6/48 + 2/M6/48	2.8	182061 o
85	Weinig HSK	40	40	26	2/6/54 + 2/M6/54	1.9	182062
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.1	182063
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.3	182064
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	2.8	182065
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.2	182066 o
85	Weinig HSK	40	240	26	2/6/54 + 2/M6/54	3.9	182067 o
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

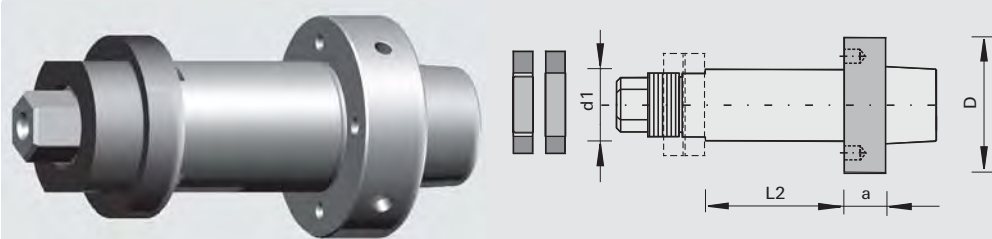


997300

Mounting Arbors Weinig HSK - with spindle nut

Product

Drawing



Machine / Application

- | profile machines Weinig Powermat
- | for mounting of tools with bore

Design

- | with spindle nut

Advantages

- | stable and secure mounting
- | twist-lock

Notes

- | for right- and lefthand rotation
- | other dimensions on request
- | for permissible RPM please refer to diagram
- | attention: please observe the recommended tightening torque 80 Nm!
- | included in delivery: mounting arbor incl. ring and spindle nut

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	40	30	26	2/6/54 + 2/M6/54	1.9	183281 s
85	Weinig HSK	40	50	26	2/6/54 + 2/M6/54	2.1	183282 s
85	Weinig HSK	40	70	26	2/6/54 + 2/M6/54	2.3	183283 s
85	Weinig HSK	40	90	26	2/6/54 + 2/M6/54	2.5	183284 s
85	Weinig HSK	40	120	26	2/6/54 + 2/M6/54	2.8	183285 s
85	Weinig HSK	40	140	26	2/6/54 + 2/M6/54	2.95	183286 s
85	Weinig HSK	40	160	26	2/6/54 + 2/M6/54	3.2	183287 s
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.3	183288 s
85	Weinig HSK	40	200	26	2/6/54 + 2/M6/54	3.6	183289 s
85	Weinig HSK	40	220	26	2/6/54 + 2/M6/54	3.8	183290 s
85	Weinig HSK	40	230	26	2/6/54 + 2/M6/54	3.9	183291 s
85	Weinig HSK	40	260	26	2/6/54 + 2/M6/54	4.2	183292 s
85	Weinig HSK	40	300	26	2/6/54 + 2/M6/54	4.6	183293 s
85	Weinig HSK	50	30	26	2/6/74 + 2/M6/64	2.1	183294 s
85	Weinig HSK	50	50	26	2/6/74 + 2/M6/64	2.4	183295 s
85	Weinig HSK	50	70	26	2/6/74 + 2/M6/64	2.7	183296 s
85	Weinig HSK	50	90	26	2/6/74 + 2/M6/64	3.0	183297 s
85	Weinig HSK	50	120	26	2/6/74 + 2/M6/64	3.5	183298 s
85	Weinig HSK	50	140	26	2/6/74 + 2/M6/64	3.75	183299 s
85	Weinig HSK	50	160	26	2/6/74 + 2/M6/64	4.1	183300 s
85	Weinig HSK	50	170	26	2/6/74 + 2/M6/64	4.3	183301 s
85	Weinig HSK	50	200	26	2/6/74 + 2/M6/64	4.7	183302 s
85	Weinig HSK	50	220	26	2/6/74 + 2/M6/64	5.0	183303 s
85	Weinig HSK	50	230	26	2/6/74 + 2/M6/64	5.13	183304 s
85	Weinig HSK	50	260	26	2/6/74 + 2/M6/64	5.6	183305 s
85	Weinig HSK	50	300	26	2/6/74 + 2/M6/64	6.3	183306 s
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

Spare parts

Dimension

Class-No.

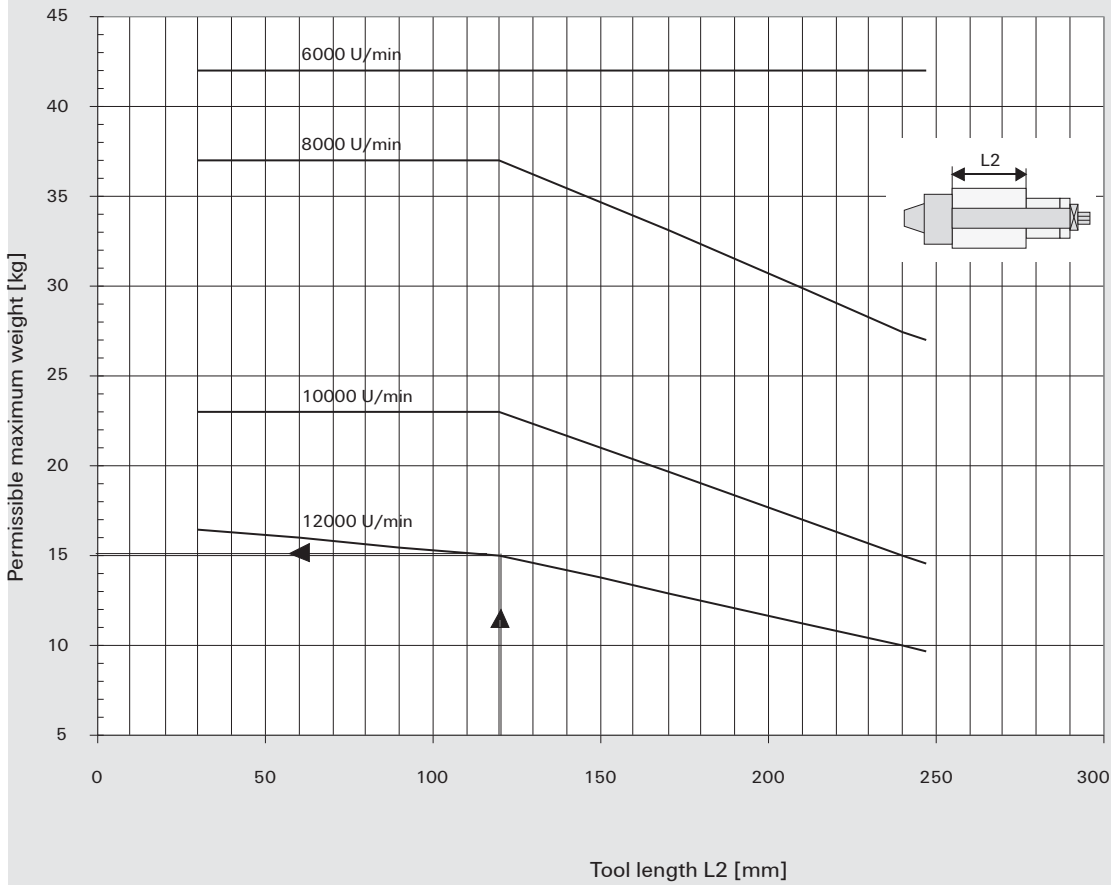
PU

Ident-No.

Set Screws	M6x16 SW3	995161	10	001617
rings	60x15x35	955520	1	183308 o
Spindle Nuts	M33x1,5	995210	1	183307 o
	[mm]		[pc.]	

Adapter Weinig HSK

Diagram for PowerLock-Adapter



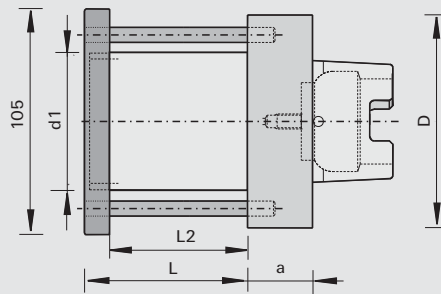
997300

Saw Blade Adapters Weinig HSK

Product



Drawing



Machine / Application

! Weinig Powermat
! for mounting of thin-kerf saw blades

Design

Advantages

Notes

! for clockwise and counter-clockwise rotation
! different diameters upon request

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
105	Weinig HSK	60	68	26	3/8/74	182974 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

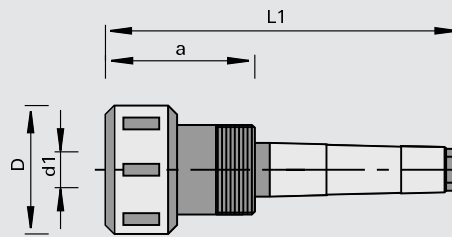
Clamping Nuts	105x15xM58x1,5	995290	1	182993 o
	[mm]		[pc.]	

933250

Draw-In Collet Chucks with MK shank

Product

Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers
- | routers
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | lock nut with sleeve bearing

Advantages

- | high concentricity thanks to ball-bearing mounted lock nut

Notes

- | for clockwise and counter-clockwise rotation
- | collet chucks DIN 6388 Type 415E/OZ16
- | included in delivery: collet chuck with lock nut

Ø D	Ø d	Ø d1	L1	a	Type	Ident-No.
43	MK 2	2-16	119	50	415E/OZ16	170784 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Union Nuts hexagonal	W 1 1/8"/M30x1,5	995290	1	165561
Ball-bearing Clamping Nuts	M30x1,5R	995290	1	178763
Hook Wrenches	40/42 DIN 1810	985720	1	169298
	[mm]		[pc.]	

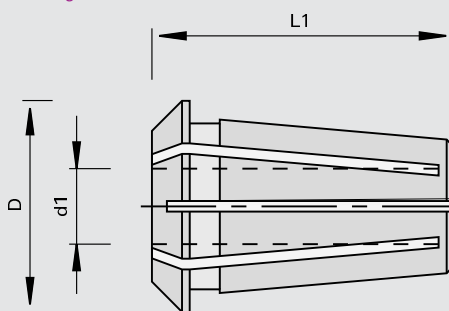
933280

Precision collets - 415E/OZ16

Product



Drawing



LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 415E/OZ16

Design

slotted from top and bottom
clamping tolerance 0.5 mm
according to DIN 6388 Type
415E/OZ16

Advantages

Notes

$\varnothing D$	$\varnothing d1$	L1	Ident-No.
25.5	2,5	40	820753 o
25.5	3	40	820754 o
25.5	4	40	820494 o
25.5	4,5	40	830236 o
25.5	5	40	820495 o
25.5	6	40	170779 o
25.5	6,35	40	821421 o
25.5	7	40	829692 o
25.5	8	40	170780
25.5	9	40	825190 o
25.5	9,5	40	168739 o
25.5	10	40	170781
25.5	12	40	168740
25.5	12,7	40	830156 o
25.5	13	40	821221 o
25.5	16	40	168741
[mm]	[mm]	[mm]	



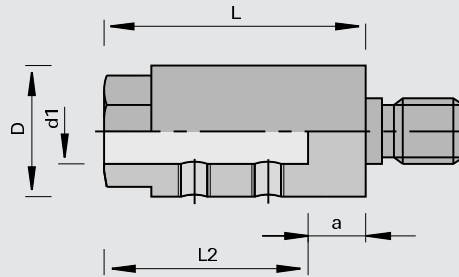
933350

Clamping Chuck Combi Systems

Product



Drawing



Machine / Application

for mounting of drill bits with cylindrical shank and clamping surface

Design

drill bits are clamped with setscrews

Advantages

Notes

clamping chucks with "BSS" mark are compatible with quick-changing system for drill bits
for threaded shank design and appropriate machines see Technical Information

Ø D	Ø d1	L2	L	a	Type	Ident-No. [L]	Ident-No. [R]	
15	8	20	22	2.0	D	161282 o	161281 o	
15	8	20	24.5	4.5	A	010683 o	010677 o	
15	8	20	24.5	4.5	B	161285 o	161284 o	
15	8	20	24.5	4.5	C	058412 o	058411 o	
15	8	20	37	17	C	059300	059299	
19	10	20	24.5	4.5	A	003575	003574	
19	10	20	24.5	4.5	B	008003	008002	
19	10	20	24.5	4.5	C	058414	058413	
19	10	20	25	5.0	D	003571	003570	
19	10	20	25	5.0		cyl. shank Ø 10x30	183055 o	183055 o
19	10	20	47	27	G	161287	161286	
19	10	20	29.3	9.3	F	003573	003572	
19	10	20	28.5	8.5	E	161987 o	161283 o	
19	10	20	37	17	C	161681	161680	
19	10	20	47	27	D	BSS	170372 s	170371 s
[mm]	[mm]	[mm]	[mm]	[mm]				

Spare parts

Dimension

For Ø D

Class-No.

PU

Ident-No.

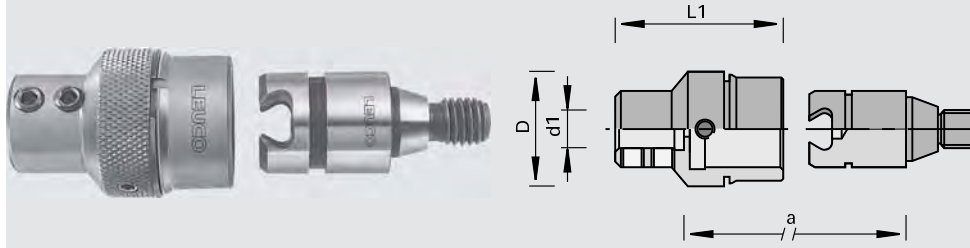
Set Screws	M6x4 DIN EN ISO 4029	15	995161	10	167068
Set Screws	M6x5 DIN EN ISO 4029	19	995161	10	165049
Set Screws	M5x4 DIN EN ISO 4029	15	995161	10	001608
	[mm]	[mm]		[pc.]	

933321

Klack Quick-Changing Chucks with hole pitch 32 mm

Product

Drawing



Machine / Application

- for boring machines
- for mounting of drill bits with cylindrical shank and clamping surface

Design

- for mounting of drill bits with cylindrical shank and clamping surface

Advantages

- low downtimes thanks to fast drill bit changes

Notes

- for larger hole pitch widths (32 mm)
- top part is drill bit seat
- bottom part to install on the machine spindle
- for threaded shank design and appropriate machines see technical information

$\varnothing D$	$\varnothing d1$	L1	Ident-No.		
30	10	44	003567		
[mm]	[mm]	[mm]			
Bottom part	Type	a	Class-No.	Ident-No. [L]	Ident-No. [R]
	D	26.5	933322	003561 #	003560 #
		[mm]			
Spare parts	Dimension	Class-No.	PU	Ident-No.	
Reducing Bushing		955530	1	057513 s	
Set Screws	M6x5 DIN EN ISO 4029	995161	10	165049	
Set Screws	M5x8 DIN EN ISO 4028	995161	10	180015	
Screws	M8x24L	995191	10	180013 #	
Screws	M8x24R	995191	10	180012 #	
	[mm]			[pc.]	



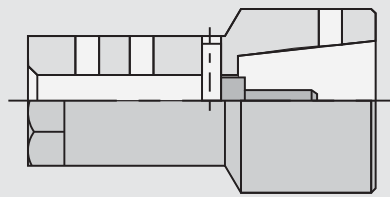
933321

Drill Bit Quick-Changing Systems - top part

Product



Drawing



Machine / Application

l boring machines
l for mounting of drill bits with cylindrical shank with clamping screws

Design

l for clamping of the drill bit with hex socket setscrews

Advantages

l low downtimes thanks to fast drill bit changes

Notes

l for larger hole pitch widths (32 mm)
l top part is drill bit seat
l bottom part to install on the machine spindle
l for threaded shank design and appropriate machines see technical information

	Dimension	Ident-No.
locating bore	Ø10	168669
locating bore	Ø8	168668
	[mm]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Collet Chucks	Ø3	933380	1	168666 o
Collet Chucks	Ø2,5	933380	1	168665 o
Engineers Wrenches	9x11 DIN 3118	985720	1	168672 o
Engineers Wrenches	11x13 DIN 3118	985720	1	168670 o
Engineers Wrenches	14x17 DIN 3118	985720	1	168671 s
	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M6x5 DIN EN ISO 4029	995161	10	165049
Set Screws	M5x4 DIN EN ISO 4029	995161	10	001608
	[mm]		[pc.]	

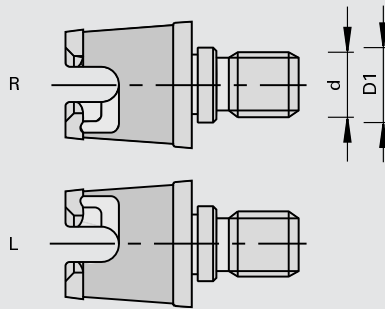
933322

Drill Bit Quick-Changing Systems - bottom part

Product



Drawing



Machine / Application

for boring machines
for installation on the machine spindle

Design

conical design

Advantages

Notes

for threaded shank design
and appropriate machines see
technical information

Type	$\varnothing d$	$\varnothing D1$	Ident-No. [L]	Ident-No. [R]
C	M8	9.0	168662	168663
D	M10	11	170243 #	170242 #
	[mm]	[mm]		

Spare parts

Dust Protection Cap
Wrench

Class-No.

997800
985730

Ident-No.

170283
168673 &

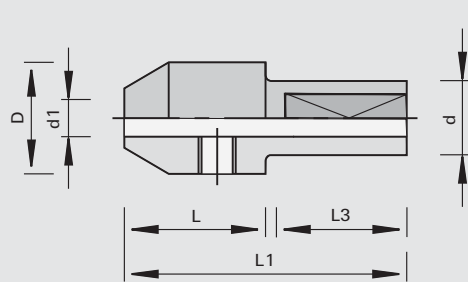
933389

Adapters

Product



Drawing



Machine / Application

for mounting of twist drills in
combi chuck and Klack chuck

Design

shank with clamping surface
thread M5, without screw

Advantages

Notes

adjusting and attachment
screw Ident-No. 186017
M5x11,5 for Weeke quick
clamping chuck must be
ordered separately

$\varnothing d1$	L	$\varnothing d$	L3	$\varnothing D$	L1	Ident-No.
2	19	10	21	15	41	183275
2,5	19	10	21	15	41	183276
3	19	10	21	15	41	183277
3,5	19	10	21	15	41	183278
4	19	10	21	15	41	183279
5	19	10	21	15	41	183280
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Set Screws
Cranked Wrench Keys

Dimension

M6x6 DIN EN ISO 4029
SW3 DIN ISO 2936
[mm]

Class-No.

995161
985730

PU

10
1
[pc.]

Ident-No.

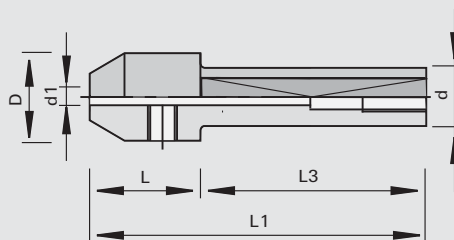
180003
009672

933389

Adapters for micro twist drills

Product

Drawing



Machine / Application

for holding micro twist drills with a shank diameter of 3.175 mm

Design

shank with clamping surface and length adjusting screw M5x10

Advantages

Notes

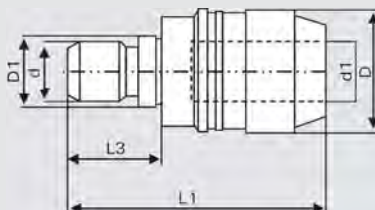
adjusting and attachment screw Ident-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately

933359

Drill Bit Quick-Changing Systems

Product

Drawing



LEUCO
CNC

Machine / Application

boring machines
CNC machining centers
for mounting of drill bits with cylindrical shank and clamping surface

Design

Advantages

low downtimes thanks to fast drill bit changes
no special adjusting screw necessary
for all common drill bits with shank Ø 10 mm and boring Ø < 20 mm

Notes

for threaded shank design and appropriate machines see Technical Information

Ø D	Ø D1	Ø d	Ø d1	L1	L3	Type	Ident-No. [L]	Ident-No. [R]
20	9.0	M8	10	42	15	C	182396 o	182395 o
20		M8	10	42	15	A	182398 o	182397 o
20		10	10	45	18		182400 o	182399 o
20	11	M10	10	42	15	D	182402 o	182401 o
20		M10	10	42	15	B	182404 o	182403 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Class-No. PU Ident-No.

Wrench d10 with clamping surface

985730 1 182405 o
[pc.]

933390

Universal Drill Chucks

Product

Drawing


LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of drill bits with cylindrical shank

Design

- | continuously adjustable clamping area between 1-13 mm
- | n max = 20,000 min⁻¹
- | hardened clamping jaws

Advantages

- | fine balance is easy on spindle and spindle bearing
- | high clamping accuracy over total lifetime of drill chuck thanks to hardened clamping jaws
- | high holding moment
- | no chips and dirt in the clamping zone thanks to special clamping jaws

Notes

- | for clockwise and counter-clockwise rotation
- | included in delivery: clamping key, retaining bolts

Ø D	Ø d	Ø d1	L1		Ident-No.
50	SK 30 (DIN)	1-13	90	Weeke, Maka, Reichenbacher	180375 o
50	SK 30	1-13	90	Biesse from 9/92, Masterwood (HSD motors)	180376 o
50	SK 30	1-13	90	Alberti, Masterwood (Colombo motors)	180377 o
50	SK 30	1-13	90	Morbidelli, SCM (with ring gear)	180378 o
50	SK 40 (DIN)	1-13	90	Maka, Reichenbacher Stegherr	180379 o
57	SK 40 (DIN)	3-16	90	Maka, Reichenbacher Stegherr	180380 o
50	HSK 63F	1-13	112	Homag, EIMA, Weeke, IMA from 9/94	180381
57	HSK 63F	3-16	112	Homag, EIMA, Weeke, IMA from 9/94	180382
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

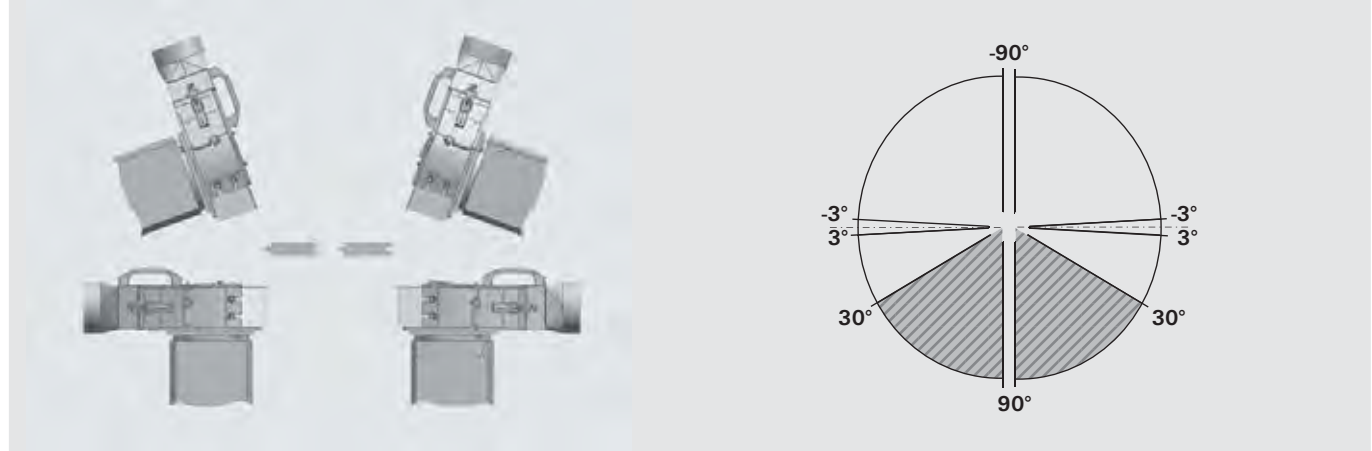
Cranked Wrench Keys	SW6x100	985730	1	180383 o
	[mm]		[pc.]	

**LEUCO dust hoods flooring
production series T16 ... for tools with $\varnothing 230 - \varnothing 250$ mm**



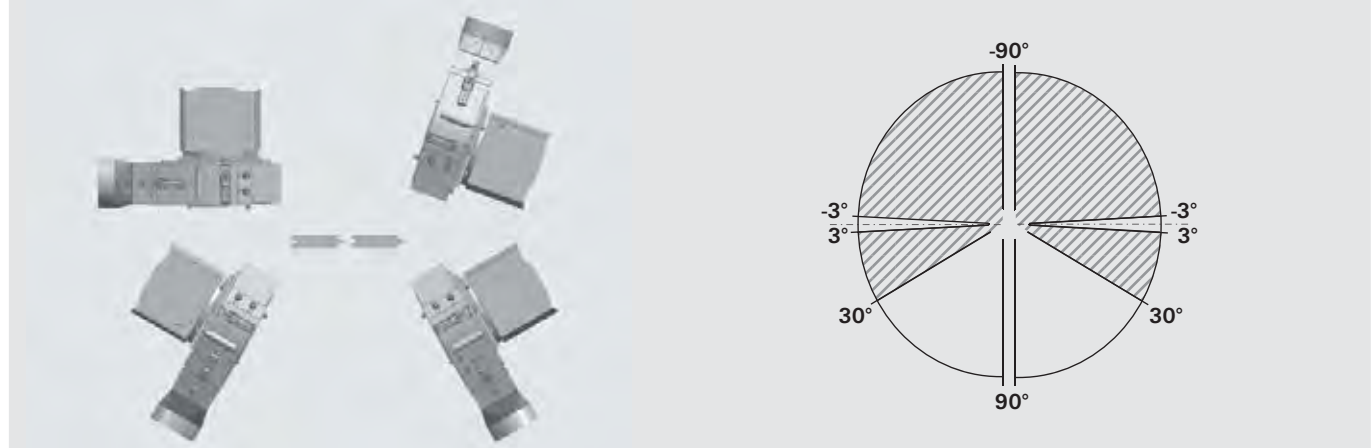
T1601 dust hood with sliding cover

installation section 30° to 90°



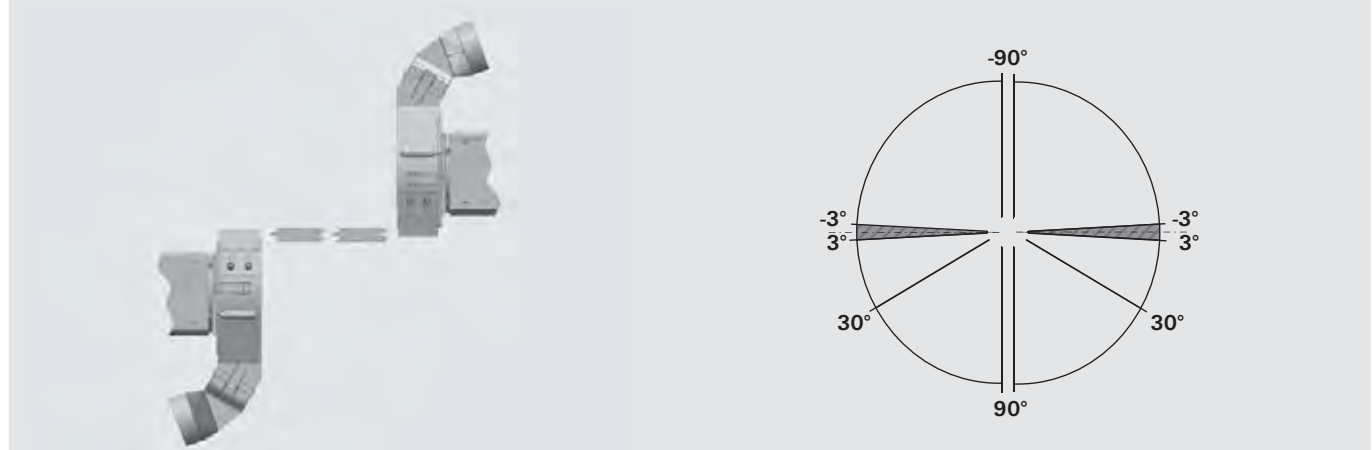
T1602 dust hood with fixed cover

installation section 3° to -30° and -3° to -90°



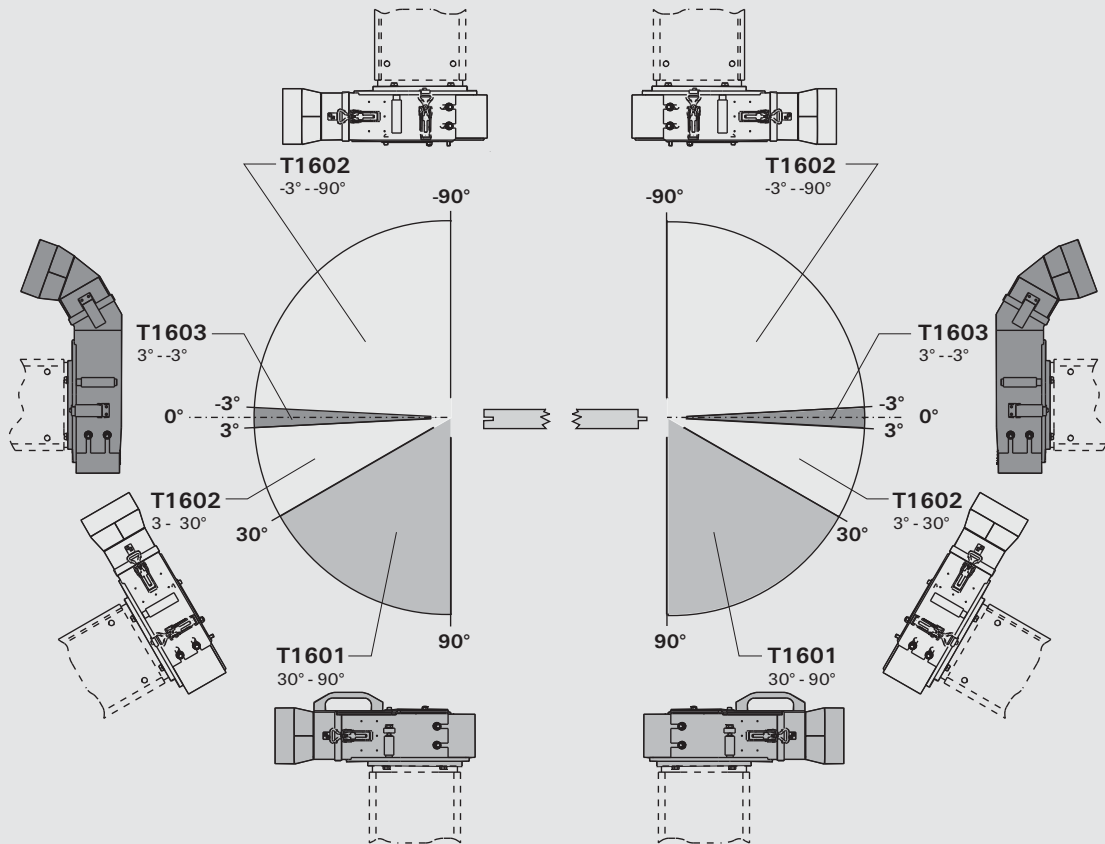
T1603 dust hood without cover

installation section 3° to -3°



Summary of installation sections

Dust hood types - T1601 / T1602 / T1603



- | generally the standard differentiates between three different types of dust hoods
- | the differentiation of the type of dust hood is depending on the a.m. sketched unit installation sections
- | the angle designation resp. the installation angle is attributed to the motor position

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> double end tenoners especially for flooring manufacturing 	<ul style="list-style-type: none"> LEUCO dust hood system symmetrical design wear parts made of 8 mm steel 	<ul style="list-style-type: none"> optimal chip caption thanks to individual adaptation of the dust hood wear parts individually replaceable flow-optimizing design cover with adjustable air supply 	<ul style="list-style-type: none"> basic plate made of steel wear reduction adjustable wear plate

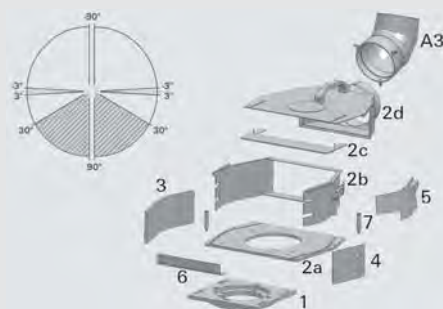
975917

LEUCO dust hood T1601 with sliding cover - flooring

Product



Drawing



Machine / Application

- | double end tenoners
- | especially for flooring manufacturing
- | for tools with Ø230 - Ø250 mm

Design

- | The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, chip guiding plate, C plate and thread bolt
- | symmetrical design
- | wear parts made of 8 mm steel
- | sliding cover for easy handling

Advantages

- | optimal chip caption thanks to individual adaptation of the dust hood
- | wear parts individually replaceable
- | flow-optimizing design
- | cover with adjustable air supply

Notes

- | basic plate made of steel
- | wear reduction
- | adjustable wear plate

	Class-No.	Ident-No.
complete dust hood T1601	975917	185862 s

1 - Flange	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301s
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105 [mm]	975117	540430s

2a - basic plate	Class-No.	Ident-No.
2a - basic plate for basic hood	975217	541421s

2b - middle part	Class-No.	Ident-No.
2b - middle part with sliding cover for basic hood	975217	542288s

2c - sliding plate	Class-No.	Ident-No.
2c - sliding plate short for basic hood	975217	542289s
2c - sliding plate long for basic hood	975217	542692s

2d - sliding cover	Class-No.	Ident-No.
2d - sliding cover for basic hood	975217	542783s

3 - wear plate	Dimension	Class-No.	Ident-No.
3 - wear plate standard complete with feed	S=8,0	975517	540484s
3 - wear plate standard complete against feed	S=8,0	975517	540210s
3 - wear plate standard complete for pre-cutters with feed	S=8,0	975517	542820s
3 - wear plate standard complete for pre-cutters against feed	S=8,0 [mm]	975517	542818s

4 - adjusting plate	Class-No.	Ident-No.
4 - adjusting plate standard (without profile)	975417	540209s

5 - chip guiding plate		Class-No.	Ident-No.
5 - chip directing steel sheet right		975217	542294s
5 - chip directing steel sheet left		975217	542296s
6 - C plate			
	Dimension	Class-No.	Ident-No.
6 - C plate 12	H=12	975417	540213s
6 - C plate 22	H=22	975417	540214s
6 - C plate 32	H=32	975417	540215s
6 - C plate 42	H=42	975417	540216s
6 - C plate 52	H=52	975417	540217s
6 - C plate 62	H=62	975417	540218s
6 - C plate 67	H=67	975417	540219s
	[mm]		
7 - thread bolt			
		Class-No.	Ident-No.
7 - thread bolt		975217	540201s
A - optional components for vacuum air connection			
	Dimension	Class-No.	Ident-No.
A1 - adapter bend	Ø120 / 30°	975317	542675s
A2 - adapter bend	Ø120 / 60°	975317	542793s
A3 - adapter bend	Ø120 / 90°	975317	542794s
A4 - reducing ring	Ø120 / Ø140	975317	542711s
	[mm]		

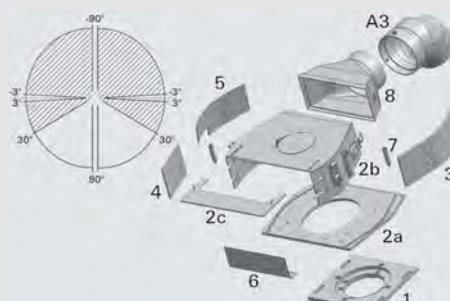
975917

LEUCO dust hood T1602 with fixed cover - flooring

Product



Drawing



Machine / Application

- double end tenoners
- especially for flooring manufacturing
- for tools with Ø230 - Ø250 mm

Design

- The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, chip guiding plate, C plate, thread bolt and connection
- symmetrical design
- wear parts made of 8 mm steel

Advantages

- optimal chip caption thanks to individual adaptation of the dust hood
- wear parts individually replaceable
- flow-optimizing design
- cover with adjustable air supply

Notes

- basic plate made of steel
- wear reduction
- adjustable wear plate

		Class-No.	Ident-No.
complete dust hood T1602		975917	185863 s
1 - Flange			
	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301s
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105	975117	540430s
	[mm]		
2a - basic plate			
		Class-No.	Ident-No.
2a - basic plate for basic hood		975217	541421s

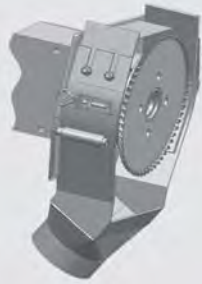


2b - middle part		Class-No.	Ident-No.	
2b - middle part with fixed cover for basic hood		975217	542554s	
2c - sliding plate		Class-No.	Ident-No.	
2c - sliding plate long for basic hood		975217	542692s	
2c - sliding plate short for basic hood		975217	542289s	
3 - wear plate		Dimension	Class-No.	Ident-No.
3 - wear plate standard complete with feed		S=8,0	975517	540484s
3 - wear plate standard complete against feed		S=8,0	975517	540210s
3 - wear plate standard complete for pre-cutters with feed		S=8,0	975517	542820s
3 - wear plate standard complete for pre-cutters against feed		S=8,0	975517	542818s
		[mm]		
4 - adjusting plate		Class-No.	Ident-No.	
4 - adjusting plate standard (without profile)		975417	540209s	
5 - chip guiding plate		Class-No.	Ident-No.	
5 - chip directing steel sheet right		975217	542294s	
5 - chip directing steel sheet left		975217	542296s	
6 - C plate		Dimension	Class-No.	Ident-No.
6 - C plate 12		H=12	975417	540213s
6 - C plate 22		H=22	975417	540214s
6 - C plate 32		H=32	975417	540215s
6 - C plate 42		H=42	975417	540216s
6 - C plate 52		H=52	975417	540217s
6 - C plate 62		H=62	975417	540218s
6 - C plate 67		H=67	975417	540219s
		[mm]		
7 - thread bolt		Class-No.	Ident-No.	
7 - thread bolt		975217	540201s	
8 - connection		Dimension	Class-No.	Ident-No.
8 - connection for extraction connections (vertical)		30° - Ø120	975317	542639s
		[mm]		
A - optional components for vacuum air connection		Dimension	Class-No.	Ident-No.
A1 - adapter bend		Ø120 / 30°	975317	542675s
A2 - adapter bend		Ø120 / 60°	975317	542793s
A3 - adapter bend		Ø120 / 90°	975317	542794s
A4 - reducing ring		Ø120 / Ø140	975317	542711s
		[mm]		

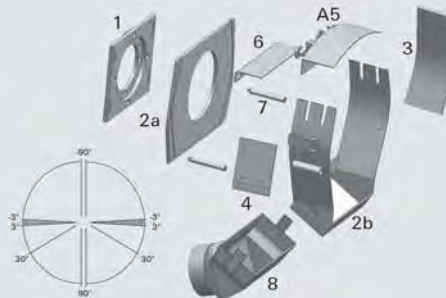
975917

LEUCO dust hood T1603 without cover - flooring

Product



Drawing

**Machine / Application**

- | double end tenoners
- | especially for flooring manufacturing
- | for tools with Ø230 - Ø250 mm

Design

- | The LEUCO modular dust hood system consists of => flange, basic hood, wear plate, adjusting plate, C plate, thread bolt and connection
- | symmetrical design
- | wear parts made of 8 mm steel
- | optional with cover (component A5)

Advantages

- | optimal chip caption thanks to individual adaptation of the dust hood
- | wear parts individually replaceable
- | flow-optimizing design

Notes

- | basic plate made of steel
- | wear reduction
- | adjustable wear plate
- | component 5 chip guiding plate is not needed

	Class-No.	Ident-No.
complete dust hood T1603	975917	185864 s

1 - Flange	Dimension	Class-No.	Ident-No.
1 - flange (Perske 8 - 11 KW)	Ø180x13	975117	540301s
1 - flange (Perske 11 - 15 KW)	Ø180x13 70x105 [mm]	975117	540430s

2a - basic plate	Class-No.	Ident-No.
2a - basic plate for basic hood	975217	541421s

2b - middle part	Class-No.	Ident-No.
2b - middle part without cover for basic hood	975217	541574s

2c - sliding plate	Dimension	Class-No.	Ident-No.
3 - wear plate standard complete with feed	S=8,0	975517	540484s
3 - wear plate standard complete against feed	S=8,0	975517	540210s
3 - wear plate standard complete for pre-cutters with feed	S=8,0	975517	542820s
3 - wear plate standard complete for pre-cutters against feed	S=8,0 [mm]	975517	542818s


4 - adjusting plate	Class-No.	Ident-No.
4 - adjusting plate standard (without profile)	975417	540209s

6 - C plate	Dimension	Class-No.	Ident-No.
6 - C plate 12	H=12	975417	540213s
6 - C plate 22	H=22	975417	540214s
6 - C plate 32	H=32	975417	540215s
6 - C plate 42	H=42	975417	540216s
6 - C plate 52	H=52	975417	540217s
6 - C plate 62	H=62	975417	540218s
6 - C plate 67	H=67 [mm]	975417	540219s

7 - thread bolt		Class-No.	Ident-No.
7 - thread bolt		975217	540201s
8 - connection	Dimension	Class-No.	Ident-No.
8 - connection for extraction connections (vertical)	40° - Ø120 [mm]	975317	542720s
A - optional components for vacuum air connection	Dimension	Class-No.	Ident-No.
A1 - adapter bend	Ø120 / 30°	975317	542675s
A2 - adapter bend	Ø120 / 60°	975317	542793s
A3 - adapter bend	Ø120 / 90°	975317	542794s
A4 - reducing ring	Ø120 / Ø140	975317	542711s
A5 - cover	[mm]	975217	542145s


985700

Cone wiper

Product		Drawing		
				
Machine / Application	Design	Advantages	Notes	
for cleaning of the inner cones of the cone tool adaptors			the highly precise machine spindle and clamping chuck needs dust-free fit	
Ø d			Ident-No.	
SK 30			180907 o	
SK 40			180908 o	
HSK 25			180909 o	
HSK 32			180910 o	
HSK 63			180911	
[mm]				

985202

Mounting devices with clamping lever


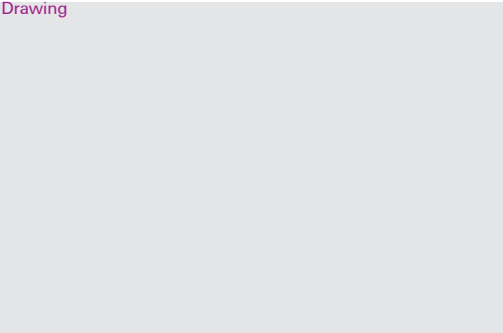
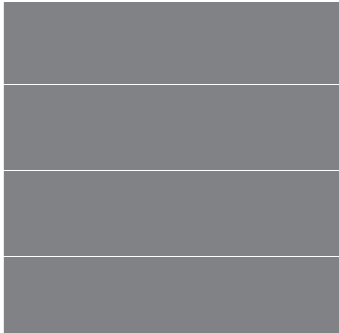
Product		Drawing		
				
Machine / Application	Design	Advantages	Notes	
for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders	with two-part clamping jaws made from high-quality light alloy mounted on stable pedestal which can be fixed onto workbench quick-grip lever for clamping of clamping chucks or holding arbors	variably applicable for all interfaces by simple exchanging of the clamping jaw		
Ø d			Ident-No.	
SK 30 (DIN) / HSK 50F			50 180362 o	
SK 40 (DIN)			63,5 180363 o	
SK 30 with ring gear (Morbidelli, SCM)			49 180364 o	
SK 30 (ISO) CMS / BT 30			46 180365 o	
HSK 63F / 63E			63 180366 o	
BT 35			53 180367 o	
HSK 85 (Weinig)			85 182284 o	
[mm]				



Spare parts	For Ident-No.	Class-No.	PU	Ident-No.
Clamping Jaws (2-parts)	180362	997300	1	180368 o
Clamping Jaws (2-parts)	180363	997300	1	180369 o
Clamping Jaws (2-parts)	180364	997300	1	180370 o
Clamping Jaws (2-parts)	180365	997300	1	180371 o
Clamping Jaws (2-parts)	180366	997300	1	180372 o
Clamping Jaws (2-parts)	180367	997300	1	180373 o
Clamping Jaws (2-parts)	182284	997300	1	182285 o
Pedestal (without clamping jaw)	For all	997300	1	180374 o
			[pc.]	

985202


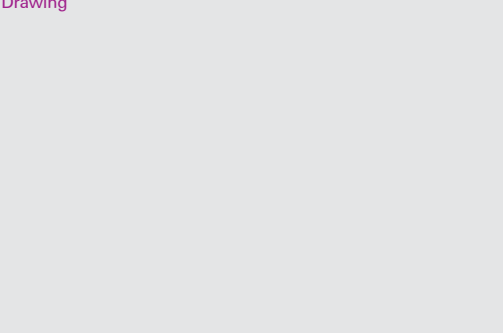
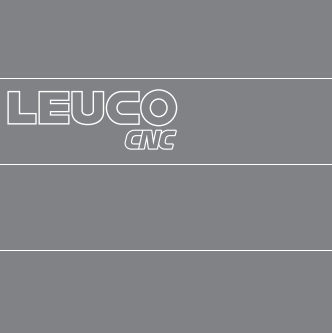
Mounting devices without clamping lever

<p>Product</p> 	<p>Drawing</p> 		
<p>Machine / Application</p> <ul style="list-style-type: none"> for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders 	<p>Design</p> <ul style="list-style-type: none"> mounted on stable pedestal which can be fixed onto workbench 	<p>Advantages</p> <ul style="list-style-type: none"> simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary 	<p>Notes</p> <ul style="list-style-type: none"> for all adapters HSK 63 F

Ø d1	Ident-No.
HSK 63F [mm]	182467

985300


Digital height measuring device

<p>Product</p> 	<p>Drawing</p> 		
<p>Machine / Application</p> <ul style="list-style-type: none"> for quick and precise adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders 	<p>Design</p> <ul style="list-style-type: none"> repeating precision 0.01 mm tungsten carbide-tipped scriber digital display 	<p>Advantages</p> <ul style="list-style-type: none"> simple adjustment and fixing of the height dimension 	<p>Notes</p> <ul style="list-style-type: none"> battery type "LR44" not included in delivery

	Ident-No.
Digital height measuring device	183684

999300

iBlade StarterKit

<p>Product</p> 	<p>Drawing</p>	
--	----------------	--

<p>Machine / Application</p> <p>for simple monitoring and tracking of tool performance</p>	<p>Design</p>	<p>Advantages</p> <p>perfect cost control</p>	<p>Notes</p> <p>the insertion of the chip depends on the tool used</p> <p>in the case of very small/thin tools the memory chip can be attached to a tool card</p>
--	---------------	---	---

			Ident-No.
iBlade StarterKit	software documentation Basic, memory chip V2 (5 pieces), reader Classic USB, activator spray, glue		184784 s

		Class-No.	PU	Ident-No.
Software documentation Basic	annual licence	999300	1	184776s
Software documentation user	annual licence	999300	1	184777s
software documentation dealer/service	annual licence	999300	1	184778s
Reader Classic USB		994721	1	184779s
Reader Bluetooth		994721	1	184780s
Memory Chip Bigstore 8.5	8.5x2.0 mm	994711	10	184781
Glue	20g	993390	1	184782s
Activator spray	200 ml can	993390	1	184783s
				[pc.]

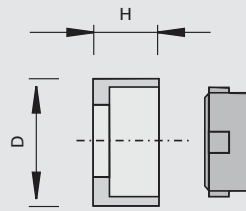


994711

Balluff Chip for mounting in HSK 63F tool adapters

Product

Drawing



LEUCO
CNC

Machine / Application

- CNC machining centers with tool recognition system based on Balluff Chip
- for machines Biesse, Reichenbacher, Homag

Design

- Balluff Chip BIS C-122-04/L, 511 Byte
- for mounting in HSK 63F tool adapters

Advantages

Notes

- without reading / writing
- reading / writing possible after clearance

	Ø D	H	Ident-No.
Balluff Chip with adapter	11,6 [mm]	6.0 [mm]	182558 o

Spare parts

Dimension

Class-No.

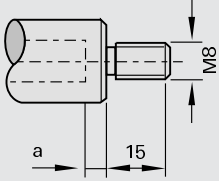
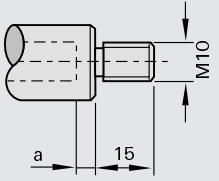
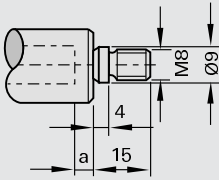
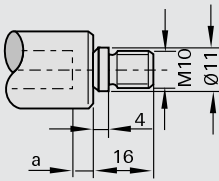
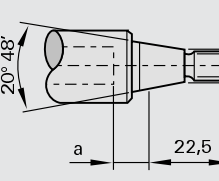
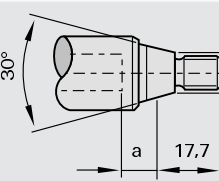
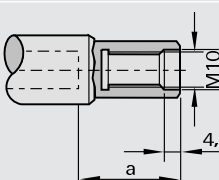
PU

Ident-No.

Balluff Chip	Ø10x4,5	994711	1	182559 o
Adapter for Balluff Chip	Ø11,6x6 [mm]	956500	1 [pc.]	182560

Connection dimensions for Drill Bit Collet Chucks

Threaded shank design for Kombi and Klack systems with appropriate machines

Type	Machine assignment	
<p>A</p> 	<p>Nottmeyer Lehbrink Pankoke + Kochsiek Priß + Horstmann</p>	
<p>B</p> 	<p>Ayen Holzma Knoevenagel Mayer Brandt Reichenbacher Torwegge Zubiola</p>	
<p>C</p> 	<p>Nottmeyer</p>	
<p>D</p> 	<p>Böttchner + Gessner Biese Busellato Dingenotto Hüllhorst Holz-Her Homag Koch</p>	<p>Morbidelli Reimall Torwegge Weeke Reich</p>
<p>E</p> 	<p>Bilek Type KÜN Knoevenagel</p>	
<p>F</p> 	<p>Alberti Balestrini Bilek (05 R) Busellato Dubus Goma Grotefeld Omeg</p>	<p>Reimall Schleicher SCM Tanzani Viciani Vitap Weingärtner</p>
<p>G</p> 	<p>Scheer</p>	





Spare Parts

Product	Page
Screws / Set Screws	8-1
Nuts	8-10
Spacer Rings	8-12
Reducing Bushings / Reducing Rings	8-17
Ball Bearings	8-21
Accessory Tools	8-23

Torque for Screws

Hexagon Socket Set Screws (DIN 913...916)

Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 45H
M3	1.5	0.82
M4	2.0	1.90
M5	2.5	3.50
M6	3.0	5.50
M8	4.0	9.50
M10	5.0	20.0
M12	6.0	30.0

Hexagon Socket Set Screws (DIN 912)

Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 8.8
M3	2.5	1.1
M4	3.0	2.5
M5	4.0	5.0
M6	5.0	10.0
M8	6.0	15.0
M10	8.0	15.0
M12	10.0	15.0

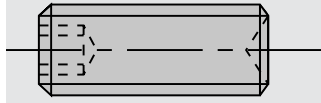
Screws with Torx

Thread	Torx-Size	Torque MA [Nm] for property class
M2.5	T8	1.31
M3	T9	2.30
M3.5	T15	2.95
M4	T15	5.20
M4x0.5	T9	2.00
M4.5	T15	5.20
M5	T15	8.00
M5	T20	8.60
M6	T25	15.00
M7	T30	15.00

995161

Set Screws - with hexagon socket and cup point

Drawing



Notes

- | with hexagon socket and cup point
- | packing unit 10 pieces

Dimension

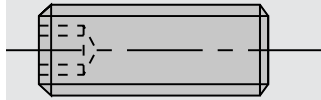
Ident-No.

M5x4 DIN EN ISO 4029	001608
M5x5 DIN EN ISO 4029	001609
M6x4 DIN EN ISO 4029	167068
M6x6 DIN EN ISO 4029	180003
M6x5 DIN EN ISO 4029	165049
[mm]	

995161

Set Screws - with hexagon socket and flat point

Drawing



Notes

- | with hexagon socket with flat point
- | packing unit 10 pieces

Dimension

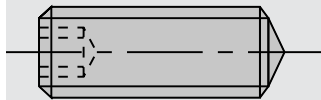
Ident-No.

M5x10 DIN EN ISO 4026	180028
M6x6 DIN EN ISO 4026	163546
M6x8 DIN EN ISO 4026	180036
M8x10 DIN EN ISO 4026	059549
[mm]	

995161

Set Screws - with hexagon socket and cone point

Drawing



Notes

- | with hexagon socket with cone point
- | packing unit 10 pieces

Dimension

Ident-No.

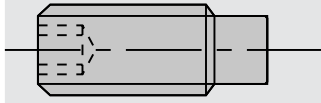
M5x10 DIN EN ISO 4027	001686
[mm]	



995161

Set Screws - with hexagon socket and dog point

Drawing



Notes

- | with hexagon socket with dog point
- | packing unit 10 pieces

Dimension

Ident-No.

M5x8 DIN EN ISO 4028	180015
M5x12 DIN EN ISO 4028	050565
M6x6 DIN EN ISO 4028	163841
M6x10 DIN EN ISO 4028	180002
M6x12 DIN EN ISO 4028	180214
M6x16 DIN EN ISO 4028	001617
M6x25 DIN EN ISO 4028	167979
M8x10 DIN EN ISO 4028	001622
M8x12 DIN EN ISO 4028	180001
M8x14 DIN EN ISO 4028	168453
M8x16 DIN EN ISO 4028	164422
M8x20 DIN EN ISO 4028	001625
M8x35 DIN EN ISO 4028	165937
M10x12 DIN EN ISO 4028	001630
M10x16 DIN EN ISO 4028	168192
M10x20 DIN EN ISO 4028	815807
M10x25 DIN EN ISO 4028	168108
M12x25 DIN EN ISO 4028	181466

[mm]

995161

Set Screws - with hexagon socket and ball pressure screw

Notes

- | with hexagon socket and ball pressure screw
- | packing unit 10 pieces

Dimension

Ident-No.

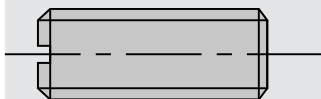
M8x20	168874 o
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[mm]

995162

Set Screws - with flat point

Drawing



Notes

- | slotted with flat point
- | packing unit 10 pieces

Dimension

Ident-No.

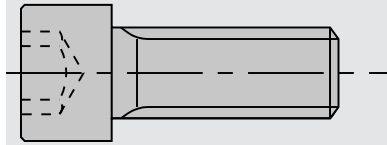
M5x10 DIN EN ISO 4766	001600
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[mm]

995111

Head Cap Screws - with hexagon socket

Drawing



Notes

- | with hexagon socket
- | packing unit 10 pieces

Dimension

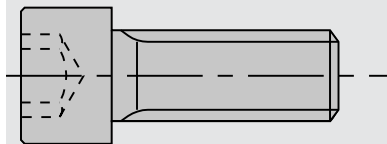
Dimension	Ident-No.
M5x40 DIN EN ISO 4762	001875 s
M6x16 DIN EN ISO 4762	001879
M6x40 DIN EN ISO 4762	001884
M8x10 DIN EN ISO 4762	001890 s
M10x50 DIN EN ISO 4762	001909
M12x30 DIN EN ISO 4762	001917
M12x50 DIN EN ISO 4762	001921
M16x40 DIN EN ISO 4762	001933 s
M16x50 DIN EN ISO 4762	166442
M16x50L DIN EN ISO 4762	166431
M16x70 DIN EN ISO 4762	059169
M16x120 DIN EN ISO 4762	001938 s
M20x50 DIN EN ISO 4762	166441
M20x50L DIN EN ISO 4762	166440
M20x80 DIN EN ISO 4762	056178
M20x120 DIN EN ISO 4762	056153 s

[mm]

995111

Head Cap Screws - with hexagon socket with low head

Drawing



Notes

- | with hexagon socket with low head
- | packing unit 10 pieces

Dimension

Dimension	Ident-No.
M5x16	165961
M8x16	180004
M8x30	180005
M8x50	180006

[mm]

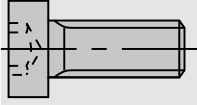


995115

Head Cap Screws - with Torx

Drawing

Notes



- | with Torx
- | packing unit 10 pieces

Dimension

Ø D

Ident-No.

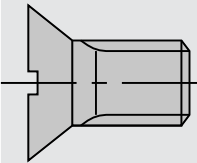
M2,5x3 T8	3,45	168237
M2,5x4 T8	3,45	168238
M3x5,5 T8	4,35	168239
M3x10 T8	4,4	168782
M3,5x3,8 T15	7,0	162645
M3,5x5,5 T15	6,0	168236
M3,5x6,5 T15	6,2	163223
M3,5x6,5 T15	7,0	162644
M3,5x8 T15	6,25	163222
M5x12 T20	8,5	171237
[mm]	[mm]	

995122

Countersunk Screws - slotted

Drawing

Notes



- | slotted
- | packing unit 10 pieces

Dimension

Ident-No.

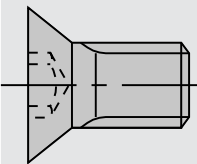
M4x8-8.8 DIN EN ISO 10642	183683
M5x10-8.8 DIN EN ISO 2009	055881
M5x12-5.8 DIN 87	180007
[mm]	

995125

Countersunk Screws - with hexagon socket

Drawing

Notes



- | with hexagon socket
- | packing unit 10 pieces

Dimension

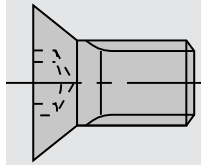
Ident-No.

M6x12 SW4	900612
[mm]	

995 125

Countersunk Screws - with Torx

Drawing



Notes

- | with Torx
- | packing unit 10 pieces

Dimension

Ident-No.

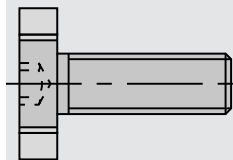
M2,5x5,5 T8		167486
M3x7,3 T8		166502
M3,5x5,5 T15		162649
M3,5x6 T15		162648
M4x0,5x3,2 T9		163925
M4x0,5x4,2 T9		165908
M4x0,5x5,3 T9		170202
M5x6 T20		176199
M5x6,8 T15		180839
M5x8 T20		164005
M5x9 T20 D=Ø9,3		827277
M5x10 T20	for attaching the saw blade without flange	171236
M5x10,8 T15		180840
M5x12 T20		166709
M5x13,5 T20	with collar 6,3 mm	171238
M5x15,5 T20		182112
M5x16 T20	for attaching the flange	164839
M6x10 T20		181244

[mm]

995 190

Cutter Retaining Bolts

Drawing



Notes

- | with hexagon socket

Dimension

Ident-No.

M8x23xØ20		171393 s
M10x26xØ28		171392
M12x22xØ35		173591 s
M16x26xØ42		173592
M16x38xØ48	with centering ring	184061

[mm]

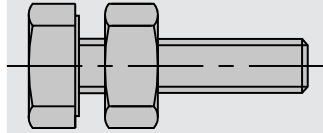


995190

Stop Screws

Drawing

Notes



- | for shank-type tools
- | packing unit 10 pieces

Dimension

Ident-No.

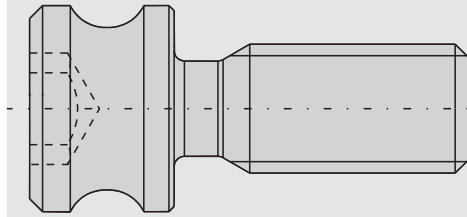
M8x25	stop screw	172828
M6x16	for shank Ø 16	172797
[mm]		

995195

Stop Screws - with Torx

Drawing

Notes



- | for clamping chucks Weeke
- | packing unit 10 pieces

Dimension

Ident-No.

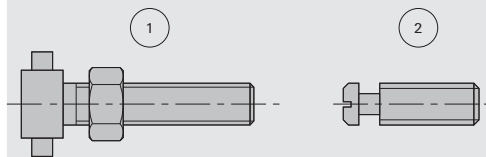
M5x17		186017
[mm]		

995190

Safety Screws

Drawing

Notes



- | for ps-System and PS 2000-E

Dimension

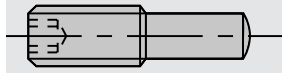
Ident-No.

1	M6x20	for ps-System 16 mm	Ident-No. 168674	172115
1	M8x25	for ps-System 25 mm	Ident-No. 173752	172113
2	M8x19	for PS-2000 E	Ident-No. 173352	172921
	[mm]			

995191

Special Set Screws

Drawing



Notes

- | for SuperProfiler "MAN"
- | with hexagon socket
- | packing unit 10 pieces

Dimension

Ident-No.

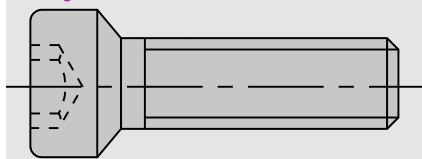
M8x24
[mm]

167269

995191

Screws

Drawing



Notes

- | for "Klack" bottom part
- | packing unit 10 pieces

Dimension

Ident-No.

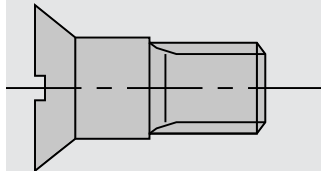
M8x24L
M8x24R
[mm]

180013 #
180012 #

995192

Countersunk Screws - with collar

Drawing



Notes

- | with collar
- | packing unit 10 pieces

Dimension

Ident-No.

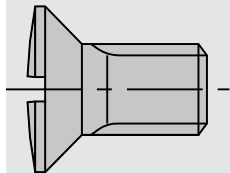
M5x12
[mm]

180009

995192

Countersunk Screws - for hogger segments

Drawing



Notes

- | for hogger segments
- | safety screws

Dimension

Ident-No.

M8x12,5
M8x17
[mm]

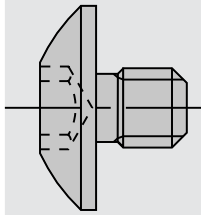
180010
180011



995 195

Round Head Screws

Drawing



Notes

- | with Torx
- | packing unit 10 pieces

Dimension

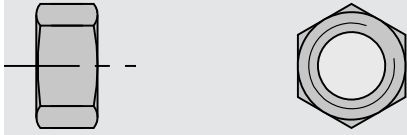
Ident-No.

M3,5x4 T15	head Ø 9	168893
M3,5x6 T15	head Ø 9	177549
M3,5x12 T15	head Ø 9	171067
M4x5,9 T15	head Ø 9	167966
[mm]		

995210

Hexagon Nuts

Drawing



Dimension

Ident-No.

M4 DIN EN ISO 4032

009631

M6 DIN EN ISO 4032

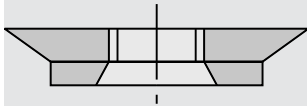
009633 s

[mm]

995290

Special Nuts

Drawing



Notes

- | for grooving cutterhead turnover knives
- | packing unit 10 pieces

Dimension

Ident-No.

M4x0,5x1,6

163704

M4x0,5x2,2

163703

M4x0,5x2,75

165907

M4x0,5x4,1

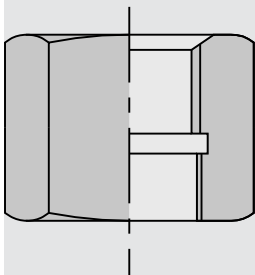
170203

[mm]

995290

Union Nuts

Drawing



Notes

- | for MK-shanks

Dimension

Ident-No.

M33x3/M30x1,5

double-edged

170275 o

W 1 1/8"/W20x14

hexagonal

167911 o

W 1 1/8"/M30x1,5/L

hexagonal

167780

W 1 1/8"/M30x1,5

hexagonal

165561

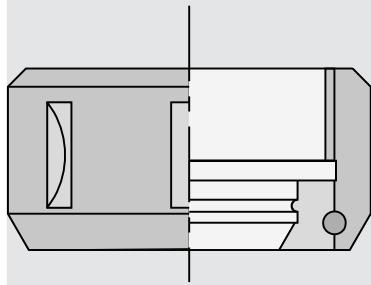
[mm]



995290

Clamping Nuts

Drawing



Notes

I for draw-in collet chucks

Dimension

Ident-No.

M30x1,5R	with ball-bearing	178763
M40x1,5R	with slide bearing	178761
M48x2R	with slide bearing	178764
M50x1,5R	with slide bearing	178762 o
[mm]		

955520

Spacers

Ø D	B	Ø d	DKN	NL	Ident-No.
14	0,1	6,0			176422 o
14	0,2	6,0			176423 o
14	0,5	6,0			176424 o
14	1,0	6,0			176425 o
14	2,0	6,0			176426 o
14	5,0	6,0			176427 o
40	0,1	20			000218
40	0,2	20			000219
40	0,5	20			000220
40	1,0	20			000221
40	2,0	20			000222
40	3,0	20			000223
80	0,05	22		2/4/42	017424
80	0,1	22		2/4/42	017425
80	0,2	22		2/4/42	017426
40	0,1	25			183756
40	0,2	25			183757
40	0,5	25			183758
40	1,0	25			183759
40	2,0	25			183760
40	4,0	25			183761
40	6,0	25			183762
40	10	25			183763 s
40	20	25			183764
45	0,1	25	10x3,3	2/5,5/35 + 4/6,5/36	185391
45	0,2	25	10x3,3	2/5,5/35 + 4/6,5/36	185392
45	0,5	25	10x3,3	2/5,5/35 + 4/6,5/36	185393
45	1,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185394
45	2,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185395
45	3,0	25	10x3,3	2/5,5/35 + 4/6,5/36	185396
50	0,1	30			000242
50	0,2	30			000243
50	0,5	30			000244
50	1,0	30			000245
50	2,0	30			000246
50	3,0	30			000247
65	0,1	30	10x3,3	2/7/45 + 8/7/48	185397
65	0,2	30	10x3,3	2/7/45 + 8/7/48	185398
65	0,5	30	10x3,3	2/7/45 + 8/7/48	185399
65	1,0	30	10x3,3	2/7/45 + 8/7/48	185400
65	2,0	30	10x3,3	2/7/45 + 8/7/48	185401
65	3,0	30	10x3,3	2/7/45 + 8/7/48	185402
65	4,0	30	10x3,3	2/7/45 + 8/7/48	185403
65	10	30	10x3,3	2/7/45 + 8/7/48	185404
90	1,0	30			000311
90	2,0	30			000312 s
90	3,0	30			000313 s
100	0,1	30			000320
100	0,2	30			000321
100	0,5	30			000322
100	1,0	30			000323
100	2,0	30			000324 s
100	3,0	30			000325 s
175	0,1	30			000458 s
175	0,2	30			000459 s
175	0,5	30			000460 s
175	1,0	30			000461 s
70	0,1	35	12x4	4/11/54 + 6/7/58	185405
70	0,2	35	12x4	4/11/54 + 6/7/58	185406
70	0,5	35	12x4	4/11/54 + 6/7/58	185407
[mm]	[mm]	[mm]	[mm]		



Ø D	B	Ø d	DKN	NL	Ident-No.
70	1,0	35	12x4	4/11/54 + 6/7/58	185408
70	2,0	35	12x4	4/11/54 + 6/7/58	185409
70	3,0	35	12x4	4/11/54 + 6/7/58	185410
70	4,0	35	12x4	4/11/54 + 6/7/58	185411
70	10	35	12x4	4/11/54 + 6/7/58	185412
70	25	35			170363 s
100	0,1	35			000326
100	0,2	35			000327
100	0,5	35			000328
100	1,0	35			000329
100	2,0	35			000330 s
100	3,0	35			000331
70	0,1	40	14x3,5	4/8/55 + 4/7/58	185413
70	0,2	40	14x3,5	4/8/55 + 4/7/58	185414
70	0,5	40	14x3,5	4/8/55 + 4/7/58	185415
70	1,0	40	14x3,5	4/8/55 + 4/7/58	185416
70	2,0	40	14x3,5	4/8/55 + 4/7/58	185417
70	3,0	40	14x3,5	4/8/55 + 4/7/58	185418
70	4,0	40	14x3,5	4/8/55 + 4/7/58	185419
70	10	40	14x3,5	4/8/55 + 4/7/58	185420
120	0,1	40			000344
120	0,2	40			000345
120	0,5	40			000346
120	1,0	40			000347
120	2,0	40			000348
90	0,1	50			000314
90	0,2	50			000315
90	0,5	50			000316
90	1,0	50			000317
90	2,0	50			000318
90	3,0	50			000319
100	0,05	50		4/9/80	177019 s
100	0,1	50		4/9/80	176835
100	0,2	50		4/9/80	176836
100	0,5	50		4/9/80	176837
100	1,0	50		4/9/80	176838
100	2,0	50		4/9/80	176839 s
100	3,0	50		4/9/80	176840 s
90	0,05	60		3/9/74	177022
90	0,1	60		3/9/74	177023
90	0,2	60		3/9/74	177024
90	0,5	60		3/9/74	177025
90	1,0	60		3/9/74	177026
90	2,0	60		3/9/74	177027
100	0,1	60			000332
100	0,2	60			000333
100	0,5	60			000334 s
100	1,0	60			000335
100	2,0	60			000336
100	3,0	60			000337
119	5,0	60			185365
119	39,5	60			185044
119,5	51	60		4/9/100	179471
120	0,1	60		4/9/100	176830
120	0,15	60		4/9/100	177018
120	0,2	60		4/9/100	176831
120	0,5	60		4/9/100	176832
120	1,0	60		4/9/100	176495
120	2,0	60		4/9/100	176833
120	3,0	60		4/9/100	176834
130	4,2	60			182200 s
130	4,3	60			182201 s
130	4,4	60			182202 s
130	4,5	60			182203 s
[mm]	[mm]	[mm]	[mm]		

Ø D	B	Ø d	DKN	NL	Ident-No.
130	4,6	60			182204 s
130	4,7	60			182205 s
130	4,8	60			182206 s
130	4,9	60			182207 s
130	5,0	60			182208 s
160	0,1	60			000452
160	0,2	60			000453
160	0,5	60			000454
160	1,0	60			000455
160	2,0	60			000456
160	3,0	60			000457 s
115	1,0	80		4/10/100	009255
130	4,5	65			182209 s
130	4,6	65			182210 s
130	4,7	65			182211 s
130	4,8	65			182212 s
130	4,9	65			182213 s
130	5,0	65			182214 s
100	7,6	70			180940
100	11,4	70			180941
120	0,1	80		4/9/100 + 2/6,5/90	177380
120	0,2	80		4/9/100 + 2/6,5/90	177381
120	0,5	80		4/9/100 + 2/6,5/90	177382
120	1,0	80		4/9/100 + 2/6,5/90	177383
120	2,0	80		4/9/100 + 2/6,5/90	177384
120	3,0	80		4/9/100 + 2/6,5/90	177385
130	0,5	80			000450 s
145	0,1	80		4/12/100 + 4/9/120	552104
145	0,2	80		4/12/100 + 4/9/120	552105
145	0,5	80		4/12/100 + 4/9/120	552106
145	1,0	80		4/12/100 + 4/9/120	552107
150	1,6	75		6/6,5/95	189542
175	7,6	70			186163 s
175	11,4	70			181034
[mm]	[mm]	[mm]	[mm]		

955521

Spacer Sets - 4 parts

Notes

| 4 piece set consists of: 1 piece 0.1 mm, 1 pieces 0.2 mm, 2 piece 0.3 mm

Ø D	B	Ø d	NL	Ident-No.
74	0,9	22	2/4/42	80272800
[mm]	[mm]	[mm]		

955521

Spacer Sets - 8 parts for milling spindles

Notes

| for milling spindles

| 8 piece set consists of: 2 pieces 5 mm, 1 piece 8 mm, 1 piece 10 mm, 2 pieces 16 mm, 1 piece 25 mm, 1 piece 40 mm

Ø D	B	Ø d	Ident-No.
50	125	30	160233 o
60	125	40	160234 o
[mm]	[mm]	[mm]	



955521

Spacer Sets - 9 parts

Notes

| 9 piece set consists of: 1 piece 0.1 mm, 2 pieces 0.2 mm, 1 piece 0.5 mm, 3 pieces 1.0 mm, 1 piece 4.0 mm, 1 piece 10 mm

Ø D	B	Ø d	Ident-No.
65	18	30	161797
70	18	35	161798 s
70	18	40	161799 s
[mm]	[mm]	[mm]	

995520

Spacers for s-System - Homag

Notes

| for s-System - Homag

Ø D	B	Ø d	DKN	Ident-No.
60	11	35	10x3,3	180647
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - steel

Product

Notes

| Spacer rings for sawmills
| Other designs and dimensions on request

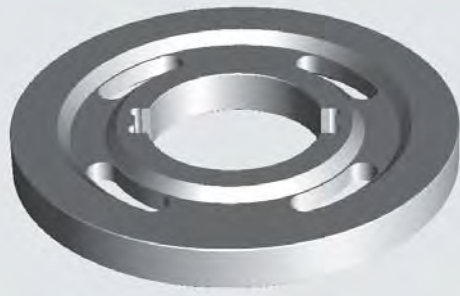


Ø D	B	Ø d	DKN	Ident-No.
150	0,5	115	29x131	80370453 s
150	1,0	115	29x131	80370454 s
190	2,0	150	36,3x167	80383237 s
190	3,0	150	36,3x167	80383238 s
190	5,0	150	36,3x167	80383239 s
190	10,5	150	37x170	80387052 s
190	11,5	150	37x170	80387053 s
190	12,5	150	37x170	80387054 s
190	40,4	150	37x170	80387912 s
200	1,0	150	37x157,8	80291659 s
200	2,0	150	37x157,8	80291660 s
200	3,0	150	37x157,8	80291661 s
200	6,8	150	37x157,8	80404151 s
200	21,6	150	37x157,8	80291663 s
200	31,6	150	37x157,8	80291662 s
220	10,4	150	37x170	80283020 s
270	10	150	36,3x167	80363407 s
270	30	150	36,5x168	80386011 s
270	150	150	36,3x167	80354756 s
320	10,4	150	37x170	80283019 s
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - aluminum, stepped

Product



Notes

- | Spacer rings for sawmills
- | Other designs and dimensions on request

Ø D	B	Ø d	DKN	Ident-No.
380	37,7	150	37x170	80187182 s
[mm]	[mm]	[mm]	[mm]	



955530

Reducing Rings

Notes

! this bore can only be reduced if the direct clamping of the saw blade via clamping rings or flanges is guaranteed

Ø D	B	Ø d	Ø d	Ident-No.
20	1,6	12,7	1/2"	161946
20	1,6	16		161945
22	2,0	20		161887
22	4,0	20		161830
25	2,2	20		000104
30	1,4	15		000107 s
30	1,4	16		000111
30	1,4	20		000117
30	1,4	25		000125
30	1,8	15,1	19/32"	161949 #
30	1,9	16		000112
30	1,9	20		000118
30	2,0	20		016848
30	2,0	25		000127 s
30	2,2	15,88	5/8"	000110 s
30	2,2	16		000113
30	2,2	18		000114
30	2,2	20		000119
30	2,2	22		000120
30	2,2	25		000128
30	2,2	25,4	1"	000130
30	2,2	28		000132
30	3,0	25		000129
32	2,0	16		161886
32	2,2	16		000134 s
32	2,2	20		000135 s
32	2,2	22		010571
32	2,2	30		000137
35	1,0	30		000145
35	1,4	30		000146 s
35	1,9	30		000147
35	2,2	20		000138
35	2,2	24		000139 s
35	2,2	25		000142
35	2,2	28		000144 s
35	2,2	30		000148
35	2,2	32		000150 s
40	2,0	32		161962
40	2,2	20		000151
40	2,2	30		000153
40	2,2	35		000154 s
45	2,5	30		161831
50	2,2	30		000156
55	2,2	30		000159
60	2,2	30		000161
60	2,2	35		000162
60	2,2	40		000163 s
60	2,2	50		000164
60	2,8	30		010577
70	2,2	30		000166 s
80	2,2	30		000171
80	2,2	35		000172 s
80	2,2	50		000175 s
80	2,2	60		000177 s
80	2,2	70		000179 s
80	2,8	60		000178 s
[mm]	[mm]	[mm]	[inch]	

956506

Reducing Bushing

Notes

- | cylindrical
- | bore tolerance H7

Ø D	B	Ø d	Ø d	Ident-No.
30	5,1-10	20		000411 s
30	5,1-10	25		000415 &
30	10,1-25	20		000441 o
30	10,1-25	25		000445 &
30	15,1-20		1"	000726 &
30	15,1-20	20		000721 o
30	15,1-20	25		000725 &
30	20,1-25		1"	000756 o
30	20,1-25	25		000755 &
30	25,1-30		1"	000786 &
30	25,1-30	20		000781 o
30	25,1-30	25		000785 &
30	30,1-40		1"	000816 &
30	30,1-40	20		000811 &
30	30,1-40	25		000815 &
30	40,1-50		1"	000846 &
30	40,1-50	25		000845 o
30	50,1-60	25		000875 &
30	60,1-80		1"	000365 s
30	60,1-80	20		000360 s
30	60,1-80	25		000364 s
35	5,1-10	20		000420 &
35	5,1-10	30		000424 &
35	10,1-25	30		000704 &
35	15,1-20		1 1/4"	000735 &
35	15,1-20	30		000734 &
35	20,1-25		1 1/4"	000765 &
35	20,1-25	30		000764 &
35	25,1-30		1 1/4"	000795 o
35	25,1-30	30		000794 &
35	30,1-40		1 1/4"	000825 &
35	30,1-40	30		000824
35	40,1-50	30		000854 &
35	50,1-60		1 1/4"	000885 &
35	50,1-60	30		000884 &
35	60,1-80		1 1/4"	000374
35	60,1-80	20		000369 s
35	60,1-80	30		000373
40	5,1-10	20		000428 &
40	5,1-10	25		000429 &
40	5,1-10	30		000430 &
40	5,1-10	35		000891 &
40	10,1-25	20		000708 &
40	10,1-25	30		000710 &
40	10,1-25	35		000912 &
40	15,1-20	30		000740 &
40	15,1-20	35		000933 &
40	20,1-25	25		000769 &
40	20,1-25	30		000770 &
40	25,1-30	30		000800 &
40	25,1-30	35		000975 o
40	30,1-40	20		000828 &
40	30,1-40	25		000829 &
40	30,1-40	30		000830 &
40	30,1-40	35		000996 &
40	40,1-50	30		000860 &
[mm]	[mm]	[mm]	[inch]	



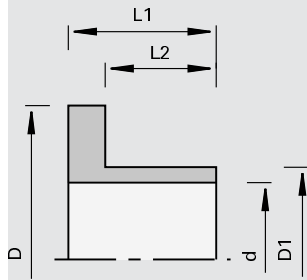
Ø D	B	Ø d	Ø d	Ident-No.
40	40,1-50	35		001017 &
40	50,1-60	30		000890 &
40	50,1-60	35		001038 &
40	60,1-80	20		000377 s
40	60,1-80	25		000378 s
40	60,1-80	30		000379
40	60,1-80	35		000380
60	5,1-10	30		000899 &
60	5,1-10	35		000900 &
60	5,1-10	40		000901 &
60	10,1-25	30		000920 &
60	10,1-25	35		000921 &
60	10,1-25	40		000922 &
60	15,1-20	30		000941 &
60	15,1-20	35		000942 &
60	15,1-20	40		000943 &
60	20,1-25	30		000962 &
60	20,1-25	35		000963 &
60	25,1-30	30		000983 &
60	25,1-30	35		000984 &
60	25,1-30	40		000985 &
60	30,1-40	30		001004 &
60	30,1-40	35		001005 &
60	30,1-40	40		001006 &
60	40,1-50	30		001025 &
60	40,1-50	35		001026 &
60	40,1-50	40		001027 &
60	50,1-60	35		001047 &
60	50,1-60	40		001048 &
60	60,1-80	30		000388
60	60,1-80	35		000389
60	60,1-80	40		000390
80	5,1-10	30		000905 &
80	10,1-25	40		000928 &
80	15,1-20	30		000947 &
80	15,1-20	35		000948 &
80	15,1-20	40		000949 &
80	20,1-25	35		000969 &
80	20,1-25	40		000970 &
80	25,1-30	30		000989 &
80	25,1-30	35		000990 &
80	30,1-40	35		001011 &
80	30,1-40	40		001012 &
80	40,1-50	30		001031 &
80	40,1-50	35		001032 &
80	40,1-50	40		001033 &
80	50,1-60	35		001053 &
80	60,1-80	30		000394 s
80	60,1-80	35		000395 s
80	60,1-80	40		000396 s
80	10,1-25	30		000926 &
80	10,1-25	35		000927 &
80	5,1-10	35		000906 &
80	5,1-10	40		000907 &
[mm]	[mm]	[mm]	[inch]	

956506

Reducing Bushings with collar

Drawing

Notes



I with collar

Ø D	Ø D1	Ø d	L1	L2	Ident-No.
60 [mm]	40 [mm]	30 [mm]	24 [mm]	18 [mm]	168063 s



997500

Ball Bearings

Notes

| for shank-type tools

Dimension

Ident-No.

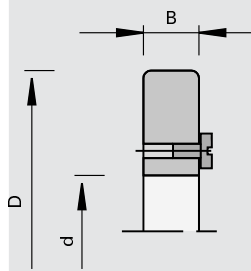
ball-bearing thrust ring assy.	Ø12	167923
ball-bearing thrust ring assy.	Ø14	169314
Ball Bearings	12,7x5x4,76	164920
Ball Bearings	15,9x5x6,35	164921
Ball Bearings	19x6x6	164922
Ball Bearings	22x7,5x8	180838
ball-bearings with thrust ring	19x7,5x6,35	164229
ball-bearings with thrust ring	21x7,5x6,35	170774 o
ball-bearings with thrust ring	22x7,5x6,35	164228
	[mm]	

955550

Rub Collars

Drawing

Notes



| for use on ball bearing bushing
 | intermediate dimensions available upon request
 | screw for axial locking: cap screw M4x10 DIN 84 Ident-No. 001730

Ø D	B	Ø d	Ident-No.
75	10	62	160205 #
80	10	62	160206 #
100	10	62	160210 #
105	10	62	160211 #
150	10	62	160219 #
[mm]	[mm]	[mm]	

955550

Ball Bearing Ring Set

Product



Drawing

Machine / Application

I for Ø 90 mm - Ø 130 mm

Design

I wood box with with ball bearing, safety screws, cover discs and thrust rings

Advantages

Notes

Ø d	Ø D	Ident-No.
30 [mm]	90/95/100/105/110/115/120/125/130 [mm]	50592754

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M6x14 DIN 963	995121	10	50947932 s
Spacers	D=48	955520	2	50592771
Ball Bearing Bushings	55/30X13 [mm]	997500	1	50592751 [pc.]



985720

Engineers Wrenches

Dimension	Ident-No.
9x11 DIN 3118	168672 o
11x13 DIN 3118	168670 o
14x17 DIN 3118	168671 s
SW10/13 DIN 895	171060 o
[mm]	


985720

Single-Head Engineers Wrenches

Dimension	Ident-No.
SW36 DIN 894	169296 o
SW41 DIN 894	169297 s
SW46x10 DIN 894	178760
[mm]	


985720

Hook Wrenches

Product	Notes
	for draw-in collet chucks
Dimension	Ident-No.
40/42 DIN 1810	169298
45/50 DIN 1810	175851
58/62 DIN 1810	169299
[mm]	

985300

Hook wrench adapter for torque wrench

Product	Notes
	for draw-in collet chucks use with torque wrench, ID No 184890
Dimension	Ident-No.
40/43 DIN 1810	186466 o
45/50 DIN 1810	186467 o
58/62 DIN 1810	186765
[mm]	

985720

Hand spanner

Product



Notes

| for draw-in collet chucks with internal clamping nut

Ident-No.

426E / ER 16

184878

470E / ER 32

184879

462E / OZ 25

184880

985300

Torque adapter for torque wrench

Product



Notes

| for draw-in collet chucks with internal clamping nut
| use with torque wrench, ID No 184890

Ident-No.

426 E / ER 16

184887

470 E / ER 32

184888

462 E / OZ 25

184889

985300

Torque wrench

Dimension

40-200 Nm

[mm]

Ident-No.

184890

985730

Cranked Wrench Keys for hexagon socket screws

Notes

| for hexagon socket screws

Dimension

SW2 DIN ISO 2936

009670 s

SW2,5 DIN ISO 2936

009671

SW3 DIN ISO 2936

009672

SW4 DIN ISO 2936

009673

SW5 DIN ISO 2936

009674

SW6 DIN ISO 2936

009675

SW6x100

180383 o

SW8 DIN ISO 2936

009677 s

SW12 DIN 6911

177106

[mm]



985730

Screwdrivers with sliding handle for hexagon socket

Notes

- | for hexagon socket screws
- | with sliding handle

Dimension	Ident-No.
SW2,5x100	168010
SW3x100	166090
SW4x100	166091
SW5x150	168703
SW6x200	167817
[mm]	

985730

Screwdrivers with sliding handle for Torx

Notes

- | for screws with Torx
- | with sliding handle

Dimension	Ident-No.
T20x100	166092
T25x100	50933169 #
T40x130	831404 o
[mm]	

985730

Screwdrivers with flag for Torx

Notes

- | for screws with Torx
- | with flag

Dimension	Ident-No.
T7	167904
T8	166499
T9	164344
T15	163161
[mm]	

985730

Cranked Wrench Keys for Torx

Notes

- | for screws with Torx

Dimension	Ident-No.
T15	for adjustment unit Altendorf 181147
T30x100	50933102
[mm]	

985730

Screwdrivers with spinner handle for Torx

Notes

- | for screws with Torx
- | with spinner handle

Dimension	Ident-No.
T9x60	173796
T15x80	171188
T15x140	179145
[mm]	

985730

Screwdrivers with spinner handle

Notes

- | with spinner handle

Dimension	Ident-No.
8,0	053874
[mm]	

985730

Screwdrivers with wooden handle

Notes

- | with wooden handle

Dimension	Ident-No.
9,0	011088
[mm]	

985200

Adjusting Gauges

Dimension	Ident-No.
0,3	055883
0,5	50570583
0,7	056096
0,8	50570581
1,0	011103
1,8	50570582
[mm]	

997800

Magnetic Stops

Dimension	Ident-No.
0,0	016613
0,5	166093
1,0	166094
[mm]	



985710

Ball hammers one sided

Product



Notes

| Hand tools for straightening circular saw blades

Weight

Ident-No.

0.5	186268 s
0.75	186269 s
1.0	186270 s
1.25	186271 s
1.5	186272 s
1.75	186273 s
2.0	186274 s
2.25	186275 s
2.5	186276 s
3.0	186277 s
[kg]	

985710

Ball hammers double sided

Product



Notes

| Hand tools for straightening circular saw blades

Weight

Ident-No.

0.5	186257 s
0.75	186258 s
1.0	186259 s
1.25	186260 s
1.5	186261 s
1.75	186262 s
2.0	186263 s
2.25	186264 s
2.5	186265 s
3.0	186266 s
3.5	186267 s
[kg]	

985710

Cross hammers

Product

Notes



| Hand tools for straightening circular saw blades

Weight

Ident-No.

0.5	186278 s
0.75	186279 s
1.0	186280 s
1.25	186281 s
1.5	186282 s
1.75	186283 s
2.0	186284 s
2.25	186285 s
2.5	186286 s
[kg]	

985710

Roughing hammers

Product

Notes



| Hand tools for straightening circular saw blades

Weight

Ident-No.

0.5	186287 s
0.75	186288 s
1.0	186289 s
1.25	186290 s
1.5	186291 s
1.75	186292 s
2.0	186293 s
2.25	186294 s
2.5	186295 s
[kg]	



985300

Rulers

Product

Notes



| Hand tools for straightening circular saw blades

Total length

Ident-No.

150	186296 o
200	186297 o
300	186298 o
400	186299 o
500	186300 o
600	186301 o
800	186302 o
[mm]	

985300

Dial gauges

Product



Ident-No.

186304 o

985300

Saw setting dial gauges

Product



Ident-No.

186303 o

997600

Drilling fixture for p-System profile cutters

Product

Drawing



Machine / Application

Design

Advantages

Notes

| Drilling fixture to repair p-System profile cutters

| with positioning screws

| fast and easy positioning on the profile cutter
| Stable guidance of the drill bits

| appropriate repair set consisting of: thread inserts, twist drills, hand tap, spindle insert, tang break-off tool (identification no. 185881)

Ident-No.

for Ø D=360 mm left and Helicoil® d=7.5 mm	186440 s
for Ø D=360 mm right and Helicoil® d=7.5 mm	186441 s
for Ø D=402 mm left and Helicoil® d=7.5 mm	186444 s
for Ø D=402 mm right and Helicoil® d=7.5 mm	186445 s
for Ø D=360 mm left and core hole d=5.5 mm	186442 s
for Ø D=360 mm right and core hole d=5.5 mm	186443 s
for Ø D=402 mm left and core hole d=5.5 mm	186446 s
for Ø D=402 mm right and core hole d=5.5 mm	186447 s



1 Ordering details

1.1 Catalogue Tools

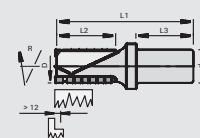
By indicating the Ident-No. the tool is described unequivocally.

The additional indication of Class-No., dimensions, sense of rotation and cutting material increases the information content and avoids wrong deliveries if the Ident-No. is false.

Please see one example each for shank-type tools and tools with bore.

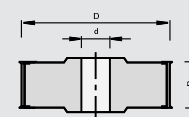
1.1.1 Shank-Type Tools

description: LEUCODIA shank-type cutter
 Class-No.: 229022
 Ident-No.: 181475
 dimensions: 25 x 38/120 x 25 (D X L2/L1 x d)
 sense of rotation: R (right-hand rotation)
 no. of teeth: Z3+3
 cutting material: DP (polycrystalline diamond)
 Type of feed: MEC



1.1.2 Tools with Bore

description: chamfering cutterhead
 Class-No.: 120255
 Ident-No.: 167048
 dimensions: 125 x 50 x 30 (D x B x d)
 double keyway: DKW 12 x 5
 no. of teeth: Z4+4 (main cutting edge knives+spurs)
 cutting material: HW (tungsten carbide)
 type of feed: MAN



1.2 Special Tools

The quick processing of inquiries and orders requires detailed information.

1.2.1 Tool Data

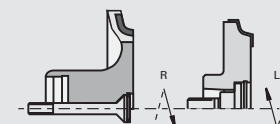
- tool design (one-part tool, compound tool or composed tool)
- diameter x cutting width x bore (tools with bore)
- diameter x effective length x shank dimension (shank-type tools)
- no. of teeth
- profile depth
- sense of rotation
- operating speed (RPM)
- feed rate
- dimensions of keyways
- cutting material type

1.2.2 Type of feed

- manual feed (MAN)
- mechanical feed (MEC)

1.2.3 Sense of rotation

- right-hand rotation[R]
- left-hand rotation[L]



1.2.4 Workpiece

- workpiece material: solid woods, wood-based panels, composite materials, plastics, NF metals etc.
- surface condition of the workpiece material: veneered, plastic-laminated, melamine-faced, lacquered etc.

In the case of lack of clarity with regard to the workpiece material samples of the material to be machined can be sent.

1.2.5 Machine data

- brand and type
- range of RPM
- installed capacity
- max. tool dimensions
- interface
- type of feed etc.

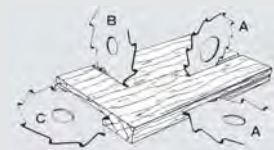
1.2.6 Position of the workpiece with regard to the tool

- reference surface and reference edge of the workpiece (i.e. machine cutting table surface)
- feed direction

1.2.7 Grain direction

Grooving in grain-oriented materials

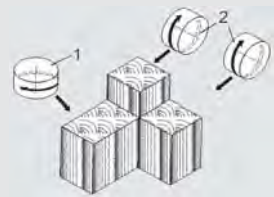
- A along the grain
- B across the grain
- C end-grain cutting



Application with and across the grain

(1)

- position of workpiece is horizontal relative to the spindle
- direction of feed is across the grain
- position of the spindle is parallel to the grain
- peripheral edge cuts parallel to the grain
- end or side (flank) edge cuts vertical relative to the grain
- no preliminary cleavage



In rebating and grooving work the flank or side edges will make the separating cut

(2)

- position of workpiece is vertical relative to the spindle
- direction of feed is across the grain
- peripheral edge cuts through end grain
- flank or side edge cuts parallel to the grain
- no preliminary cleavage

In jointing, rebating and grooving work the peripheral edges will do the principal cutting.

1.2.8 Mode of application

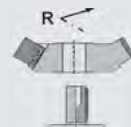
- against feed
- with feed

1.2.9 Profile details

Profile drawings must clearly show whether the workpiece or the tool is shown. Please state bearing side, sense of rotation, dimensions and application conditions on workpiece samples or drawings.

1.2.10 Information for chamfering, rabbeting and profiling tools

If no special information is available chamfering, rabbeting and profiling tools are always delivered as follows:
clockwise rotation and large diameter resp. top side spur.



2.1 Tools

One-piece tools (solid tungsten carbide tool / solid steel tool)

Tools without combined or removable parts; the body and the cutting parts are made from one piece.



Composite tools (tipped tools)

Tools with cutting parts (cutting tips) which are tightly connected with the body by means of welding, soft-soldering, hard-soldering, non-detachable bonding, etc.



Complex tools

Tools consisting of a body and one or more cutting parts (exchangeable inserts, knives) which can be changed by means of unlockable clamping elements. The cutting parts can be made in one-piece or compound design.



Tool set

Single tools which are mounted on a tool carrier and meant to work like one tool.



Tool combination

Unit consisting of multiple loose tools which can be combined with each other in diverse order or can be varied axially in different positions.



2.2 Tool bodies

Tool bodies are made from such materials that they can withstand the forces and strains to be expected during use. For this purpose steel- and aluminum materials are used. For shank-type tools supplemental materials are available.

2.3 Types of feed (according to EN 847)

2.3.1 Manual feed (MAN)

Manual feed means manually holding and guiding workpieces or machine elements with tools. Manual feed also includes using a removable feed device that is not interlocked with the tool as well as as a manual push-slide.

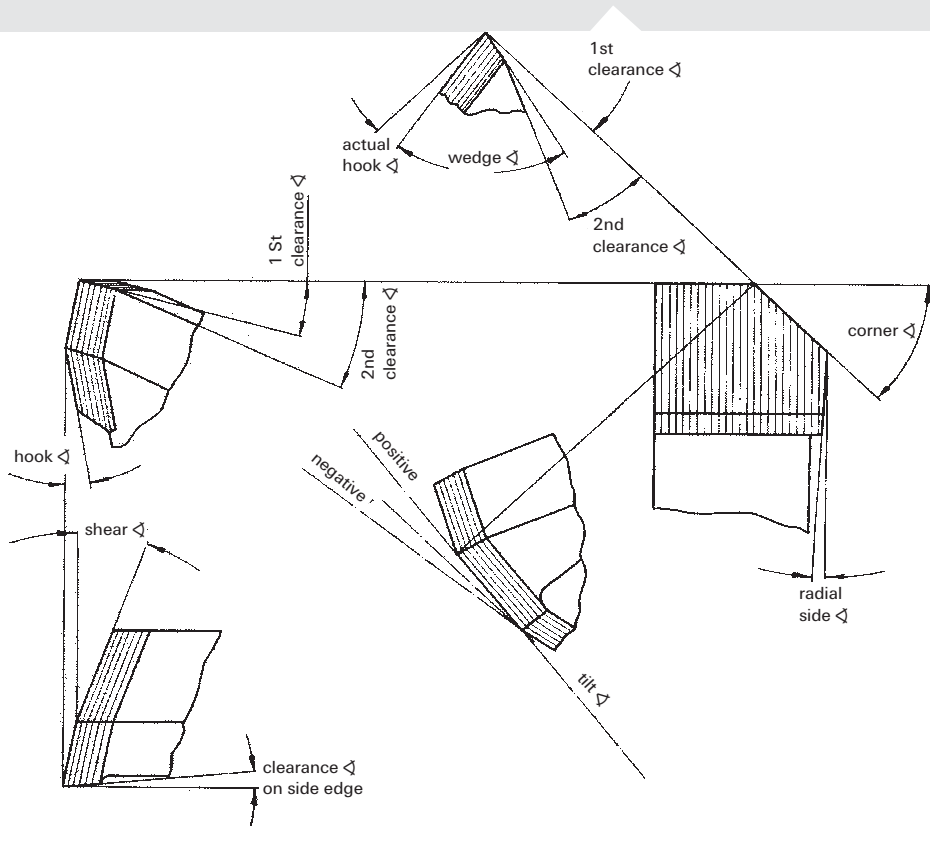
2.3.2 Mechanical feed (MEC)

Feed mechanism for the workpiece or the tool, integrated in the machine and by means of which the workpiece or machine element with tool is mechanically clamped and guided during operation.

2.4 Information with regard to the tables and charts

The working parameters for machining of wood and wood-composites are significantly co-determined by a multitude of individual factors (i.e. structure and composition of the workpiece material, machine parameters). In specific application cases there may be differences from the indications given in the tables and diagrams.

2.5 Angles and cutting edge geometries



Diameter D [mm]

Cutting width B [mm]

Hook angle [°]

Wedge angle [°]

Shear angle [°]

Corner angle [°]

3 Formulas, standard values and further information

cutting diameter D [mm]	$D = (1000 \times 60 \times v_c) / (n \times \pi)$
RPM n [dak ⁻¹]	$n = v_c \times 1000 \times 60 / (\pi \times D)$
depth of knife marks t [mm]	$t = f_z^2 / (4 \times D)$
medium chip thickness h _m [mm]	$h_m = f_z \times \sqrt{(a_e / D)}$
cutting speed [m/s ⁻¹]	$v_c = \pi \times D \times n / (1000 \times 60)$
depth of cut a _e [mm]	
feedrate v _f [m/dak ⁻¹]	$v_f = f_z \times n \times z / 1000$
feedrate per tooth f _z [mm]	$f_z = v_f \times 1000 / (n \times z)$
number of teeth z	$z = (v_f \times 1000) / (f_z \times n)$

For safety reasons (noise emission, danger of kickback) the range of cutting speeds for tools with manual feed (MAN) lies between 40 - 70 m/s.

4 Cutting materials

4.1 General information

For woodworking the following cutting materials are used:

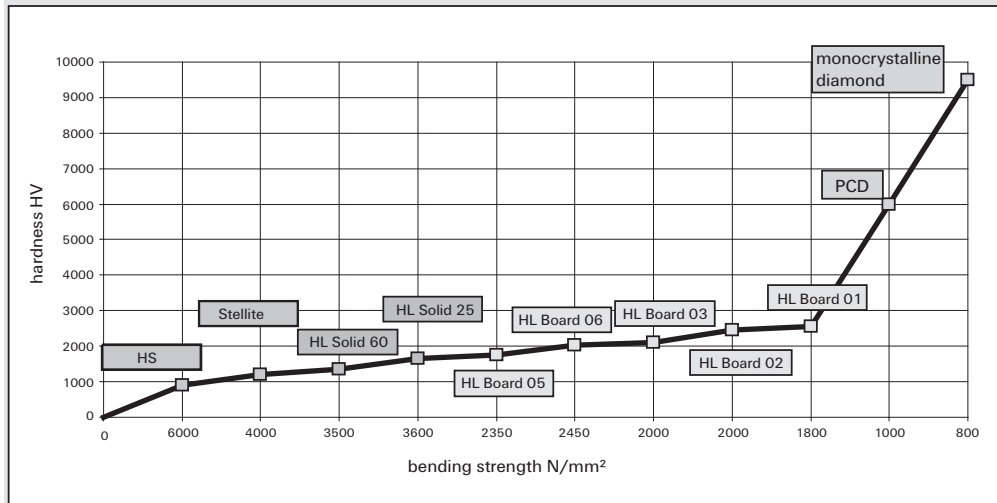
- SP alloyed steel
- HL high-alloyed steel
- HS high-speed steel
- HW uncoated tungsten carbide
- HC coated tungsten carbide
- ST casting alloy on cobalt basis
- DP polycrystalline diamond
- DM monocrystalline diamond

The multitude of materials to be machined and the various kinds of applications make different demands on the cutting edge and thus on the cutting edge material and the cutting edge geometry.

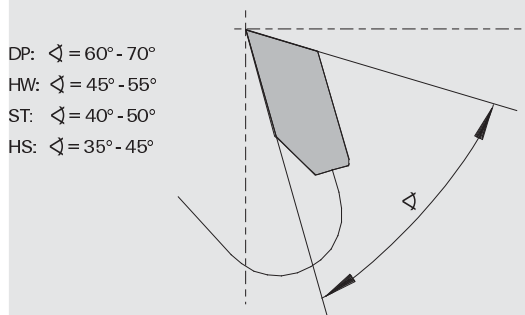
Whereas soft woods require a small hook angle, particle boards require a cutting edge which is extremely wear-resistant.

The optimum cutting material would thus be tough and hard.

The chart shows the hardness and bending strength of the most popular cutting materials.



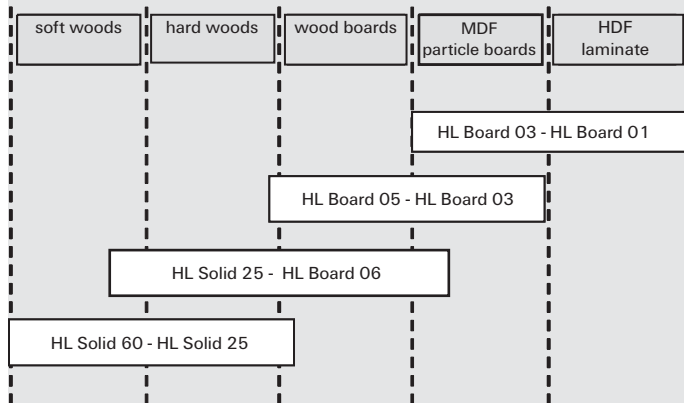
This suggests that an increase of hardness is inevitably linked with a decrease of the bending strength. With other words: "Hard cutting materials need a large wedge angle."



4.2 Range of application of the different cutting materials

4.2.1 Tungsten carbide cutting materials (HW, HC)

Tungsten carbide grades are destined for the use in soft woods, hard woods and laminated timbers as well as in wood-based panels.



The spectrum of tungsten carbide grades ranges from HL Board 01 to HL Solid 60. HL Board grades are hard and wear-resistant. HL Solid grades are tougher and can have a smaller wedge angle.

4.2.2 Diamond cutting materials (DP)

Diamond cutting materials have a wide range of application (from hard woods to laminate overlays).

The applied diamond grades are exclusively made by well-known manufacturers of cutting materials who guarantee a constant high quality.

Mainly the following grades are applied:

	Fine	Medium	Coarse
Advantages	<ul style="list-style-type: none"> high wear resistance excellent surface condition excellent sharpness of cutting edges, long edge lives 	<ul style="list-style-type: none"> excellent wear resistance high sharpness of cutting edges moderate impact resistance 	<ul style="list-style-type: none"> extremely high wear resistance slightly lesser impact resistance and toughness
Application area	for moderately abrasive materials	universally applicable	for extremely abrasive materials

4.2.3 Monocrystalline diamond (DM)

Because of its high brittleness and hardness monocrystalline diamond is applied in the case of homogeneous and extremely abrasive workpiece materials. Application areas are for example the machining of laminate overlays and transparent plastics.

4.2.4 Casting alloy on cobalt basis (ST, Stellite)

Stellite is the ideal cutting material for the machining of humid woods.

4.2.5 High speed steel (HS)

High speed steel is chosen for the machining of soft and hard woods.

For special applications further cutting materials (e.g. CVD) and coatings (e.g. topcoat) are available.

5 Workpiece materials

Overview

Solid woods	Soft woods Hard woods Exotic woods Veneers	
Wood-based materials	Laminated woods Particle materials Fiber boards Laminates Wood wool	Plywood etc. Particle boards MDF etc. HPL, CPL, Trespa, Multiplex etc. Heraklith etc.
Plastics	Thermoplastic Thermosets Fiber-reinforced plastics Polymer bound plastics	PA, PE, PMMA etc. Pertinax®, Restitex® etc. CFRP, GFRP etc. Corian®, Varicor®, Noblan®, Kerrock® etc.
Composite materials	Solid wood laminated with Panels laminated with Gypsum boards Gypsum plaster boards Cement bonded boards Mineral wool boards Plastics with metals (Alucobond® etc.)	HDF, MDF, veneer HPL, cork etc.
NF-Metals	Pure aluminum Al-Mg-Cu Al-Si alloys	

® different trade marks

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- HW-Service

Tool Checklist

Imperative features for special tools

	Saw Blades / Hoggers	Cutters with Bore	Finger Joint Cutters	Shank-Type Cutters	Drill Bits / Plunge Cutters	Profile Knives
Machine data						
Flange diameter	●					
Spindle diameter	●	●	●			
Spindle position	●	●	●	●		
RPM [n]	●	●	●	●		
Feedrate [Vf]	●	●	●	●	●	
Type of feed [MEC / MAN]	●	●	●	●		
Clamping system [e.g. TRIBOS, ps-System]	●	●	●	●	●	●
Machining data						
Workpiece material	●	●	●	●	●	●
Required cutting quality	●	●	●	●	●	●
Cutting direction [along, across, ...]	●	●		●		
Application [with feed, against feed]	●	●		●		
Design	●					
Tool data						
Product group [PHG]	●	●	●	●	●	●
Single / set tool	●	●	●	●	●	●
Outside diameter	●	●	●	●	●	●
Cutting width [B]	●	●	●	●		
Bore diameter 1, shank diameter 2 [d]	● ₁	● ₁	● ₁	● ₂	● ₂	
Number of teeth [T], Description of cutterhead	●	●	●	●	●	● ₁
Shear angle	●	●		●		
Raker 1; spur 2	● ₁	● ₂		● ₂	● ₂	
Pin holes [NL]	●	●				
Cutting material	●	●	●	●	●	●
Keyway [KN], double keyway [DKN]	●	●	●			
Plunging insert / face cutting edge				●		
Drawing						
Drawing	●	●	●	●	●	●
Tool dimension	●	●	●	●	●	●
Arrow indicating direction of rotation	●	●	●	●	●	

Tool Checklist

Imperative features for special tools

Date: _____

LEUCO sales person	_____	Offer / Order no.	_____
Customer	_____		
Address	_____		
Contact name	_____	Phone:	_____ Fax: _____
Customer no.	_____	E-mail:	_____

Machine data

Machine	_____	Type	_____
Flange Ø [mm]	_____	RPM [min-1]:	_____
Spindle Ø [mm]	_____	Clamping System	_____
Type of feed	_____	Spindle position	<input type="radio"/> Horizontal <input type="radio"/> Vertical <input type="radio"/> Tilted Degree of tilt [°] _____
			<input type="radio"/> MEC <input type="radio"/> MAN Feed rate [m/min]: _____

Machining data

Workpiece material	_____	Mode of application:	<input type="radio"/> Against feed <input type="radio"/> With feed
Cutting quality	<input type="radio"/> Trimming cut <input type="radio"/> Finish cut	<input type="radio"/> Pre-Trimming <input type="radio"/> Finish-Trimming	
Cutting direction	<input type="radio"/> With grain <input type="radio"/> Across grain	<input type="radio"/> Crosscut wood <input type="radio"/> Contour <input type="radio"/> Drill	
Profile as drawing no.	<input type="radio"/> Drawing <input type="radio"/> Wood sample	<input type="radio"/> Tool sample <input type="radio"/> Customer drawing	
Version hoggers	<input type="radio"/> Folding <input type="radio"/> Stepped	<input type="radio"/> Circular cut <input type="radio"/> Double hogging <input type="radio"/> Scoring / Hogging	

Tool data

Type of tool	_____	Prod. group	_____	Class-No.	_____
<input type="radio"/> Single tool	<input type="radio"/> Set tool	<input type="radio"/> Bolted		<input type="radio"/> Pinned	
Ø D [mm]	B [mm]	Ø d [mm]	_____	Hub diameter [mm]	_____
Z [qty.]	Raker [qty.]	Spur [qty.]	_____	<input type="radio"/> Face cutting edge	
KN [mm]	DKN [mm]	NL [mm]	_____	Minor diameter [mm]	_____
Shear angle <input type="radio"/> Yes <input type="radio"/> No	Hook angle [°]	TOK runout [°]	_____	Description of cutterhead	_____
Cutting material	<input type="radio"/> HS <input type="radio"/> Stellite	<input type="radio"/> HW <input type="radio"/> DP		Cutting material quality	_____

Drawing

482-01.0705



LEUCO SERVICES

Unique process optimization from a single source.

Market leaders in the tool industry are no longer simple tool manufacturers. The integration of tools, system components and services in order to become a solution provider gain in importance.

LEUCO is a provider of the most customized solutions for the customers and distinguishes itself from its competitors on the market.

THE LEUCO SERVICE PACKAGE COMPRISES SEVERAL STAGES.

The target of the structured service concept is to achieve an optimum in the manufacturing process, together with the customer.

LEUCO LEASING & CONSIGNMENT STOCK

The second mainstay of the LEUCO services package deals with billing models for the tools. This includes leasing or consignment stocks.

LEUCO COLOR CODING

Depending on the desired service in the LEUCO service package, the customer can also make use of an optimization of his production processes. Especially the visualization by means of the color coding creates a noticeably better transparency.

NETWORKED TOOLS

LEUCO is a partner for the platforms of the machine manufacturers. Twinio, for example, is the digital tool and material management app of tapio which is supported by LEUCO. This app offers transparency and allows the access to the digital tool data of LEUCO. Twinio provides answers to questions such as: what tools do I have in my company, where is which tool located and what are the basic dimensions of my saw blade? Twinio users can also save individual data per tool, e.g. the running meter performance of a saw blade.



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01

Code designations of the cutting materials

NEW - according to ISO	Signification	Old name
SP	alloyed tool steel (minimum 0.6% C and no more than 5 % alloy constituents)	SP
HS	high-alloyed steel (more than 12 % alloy elements Mo, V, Co in total)	HSS
ST	casting alloy on cobalt basis e.g. Stellite	Stellite
HW	uncoated tungsten carbide	HM
VHW	solid tungsten carbide	VHM
DP	polycrystalline diamond	DIA

02

Tool Attributes

Short form	Significance
NL	pin holes
KN	keyway
DKN	double keyway
n	permitted range of RPM
n max	maximum RPM
U min-1	rotations per minute
Vc	cutting speed
Vf	feedrate
Z	number of teeth

03

Types of feed

Short form	Significance
MEC	mechanical feed
MAN	manual feed

04

Delivery signs

Short form	Significance
⊕	modification and/or mounting of stock parts
o	available on short notice
s	production per drawing
#	new type in process
\$	Superstandard

All Ident-No. are available from stock unless specifically indicated.

LEUCO Ledermann GmbH & Co. KG fulfills all demands of ISO ISO 9001:2015.
The certificate-no. is 01 100 010679.



SHARPENING SERVICE IN MANUFACTURER-QUALITY

If your tool is dull or damaged: we sharpen and repair your tools in our LEUCO service centers using our know-how as a tool manufacturer.

Take a look at the new LEUCO sharpening service video to see how a dull tool moves through the various process steps in the LEUCO service center to become a freshly sharpened precision tool in manufacturer quality.

You can find the contact information of your competent LEUCO service partner at the end of the catalog or contact us at:

+49 (0) 7451 / 93 - 0 or info@leuco.com

TO THE
VIDEO



www.youtube.com/leucotooling



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