

# Panel processing

Leitz Lexicon Edition 7

Version 3

01/2026



## Explanation of abbreviations

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

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

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

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

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

|     |                 |
|-----|-----------------|
| GEW | = thread        |
| GL  | = total length  |
| GS  | = Plunging edge |

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

|    |                      |
|----|----------------------|
| ID | = ident number       |
| IV | = insulation glazing |

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

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

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

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

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

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

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

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

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

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

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

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

|     |                      |
|-----|----------------------|
| WSS | = workpiece material |
|-----|----------------------|

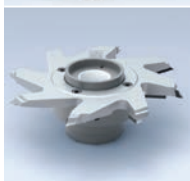
|    |                                    |
|----|------------------------------------|
| Z  | = number of teeth                  |
| ZA | = number of fingers                |
| ZF | = tooth shape (cutting edge shape) |
| ZL | = finger length                    |

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

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



## 2. Panel processing



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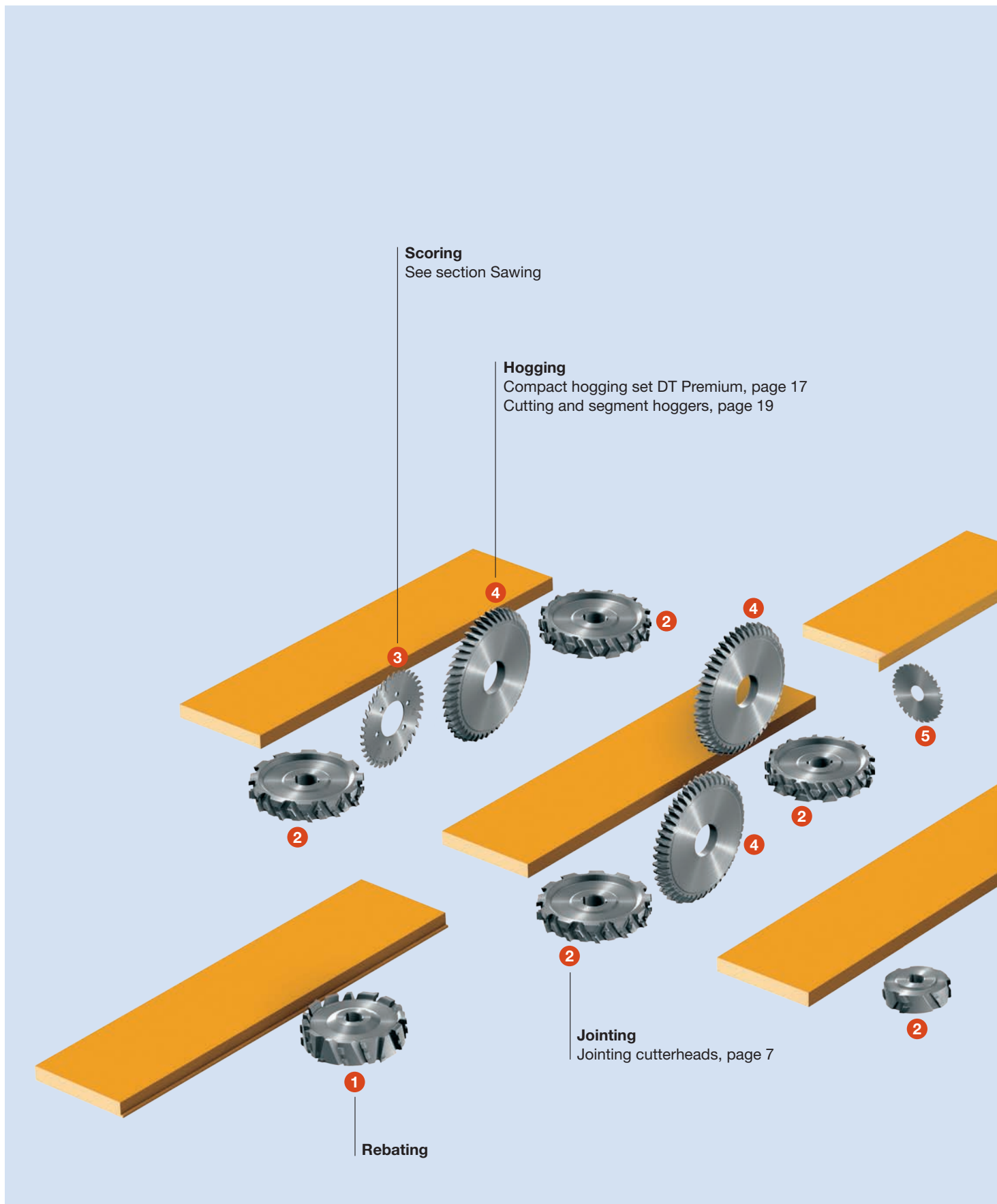
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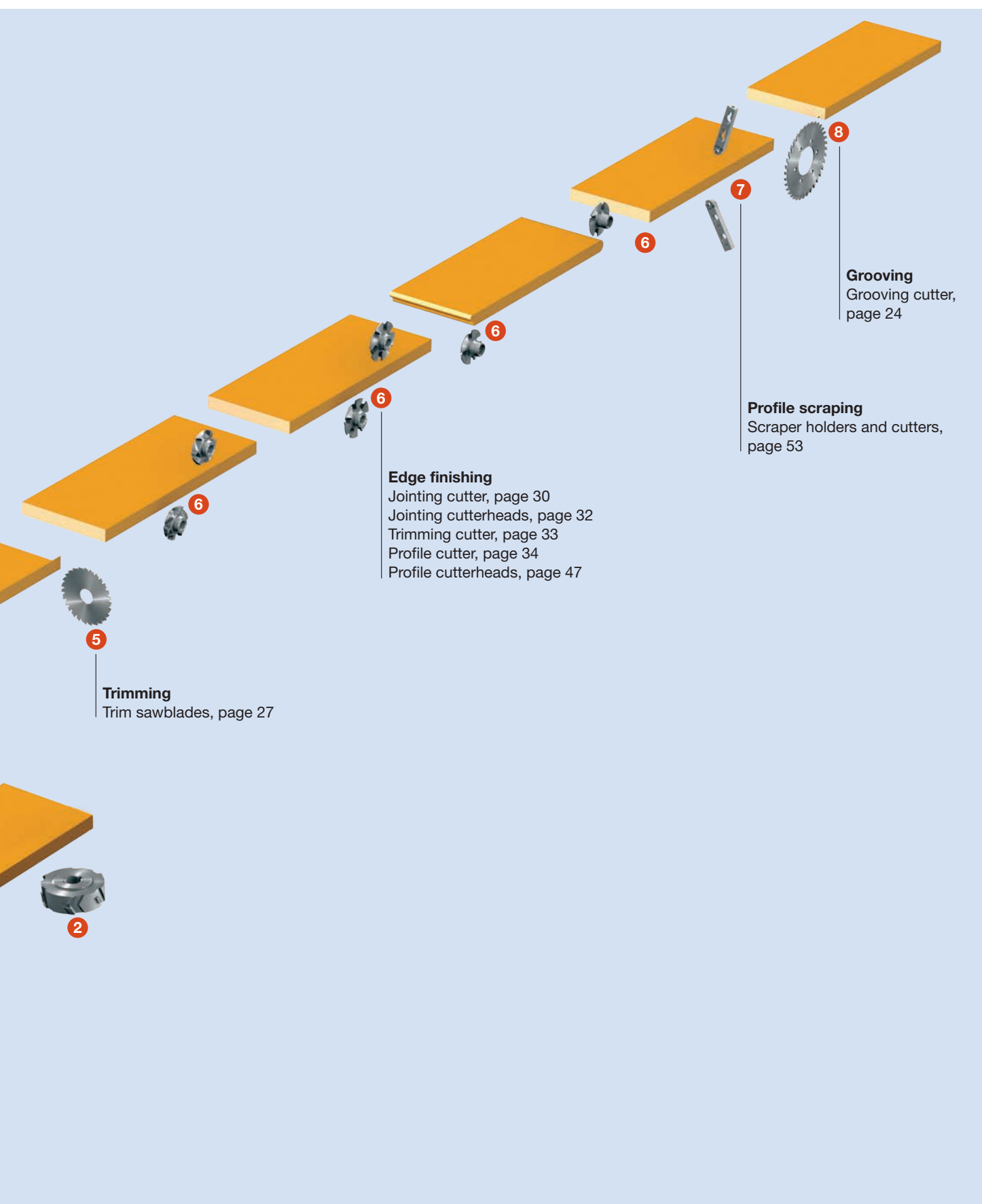
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## 2. Panel processing

### 2.1 Edge processing

#### 2.1.1 Edging processing machines





### Trimming

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### Edge finishing

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### Grooving

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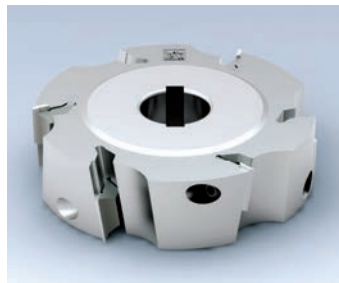
## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

|                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|---------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Type of operation</b>  | Cutting of the finished size with pre-sized, panel shaped working pieces. Therefore the jointing tools only are peripheral cutting and not with side relief!                                                                                                                                                                                                                                                                                                |
| <b>Workpiece material</b> | Softwood and hardwood, glulam, chipboard and fibre material, uncoated and veneered, plastic and paper coated.                                                                                                                                                                                                                                                                                                                                               |
| <b>Machines</b>           | Spindle moulders, edgebanding machines with sizing part, double end tenoners. Counter milling or jump cutting: Depending on the processing quantity and material, diamond tools or cutterheads with tungsten carbide turnblades are used.                                                                                                                                                                                                                   |
| <b>Application</b>        | Jointing against feed: For all panel working materials with or without coating.<br>Jointing with feed: For machining solid wood with heavily irregular course of fibres and risk of tear outs. Only allowed for machines with mechanical feed. Note: Chips are very difficult to remove.<br>Jump cutting: Jointing with and against feed when cutting across, to prevent tear outs on the front and backside of the workpiece when these are already glued. |

#### Tool Designs



Turnblade cutterhead with alternate shear angle: Suitable for all coated and uncoated panel shaped working materials. Turnblade tools with shear angle produce a curved surface on the workpiece. For exactly straight jointing edges we recommend ProfilCut profile cutterheads with profiled edges (special production) or diamond jointing cutters.

Diamond jointing cutter with alternate shear angle:

S = with symmetrical edge arrangement: Produce a slight hollow section on the milled jointing edge. This has the advantage that the edgebanding on the outside edge close tightly. The tool always must be adjusted symmetrically to the workpiece thickness.

The tool can be used in RH and LH rotation.

AS = Asymmetrical edge arrangement: One cutting edge cuts from bottom to top, the top cutting edges all are directed downward which is advantageous for frequently changing material thicknesses.



2-part tools on synchronically adjustable sleeve:

These tools with alternate shear angles are advantageous for high quantities and nearly constant workpiece thicknesses as with increasing tool blunting the jointing edges on the coating do not remain tear-free. The stepless and synchronic adjustment allows the use of multiple performance times and thus an increase of the tool lifetime.

#### Diamaster WhisperCut



Diamaster WhisperCut – The lightweight and efficient jointing cutterhead for low noise sizing of panel material.

Advantages at a glance:

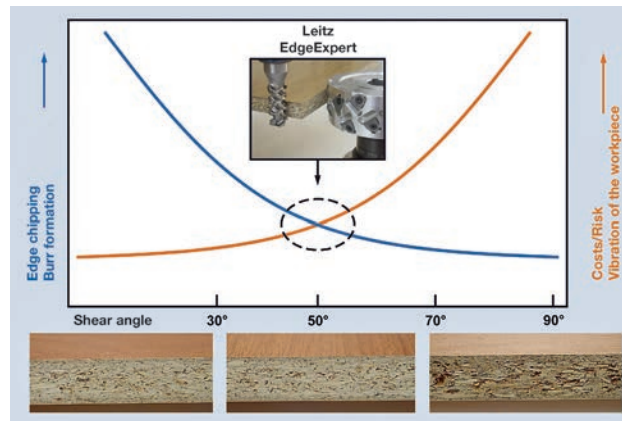
- Significant noise reduction of up to 5 dB(A) through optimized tool body shape and weight halving
- Trouble free chip ejection and excellent chip collection through DFC technology
- Individual use as per customer requirement: resharpenable or as changing knife system

##### Diamaster EdgeExpert



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

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

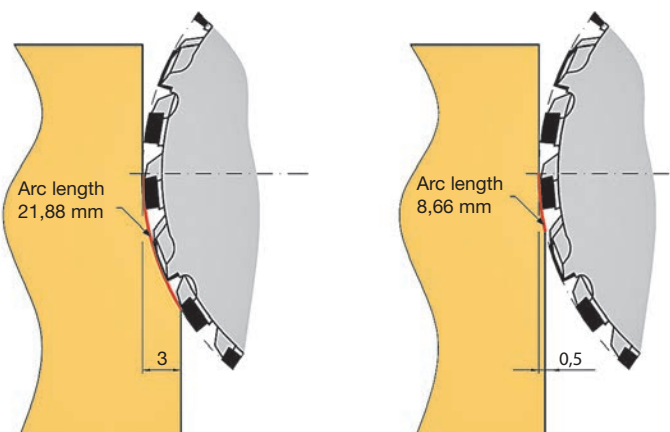


##### Dust collection

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

##### Chip removal

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



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

##### Noise emission

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

##### Service

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

##### Resharpener Diamaster WhisperCut



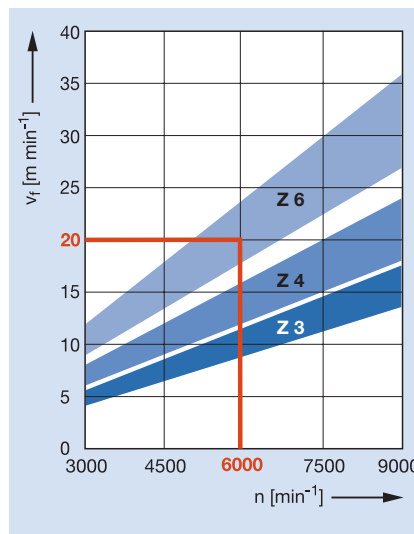
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times  
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

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

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

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

Material: Chipboard with melamine  
resin coating





### WhisperCut jointing / milling cutter - cutterhead design

#### Application:

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

#### Machine:

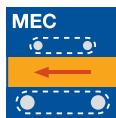
Edgebanding machines, copy shaping machines, double-end tenoners etc.

#### Workpiece material:

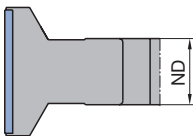
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

#### Technical information:

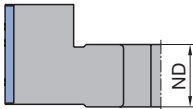
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surfaces. Tool with knife arrangement S can be used left and right and produces hollow cut for tightly closing edgebanding. Low noise design with up to 5 dB(A) noise reduction and highly efficient chip collection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



Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3

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

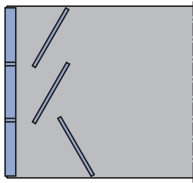
WF 230 2 DP, WM 230 2 01

| Machine     | D<br>mm | SB<br>mm | ND<br>mm | BO<br>mm | NAL | Z | Knife<br>Type | Type | ID<br>LH | ID<br>RH          |
|-------------|---------|----------|----------|----------|-----|---|---------------|------|----------|-------------------|
| Ayza Mizrak | 70      | 54       | 30       | 20       | DKN | 2 | 2x5           | 10xD | AS       | 192320 • 192321 • |
| Ayza Mizrak | 125     | 54       | 40       | 30       | DKN | 3 | 3x5           | 15xE | AS       | 192326 • 192327 • |
| Biesse      | 80      | 45       | 53       | 30       | DKN | 1 | 2x4           | 8xB  | S        | 192127 • 192127 • |
| Biesse      | 80      | 65       | 53       | 30       | DKN | 2 | 2x6           | 12xB | S        | 192128 • 192128 • |
| Biesse      | 100     | 43       | 75       | 30       | DKN | 1 | 3x4           | 12xA | S        | 192088 • 192088 • |
| Biesse      | 100     | 65       | 75       | 30       | DKN | 1 | 3x6           | 18xA | S        | 192089 • 192089 • |
| Biesse      | 125     | 43       | 40       | 30       | DKN | 2 | 3x4           | 12xE | S        | 075627 • 075627 • |
| Biesse      | 125     | 43       | 51       | 30       | DKN | 2 | 3x5           | 12xE | AS°      | 192379 • 192380 • |
| Biesse      | 125     | 61       | 51       | 30       | DKN | 2 | 3x6           | 15xE | AS°      | 192381 • 192382 • |
| Biesse      | 125     | 63       | 40       | 30       | DKN | 2 | 3x6           | 18xE | S        | 075626 • 075626 • |
| Brandt      | 100     | 43,6     | 40,6     | 25       | DKN | 3 | 2x4           | 8xA  | AS       | 192211 • 192212 • |
| Brandt      | 100     | 62,5     | 40,6     | 25       | DKN | 3 | 2x6           | 12xA | AS       | 192345 • 192346 • |
| Brandt      | 100     | 43,6     | 40,6     | 30       | DKN | 3 | 3x4           | 12xA | AS       | 090885 • 090886 • |
| Brandt      | 100     | 65,2     | 40,6     | 30       | DKN | 3 | 3x6           | 18xA | AS       | 090887 • 090888 • |
| Brandt      | 100     | 105      | 85       | 30       | DKN | 3 | 3x10          | 30xA | AS       | 090891 • 090892 • |
| Cehisa      | 100     | 54       | 25       | 20       | DKN | 2 | 2x5           | 10xA | AS       | 192078 • 192079 • |
| EBM         | 70      | 43       | 61       | 25       | DKN | 1 | 2x4           | 8xB  | AS       | 192237 • 192238 • |
| EBM         | 70      | 63       | 81       | 25       | DKN | 1 | 2X6           | 12xB | AS       | 192239 • 192240 • |
| EBM         | 100     | 43       | 61       | 30       | DKN | 1 | 2x4           | 8xB  | AS       | 192233 • 192234 • |
| EBM         | 100     | 63       | 81       | 30       | DKN | 1 | 2x6           | 12xB | AS       | 192235 • 192236 • |
| Felder      | 60      | 63       | 63.5     | 25       | DKN | 3 | 2x7           | 12xC | AS°      | 192278 •          |
| Felder      | 60      | 63       | 63.5     | 25       | DKN | 3 | 2x7           | 12xC | AS°      | 192277 •          |
| Felder      | 80      | 48,5     | 64       | 25       | DKN | 1 | 3x6           | 12xF | AS°      | 192281 • 192282 • |
| Felder      | 80      | 64       | 64       | 25       | DKN | 3 | 2x7           | 12xF | AS°      | 192300 •          |
| Felder      | 80      | 64       | 64       | 25       | DKN | 3 | 2x7           | 12xF | AS°      | 192299 •          |
| Felder      | 80      | 64       | 64       | 25       | DKN | 3 | 3x7           | 18xF | AS°      | 192279 •          |
| Felder      | 80      | 64       | 64       | 25       | DKN | 3 | 3x7           | 18xF | AS°      | 192280 •          |
| Felder      | 100     | 45       | 68       | 30       | DKN | 1 | 3x4           | 12xA | S        | 192400 • 192400 • |
| Felder      | 100     | 64       | 68       | 30       | DKN | 2 | 3x6           | 18xB | S        | 192399 • 192399 • |
| Fravol      | 60      | 63       | 63.5     | 25       | DKN | 3 | 2x7           | 12xC | AS°      | 192247 •          |

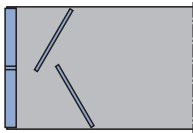
• available ex stock

□ available at short notice

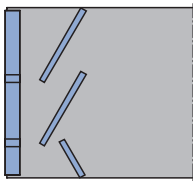
Instruction manual visit [www.leitz.org](http://www.leitz.org)



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



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

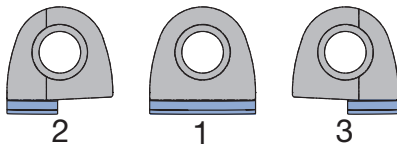
| Machine   | D<br>mm | SB<br>mm | ND<br>mm | BO<br>mm |     | NAL | Z    | Knife<br>Type | Type | ID<br>LH | ID<br>RH |
|-----------|---------|----------|----------|----------|-----|-----|------|---------------|------|----------|----------|
| Fraval    | 60      | 63       | 63.5     | 25       | DKN | 3   | 2x7  | 12xC          | AS°  |          | 192248 ● |
|           |         |          |          |          |     |     |      | 2xC2          |      |          |          |
| Fraval    | 100     | 65       | 56.5     | 30       | DKN | 3   | 2x6  | 12xA          | AS   | 192243   | 192244   |
| Fraval    | 100     | 84       | 56.5     | 30       | DKN | 3   | 2x8  | 14xA          | AS°  | 192285 ● |          |
|           |         |          |          |          |     |     |      | 14xA1         |      |          |          |
| Fraval    | 100     | 84       | 56.5     | 30       | DKN | 3   | 2x8  | 14xA          | AS°  |          | 192286 ● |
|           |         |          |          |          |     |     |      | 14xA2         |      |          |          |
| Fraval    | 100     | 124      | 96       | 30       | DKN | 2   | 2x11 | 22xA          | AS   | 192245   | 192246   |
| Hebrock   | 70      | 43       | 61       | 25       | DKN | 1   | 2x4  | 8xB           | AS   | 192237 ● | 192238 ● |
| Hebrock   | 70      | 63       | 81       | 25       | DKN | 1   | 2X6  | 12xB          | AS   | 192239 ● | 192240 ● |
| Hebrock   | 100     | 43       | 61       | 30       | DKN | 1   | 2x4  | 8xB           | AS   | 192233 ● | 192234 ● |
| Hebrock   | 100     | 63       | 81       | 30       | DKN | 1   | 2x6  | 12xB          | AS   | 192235 ● | 192236 ● |
| Holz-Her  | 70      | 48       | 41       | 30       | DKN | 2   | 2x5  | 8xD           | AS°  |          | 192221 ● |
| 1801/1802 |         |          |          |          |     |     |      | 2xD2          |      |          |          |
| Holz-Her  | 70      | 48       | 41       | 30       | DKN | 2   | 2x5  | 8xD           | AS°  | 192222 ● |          |
| 1801/1802 |         |          |          |          |     |     |      | 2xD1          |      |          |          |
| Holz-Her  | 70      | 64       | 41       | 30       | DKN | 2   | 2x7  | 12xD          | AS°  |          | 192223 ● |
| 1801/1802 |         |          |          |          |     |     |      | 2xD2          |      |          |          |
| Holz-Her  | 70      | 64       | 41       | 30       | DKN | 2   | 2x7  | 12xD          | AS°  | 192224 ● |          |
| 1801/1802 |         |          |          |          |     |     |      | 2xD1          |      |          |          |
| Holz-Her  | 100     | 63       | 39,5     | 30       | DKN | 2   | 3x6  | 18xB          | S    | 192147   | 192148   |
| 1804      |         |          |          |          |     |     |      |               |      |          |          |
| Holz-Her  | 100     | 43       | 25       | 30       | DKN | 2   | 2x4  | 8xA           | AS   | 192082 ● | 192083 ● |
| 1891      |         |          |          |          |     |     |      |               |      |          |          |
| Holz-Her  | 100     | 65       | 25       | 30       | DKN | 2   | 2x6  | 12xA          | AS   | 192084   | 192085   |
| 1891      |         |          |          |          |     |     |      |               |      |          |          |
| Holz-Her  | 100     | 63       | 39,5     | HSK 32   | R 2 |     | 3x6  | 18xB          | S    | 192307   | 192308   |
| FG701     |         |          |          |          |     |     |      |               |      |          |          |
| Homag     | 100     | 43,6     | 40,6     | 25       | DKN | 3   | 2x4  | 8xA           | AS   | 192211 ● | 192212 ● |
| Homag     | 100     | 62,5     | 40,6     | 25       | DKN | 3   | 2x6  | 12xA          | AS   | 192345   | 192346   |
| Homag     | 100     | 43,6     | 40,6     | 30       | DKN | 3   | 3x4  | 12xA          | AS   | 090885 ● | 090886 ● |
| Homag     | 100     | 65,2     | 40,6     | 30       | DKN | 3   | 3x6  | 18xA          | AS   | 090887 ● | 090888 ● |
| Homag     | 100     | 105      | 85       | 30       | DKN | 3   | 3x10 | 30xA          | AS   | 090891   | 090892   |
| Homag     | 125     | 42,6     | 54       | 30       | DKN | 3   | 3x4  | 12xA          | AS   | 192287 ● | 192288 ● |
| Homag     | 125     | 43       | 40       | 30       | DKN | 2   | 3x4  | 12xE          | S    | 075627 ● | 075627 ● |
| Homag     | 125     | 63       | 40       | 30       | DKN | 2   | 3x6  | 18xE          | S    | 075626 ● | 075626 ● |
| Homag     | 125     | 63       | 54       | 30       | DKN | 3   | 3x6  | 18xA          | AS   | 192289   | 192290   |
| IMA       | 125     | 32       | 34       | 30       | DKN | 2   | 3x4  | 12xD          | AS   | 192092   | 192093   |
| IMA       | 125     | 43       | 42       | 30       | DKN | 2   | 3x5  | 15xD          | AS   | 192094 ● | 192095 ● |
| IMA       | 125     | 63       | 42       | 30       | DKN | 3   | 3x7  | 21xD          | AS   | 192096 ● | 192097 ● |
| IMA       | 125     | 43       | 57       | 30       | DKN | 1   | 3x5  | 15xD          | AS   | 192098 ● | 192099 ● |
| Advantage |         |          |          |          |     |     |      |               |      |          |          |
| IMA       | 125     | 65       | 57       | 30       | DKN | 1   | 3x7  | 21xD          | AS   | 192100 ● | 192101 ● |
| Advantage |         |          |          |          |     |     |      |               |      |          |          |
| Lange     | 60      | 65       | 62       | 20       | DKN | 2   | 2x7  | 12xC          | AS°  | 192397   |          |
|           |         |          |          |          |     |     |      | 2xC1          |      |          |          |
| Lange     | 60      | 65       | 62       | 20       | DKN | 2   | 2x7  | 12xC          | AS°  |          | 192398   |
|           |         |          |          |          |     |     |      | 2xC2          |      |          |          |
| Mizrak    | 70      | 54       | 30       | 20       | DKN | 2   | 2x5  | 10xD          | AS   | 192320 ● | 192321 ● |
| Makine    |         |          |          |          |     |     |      |               |      |          |          |
| Nanxing   | 125     | 35       | 32       | 30       | DKN | 2   | 3x4  | 12xE          | S    | 192419   | 192419   |
| Nanxing   | 125     | 43       | 40       | 30       | DKN | 2   | 3x4  | 12xE          | AS   | 192418   | 192417   |
| Nanxing   | 125     | 55       | 40       | 30       | DKN | 1   | 4x5  | 20xE          | AS   | 192421   | 192420   |
| Ott       | 85      | 48       | 50       | 30       | DKN | 3   | 3x5  | 12xB          | AS°  | 192209 ● |          |
|           |         |          |          |          |     |     |      | 3xB1          |      |          |          |
| Ott       | 85      | 48       | 50       | 30       | DKN | 3   | 3x5  | 12xB          | AS°  |          | 192210 ● |
|           |         |          |          |          |     |     |      | 3xB2          |      |          |          |
| Ott       | 85      | 65       | 45       | 30       | DKN | 2   | 3x6  | 18xB          | AS   | 192227 ● | 192228 ● |
| Ott       | 85      | 85       | 50       | 30       | DKN | 3   | 3x8  | 24xB          | AS   | 192229   | 192230   |
| Ott       | 100     | 43,6     | 40,6     | 30       | DKN | 3   | 3x4  | 12xA          | AS   | 192413 ● | 192414 ● |
| Ott       | 100     | 65,2     | 40,6     | 30       | DKN | 3   | 3x6  | 18xA          | AS   | 192415 ● | 192416 ● |
| SCM       | 80      | 56       | 58       | 30       | DKN | 2   | 2x6  | 10xC          | AS°  | 192318   |          |
|           |         |          |          |          |     |     |      | 2xC1          |      |          |          |
| SCM       | 80      | 56       | 58       | 30       | DKN | 2   | 2x6  | 10xC          | AS°  |          | 192319   |
|           |         |          |          |          |     |     |      | 2xC2          |      |          |          |
| SCM       | 100     | 51       | 60       | 30       | DKN | 3   | 2x6  | 8xB           | AS°  | 192215 ● | 192216 ● |
|           |         |          |          |          |     |     |      | 2xB1          |      |          |          |
|           |         |          |          |          |     |     |      | 2xB2          |      |          |          |

| Machine            | D<br>mm | SB<br>mm | ND<br>mm | BO<br>mm   | NAL | Z   | Knife<br>Type        | Type | ID<br>LH        | ID<br>RH        |
|--------------------|---------|----------|----------|------------|-----|-----|----------------------|------|-----------------|-----------------|
| SCM                | 100     | 51       | 60       | 30 DKN     | 3   | 3x6 | 12xB<br>3xB1<br>3xB2 | AS°  | <b>192217 •</b> | <b>192218 •</b> |
| SCM                | 100     | 66       | 60       | 30 DKN     | 3   | 2x7 | 12xB<br>2xB1<br>2xB2 | AS°  | <b>192213 •</b> |                 |
| SCM                | 100     | 66       | 60       | 30 DKN     | 3   | 2x7 | 12xB<br>2xB2         | AS°  |                 | <b>192214 •</b> |
| SCM                | 100     | 66       | 60       | 30 DKN     | 3   | 3x7 | 18xB<br>3xB1         | AS°  | <b>192219 •</b> |                 |
| SCM                | 100     | 66       | 60       | 30 DKN     | 3   | 3x7 | 18xB<br>3xB2         | AS°  |                 | <b>192220 •</b> |
| SCM                | 125     | 51       |          | HSK 32 R 2 |     | 3x6 | 12xA<br>3xA1<br>3xA2 | AS°  | <b>192337</b>   | <b>192338</b>   |
| SCM                | 125     | 51       |          | HSK 32 R 2 |     | 4x6 | 16xA<br>4xA1<br>4xA2 | AS°  | <b>192341</b>   | <b>192342</b>   |
| SCM                | 125     | 66       |          | HSK 32 R 2 |     | 3x7 | 18xA<br>3xA1         | AS°  | <b>192339</b>   |                 |
| SCM                | 125     | 66       |          | HSK 32 R 2 |     | 3x7 | 18xA<br>3xA2         | AS°  |                 | <b>192340</b>   |
| SCM                | 125     | 66       |          | HSK 32 R 2 |     | 4x7 | 24xA<br>4xA1         | AS°  | <b>192343</b>   |                 |
| SCM                | 125     | 66       |          | HSK 32 R 2 |     | 4x7 | 24xA<br>4xA2         | AS°  |                 | <b>192344</b>   |
| Stefani            | 100     | 51       | 60       | 30 DKN     | 3   | 2x6 | 8xB<br>2xB1<br>2xB2  | AS°  | <b>192215 •</b> | <b>192216 •</b> |
| Stefani            | 100     | 51       | 60       | 30 DKN     | 3   | 3x6 | 12xB<br>3xB1<br>3xB2 | AS°  | <b>192217 •</b> | <b>192218 •</b> |
| Stefani            | 100     | 66       | 60       | 30 DKN     | 3   | 2x7 | 12xB<br>2xB1<br>2xB2 | AS°  | <b>192213 •</b> |                 |
| Stefani            | 100     | 66       | 60       | 30 DKN     | 3   | 2x7 | 12xB<br>2xB2         | AS°  |                 | <b>192214 •</b> |
| Stefani            | 100     | 66       | 60       | 30 DKN     | 3   | 3x7 | 18xB<br>3xB1         | AS°  | <b>192219 •</b> |                 |
| Stefani            | 100     | 66       | 60       | 30 DKN     | 3   | 3x7 | 18xB<br>3xB2         | AS°  |                 | <b>192220 •</b> |
| Turanlar<br>Makine | 70      | 54       | 30       | 20 DKN     | 2   | 2x5 | 10xD                 | AS   | <b>192320 •</b> | <b>192321 •</b> |
| Turanlar<br>Makine | 70      | 54       | 30       | 20 DKN     | 2   | 3x5 | 15xD                 | AS   | <b>192324</b>   | <b>192325</b>   |
| Turanlar<br>Makine | 125     | 54       | 30       | 30 DKN     | 3   | 3x5 | 15xE                 | AS   | <b>192322</b>   | <b>192323</b>   |
| Türk Makine        | 100     | 65,2     | 40,6     | 30 DKN     | 3   | 3x6 | 18xA                 | AS   | <b>192415 •</b> | <b>192416 •</b> |

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



Shape of WhisperCut spare knives  
SB 6.7 / 14 mm

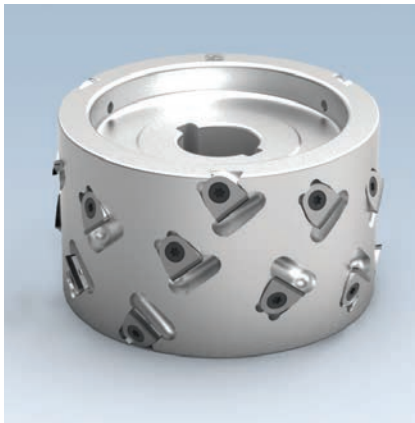
##### Spare knives:

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

Eroded spare knives for quick and easy knife change.

##### Spare parts:

| BEZ                                | ABM<br>mm     | Machine                 | ID       |
|------------------------------------|---------------|-------------------------|----------|
| Securing part set                  | 40/30x8 M12   | Holz-Her 1801/1802      | 116011 ● |
| Spindle nut                        | 38x28 M25x1,5 | Felder, Fraval          | 066566 ● |
| Countersink screw,<br>Torx® 20/59° | M5x11.5       |                         | 007899 ● |
| Spanner wrench                     | 50x5          | Holz-Her up to YOM 2016 | 117538 ● |
| Torx® key                          | Torx® 20      |                         | 117503 ● |



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

#### Application:

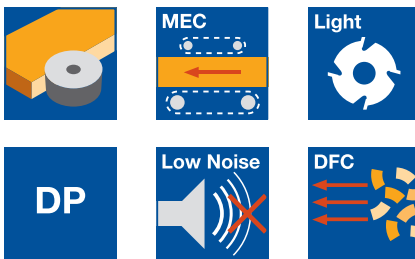
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

#### Machine:

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

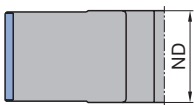
#### Workpiece material:

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

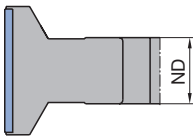


#### Technical information:

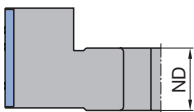
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for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



Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3

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

| Machine | D   | SB | ND   | BO     | NAL | Z   | Knife | Type | ID       | ID       |
|---------|-----|----|------|--------|-----|-----|-------|------|----------|----------|
|         | mm  | mm | mm   | mm     |     |     |       |      | LH       | RH       |
| Biesse  | 80  | 33 | 53   | 30 DKN | 1   | 3x4 | 12xG  | S    | 192375   | 192375   |
| Biesse  | 80  | 43 | 53   | 30 DKN | 1   | 3x6 | 18xG  | S    | 192356   | 192356   |
| Biesse  | 100 | 33 | 75   | 30 DKN | 1   | 3x4 | 12xH  | S    | 192376   | 192376   |
| Biesse  | 100 | 43 | 75   | 30 DKN | 1   | 3x6 | 18xH  | S    | 192357   | 192357   |
| Biesse  | 125 | 33 | 40   | 30 DKN | 2   | 3x4 | 12xl  | S    | 192373   | 192373   |
| Biesse  | 125 | 33 | 40   | 30 DKN | 2   | 4x4 | 16xl  | S    | 192374   | 192374   |
| Biesse  | 125 | 43 | 40   | 30 DKN | 2   | 3x6 | 18xl  | S    | 192249 • | 192249 • |
| Biesse  | 125 | 43 | 48   | 30 DKN | 2   | 3x6 | 15xl  | AS°  | 192383   |          |
| Biesse  | 125 | 43 | 48   | 30 DKN | 2   | 3x6 | 15xl  | AS°  |          | 192384   |
| Biesse  | 125 | 43 | 40   | 30 DKN | 2   | 4x6 | 24xl  | S    | 192358   | 192358   |
| Biesse  | 125 | 63 | 40   | 30 DKN | 2   | 3x8 | 24xJ  | S    | 192250   | 192250   |
| Biesse  | 125 | 63 | 48   | 30 DKN | 2   | 3x9 | 24xl  | AS°  | 192392   |          |
| Biesse  | 125 | 63 | 48   | 30 DKN | 2   | 3x9 | 24xl  | AS°  |          | 192393   |
| Homag   | 100 | 33 | 40.6 | 30 DKN | 3   | 3x4 | 12xH  | AS   | 192371   | 192372   |
| Homag   | 100 | 43 | 40.6 | 25 DKN | 3   | 3x5 | 15xl  | AS   | 192361   | 192362   |
| Homag   | 100 | 43 | 40.6 | 30 DKN | 3   | 3x5 | 15xl  | AS   | 192359 • | 192360 • |
| Homag   | 125 | 33 | 40   | 30 DKN | 2   | 3x4 | 12xl  | S    | 192373   | 192373   |
| Homag   | 125 | 33 | 40   | 30 DKN | 2   | 4x4 | 16xl  | S    | 192374   | 192374   |
| Homag   | 125 | 43 | 40   | 30 DKN | 2   | 3x6 | 18xl  | S    | 192249 • | 192249 • |
| Homag   | 125 | 43 | 54   | 30 DKN | 3   | 3x5 | 15xJ  | AS   | 192389   | 192390   |
| Homag   | 125 | 43 | 40   | 30 DKN | 2   | 4x6 | 24xl  | S    | 192358   | 192358   |
| IMA     | 125 | 43 | 40   | 30 DKN | 2   | 3x6 | 18xl  | AS   | 192251   | 192252   |
| IMA     | 125 | 43 | 42   | 30 DKN | 2   | 4x5 | 20xJ  | AS   | 192367   | 192368   |
| IMA     | 125 | 43 | 57   | 30 DKN | 1   | 4x5 | 20xJ  | AS   | 192369   | 192370   |
| IMA     | 125 | 63 | 40   | 30 DKN | 3   | 3x8 | 24xJ  | AS   | 192301   | 192302   |
| SCM     | 100 | 43 | 60   | 30 DKN | 1   | 3x6 | 15xH  | AS°  | 192363   |          |
| SCM     | 100 | 43 | 60   | 30 DKN | 1   | 3x6 | 15xH  | AS°  |          | 192364   |
| SCM     | 125 | 43 |      | HSK    | 2   | 4x6 | 20xl  | AS°  | 192365   |          |
| SCM     | 125 | 43 |      | 32 R   |     |     | 4xJ1  |      |          |          |
| SCM     | 125 | 43 |      | HSK    | 2   | 4x6 | 20xl  | AS°  |          | 192366   |
| SCM     | 125 | 43 |      | 32 R   |     |     | 4xJ2  |      |          |          |

• available ex stock

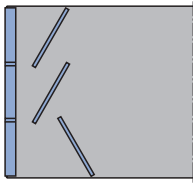
□ available at short notice

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

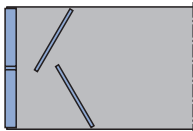
## 2. Panel processing

### 2.1 Edge processing

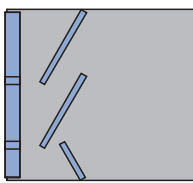
#### 2.1.2 Jointing cutters



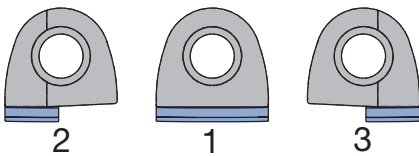
Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



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



Shape of WhisperCut spare knives  
SB 6.7 / 14 mm

##### Spare knives:

| BEZ                    | ABM<br>mm    | QAL | Type | Shape | ID       |
|------------------------|--------------|-----|------|-------|----------|
| WhisperCut-knife SB14  | 14x14.2x4.3  | DP  | G    | 1     | 091085 ● |
| WhisperCut-knife SB14  | 14x14.2x4.3  | DP  | H    | 1     | 091086 ● |
| WhisperCut-knife SB14  | 14x14.2x4.3  | DP  | I    | 1     | 091087 ● |
| WhisperCut-knife SB6,7 | 6.7x14.2x4.3 | DP  | I2   | 2     | 091093 ● |
| WhisperCut-knife SB6,7 | 6.7x14.2x4.3 | DP  | I1   | 3     | 091094 ● |
| WhisperCut-knife SB14  | 14x14.2x4.3  | DP  | J    | 1     | 091088 ● |
| WhisperCut-knife SB6,7 | 6.7x14.2x4.3 | DP  | J2   | 2     | 091095 ● |
| WhisperCut-knife SB6,7 | 6.7x14.2x4.3 | DP  | J1   | 3     | 091096 ● |

##### Spare parts:

| BEZ                             | ABM<br>mm | ID       |
|---------------------------------|-----------|----------|
| Countersink screw, Torx® 20/59° | M5x11.5   | 007899 ● |
| Torx® key                       | Torx® 20  | 117503 ● |



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

#### Application:

For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting).

#### Machine:

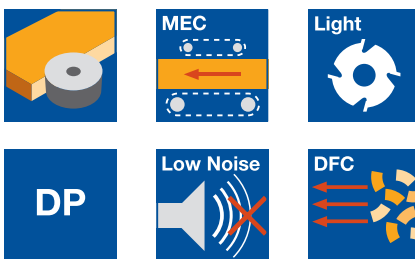
Edgebanding machines, copy shaping machines, double-end tenoners etc.

#### Workpiece material:

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

#### Technical information:

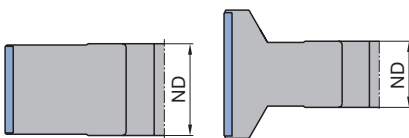
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. Resharpenable up to 12 times.



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

WM 230 2 02

| Machine | D   | SB   | ND | BO     | NAL | $n_{\max}$        | Z   | Type | ID            | ID            |
|---------|-----|------|----|--------|-----|-------------------|-----|------|---------------|---------------|
|         | mm  | mm   | mm | mm     |     | min <sup>-1</sup> |     |      | LH            | RH            |
| Biesse  | 84  | 45   | 53 | 30 DKN | 1   | 16600             | 2x4 | S    | <b>192401</b> | <b>192401</b> |
| Biesse  | 84  | 43   | 53 | 30 DKN | 1   | 16600             | 3x4 | S    | <b>192402</b> | <b>192402</b> |
| Biesse  | 100 | 43   | 75 | 30 DKN | 1   | 15300             | 3x4 | S    | <b>192403</b> | <b>192403</b> |
| Biesse  | 125 | 43   | 40 | 30 DKN | 2   | 13700             | 3x4 | S    | <b>192404</b> | <b>192404</b> |
| Homag   | 125 | 43   | 40 | 30 DKN | 2   | 13700             | 3x4 | S    | <b>192404</b> | <b>192404</b> |
| Homag   | 125 | 42,6 | 54 | 30 DKN | 3   | 13700             | 3x4 | AS   | <b>192405</b> | <b>192406</b> |

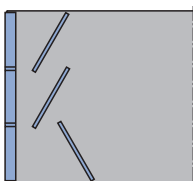


Position of boss (NAL) 1

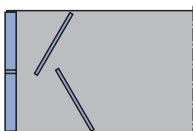
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement

#### Workpiece material:

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

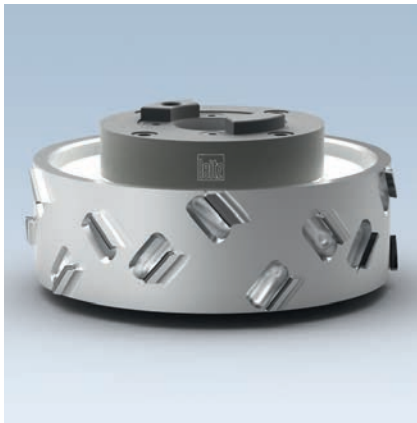
#### Technical information:

Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers.

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

WM 230 2 02

| Machine | D   | SB | ND | BO     | NAL | $n_{\max}$        | Z   | Type | ID            | ID            |
|---------|-----|----|----|--------|-----|-------------------|-----|------|---------------|---------------|
|         | mm  | mm | mm | mm     |     | min <sup>-1</sup> |     |      | LH            | RH            |
| Biesse  | 125 | 43 | 40 | 30 DKN | 2   | 13700             | 3x6 | S    | <b>192394</b> | <b>192394</b> |
| Homag   | 125 | 43 | 40 | 30 DKN | 2   | 13700             | 3x6 | S    | <b>192394</b> | <b>192394</b> |
| IMA     | 125 | 43 | 40 | 30 DKN | 2   | 13700             | 3x6 | AS   | <b>192395</b> | <b>192396</b> |



### Jointing / milling cutter on hydro sleeve

#### Application:

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

#### Machine:

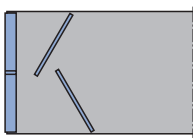
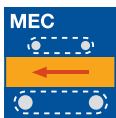
Edgebanding machines with zero joint technology.

#### Workpiece material:

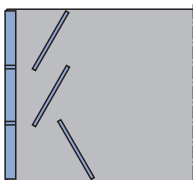
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

#### Technical information:

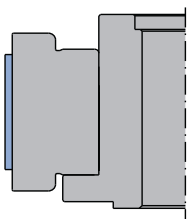
Increase of the processing quality through zero clearance hydro adaptor. Tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces hollow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



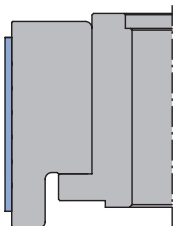
Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement



Position of boss (NAL) 1



Position of boss (NAL) 2

#### Diamaster PRO mounted on hydro sleeve

HF 230 2, HF 230 2 DP

| Machine | D<br>mm | SB<br>mm | BO<br>mm | $n_{\max}$<br>min <sup>-1</sup> | NAL | Z   | Type | ID<br>LH        | ID<br>RH        |
|---------|---------|----------|----------|---------------------------------|-----|-----|------|-----------------|-----------------|
| Homag   | 125     | 43       | 30       | 13600                           | 1   | 5x4 | S    | <b>192133</b>   | <b>192134</b>   |
| Homag   | 125     | 63       | 30       | 13600                           | 1   | 5x6 | S    | <b>192135</b>   | <b>192136</b>   |
| Homag   | 150     | 43       | 30       | 13600                           | 1   | 5x4 | S    | <b>192205</b> □ | <b>192206</b> □ |
| Homag   | 150     | 63       | 30       | 13600                           | 1   | 5x6 | S    | <b>192207</b> □ | <b>192208</b> □ |

#### Diamaster WhisperCut EdgeExpert mounted on hydro sleeve

HM 230 2 01

| Machine | D<br>mm | SB<br>mm | BO<br>mm | $n_{\max}$<br>min <sup>-1</sup> | NAL | Z   | Type | ID<br>LH      | ID<br>RH      |
|---------|---------|----------|----------|---------------------------------|-----|-----|------|---------------|---------------|
| IMA     | 125     | 43       | 30       | 13700                           | 1   | 4x6 | AS   | <b>192259</b> | <b>192258</b> |
| IMA     | 125     | 63       | 30       | 13700                           | 1   | 4x8 | AS   | <b>192261</b> | <b>192260</b> |
| IMA     | 150     | 43       | 30       | 13700                           | 1   | 4x6 | AS   | <b>192263</b> | <b>192262</b> |
| IMA     | 150     | 63       | 30       | 13700                           | 1   | 4x8 | AS   | <b>192265</b> | <b>192264</b> |

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

WM 230 2 01

| Machine | D<br>mm | SB<br>mm | BO<br>mm | $n_{\max}$<br>min <sup>-1</sup> | NAL | Z   | ID<br>LH      | ID<br>RH      |
|---------|---------|----------|----------|---------------------------------|-----|-----|---------------|---------------|
| IMA     | 125     | 65       | 30       | 13700                           | 2   | 4x7 | <b>192313</b> | <b>192312</b> |
| IMA     | 125     | 43,5     | 30       | 13700                           | 2   | 4x5 | <b>192315</b> | <b>192314</b> |

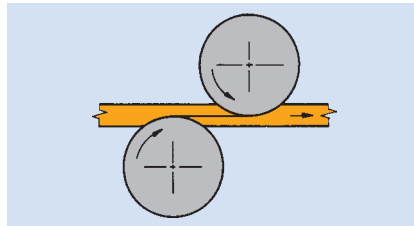
#### Spare parts:

|               |                      |                 |
|---------------|----------------------|-----------------|
| BEZ           | ABM<br>mm            | ID              |
| Securing part | for HF-spindle HF 30 | <b>066563</b> ● |
| Allen key     | SW 5, L 150          | <b>005501</b> ● |

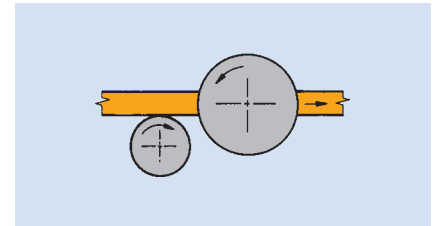
## 2. Panel processing

### 2.1 Edge processing 2.1.3 Compact hoggers - DP

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

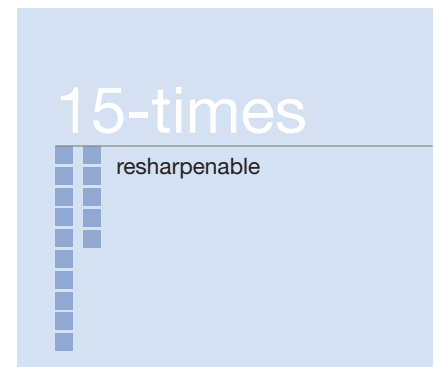
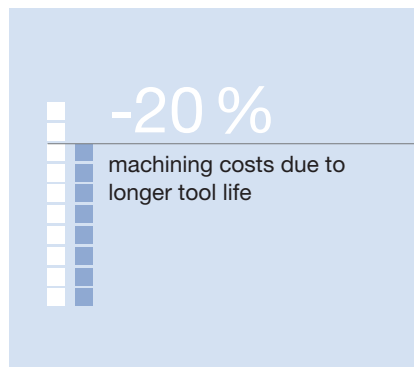


Double hogging: Both hoggers cut with feed.



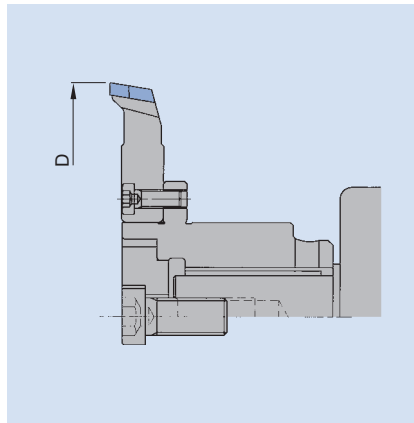
Scoring/hogging: Scoring saw cuts with feed, hogger against feed.

|                                  |                                                                                                                                                                                                                                                                                                                                                                            |
|----------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Compact hogger DT Premium</b> | Manufacturers are facing major challenges due to their customers demanding changing quantities as well as requesting a wide variety of carrier and decorative materials to be used in panel production. The new DT Premium compact hogger is the solution for increasing productivity thanks to its long tool life – with perfect quality on the edge and cutting surface. |
|----------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

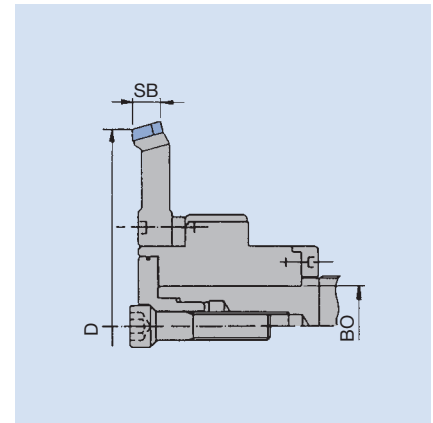


|                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
|--------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Productivity &amp; efficiency</b> | <p>Maximum economic efficiency through long tool life</p> <ul style="list-style-type: none"> <li>– Long tool life even under difficult operating conditions thanks to new tooth shape</li> <li>– Reduction of set-up costs due to long tool life</li> <li>– Efficient chip removal due to innovative gullet geometry and integrated chipbreaker</li> <li>– Cost efficient processing of various materials</li> <li>– Ideal also for batch size 1 due to adapted cutting geometries</li> <li>– Resharpenable up to 15 times through larger resharpening area</li> </ul> |
| <b>Quality</b>                       | <p>Perfect edges and cutting surfaces</p> <ul style="list-style-type: none"> <li>– Excellent edge quality and smooth cutting surfaces through adapted cutting geometries</li> <li>– Clean workpiece finishes due to efficient chip removal with DFC®-Technology</li> <li>– Constant cutting width over the entire life cycle</li> </ul>                                                                                                                                                                                                                                |
| <b>Sustainability</b>                | <p>Longer tool life time, less dust and noise</p> <ul style="list-style-type: none"> <li>– Reduced noise due to special tool design</li> <li>– Reduction of noise and vibration through damping elements</li> <li>– Longer tool life time through larger resharpening area</li> </ul>                                                                                                                                                                                                                                                                                  |

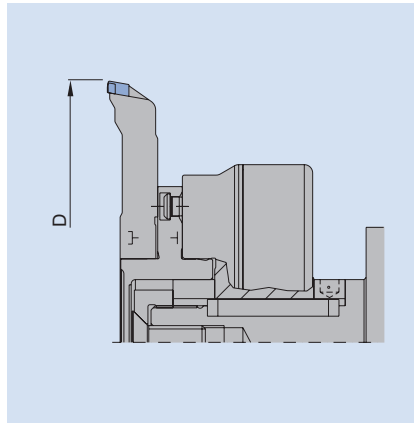
##### Designs



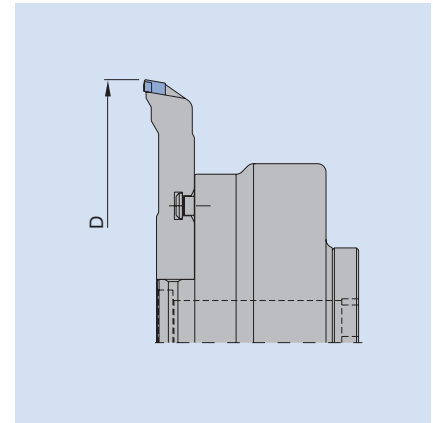
Tooth shape: top bevel decreasing.  
Hogger on standard flange.



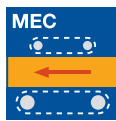
Tooth shape: top bevel increasing.  
Hogger on HF hydro sleeve.



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



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



#### Order example:

Hogging set D-250 mm, Z 36, right  
Hogging set consisting of:  
DT Premium hogger D-250 ID **190393**  
Hydro clamping sleeve ID **061702**

#### Special information:

Including assembly, machine model

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

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

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

For processing veneers, paper, honeycomb panels.

### Diamaster DT Premium

#### Application:

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

#### Machine:

Double-end tenoners, edgebanding machines etc.

#### Workpiece material:

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

#### Technical information:

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

#### Diamaster DT Premium

HZ 210 2

| D   | SB | BO | ZF | Z  | $v_f^*$             | ID              | ID              |
|-----|----|----|----|----|---------------------|-----------------|-----------------|
| mm  | mm | mm |    |    | m min <sup>-1</sup> | LH              | RH              |
| 250 | 10 | 60 | 1  | 24 | 30                  | <b>190382</b> □ | <b>190383</b> □ |
| 250 | 10 | 60 | 1  | 36 | 40                  | <b>190390</b> □ | <b>190391</b> □ |
| 250 | 10 | 60 | 1  | 48 | 50                  | <b>190398</b> ● | <b>190399</b> ● |
| 250 | 10 | 60 | 1  | 60 | 80                  | <b>190406</b>   | <b>190407</b>   |
| 250 | 10 | 60 | 2  | 24 | 30                  | <b>190384</b> □ | <b>190385</b> □ |
| 250 | 10 | 60 | 2  | 36 | 40                  | <b>190392</b> □ | <b>190393</b> □ |
| 250 | 10 | 60 | 2  | 48 | 50                  | <b>190400</b> □ | <b>190401</b> □ |
| 250 | 10 | 80 | 1  | 24 | 30                  | <b>190410</b>   | <b>190411</b>   |
| 250 | 10 | 80 | 1  | 36 | 40                  | <b>190418</b>   | <b>190419</b>   |
| 250 | 10 | 80 | 1  | 48 | 50                  | <b>190426</b> □ | <b>190427</b> □ |
| 250 | 10 | 80 | 2  | 24 | 30                  | <b>190412</b>   | <b>190413</b>   |
| 250 | 10 | 80 | 2  | 36 | 40                  | <b>190420</b>   | <b>190421</b>   |
| 250 | 10 | 80 | 2  | 48 | 50                  | <b>190428</b> □ | <b>190429</b> □ |

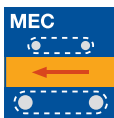
Further dimensions on request.

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

\* Recommended feed rate.

## 2. Panel processing

### 2.1 Edge processing 2.1.3 Compact hoggers - DP



#### Compact hogger

##### Application:

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

##### Machine:

Double-end tenoners, edgebanding machines etc.

##### Workpiece material:

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

##### Technical information:

Resharpenable 10 times. Hogger as standard with 4 pinholes reference diameter 100 and quick clamping system 160 (BO 60) and 192 (BO 80).

##### Compact hogger

HZ 210 2

| D   | SB  | BO | Z  | $v_f^*$             | ID              | ID              |
|-----|-----|----|----|---------------------|-----------------|-----------------|
| mm  | mm  | mm |    | m min <sup>-1</sup> | LH              | RH              |
| 250 | 6,5 | 60 | 35 | 35                  | <b>190478 ●</b> | <b>190479 ●</b> |
| 250 | 6,5 | 60 | 45 | 45                  | <b>190480 ●</b> | <b>190481 ●</b> |
| 250 | 6,5 | 60 | 55 | 55                  | <b>190482</b>   | <b>190483</b>   |
| 250 | 6,5 | 80 | 35 | 35                  | <b>190484</b>   | <b>190485</b>   |
| 250 | 6,5 | 80 | 45 | 45                  | <b>190486</b>   | <b>190487</b>   |
| 250 | 6,5 | 80 | 55 | 55                  | <b>190488</b>   | <b>190489</b>   |

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

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

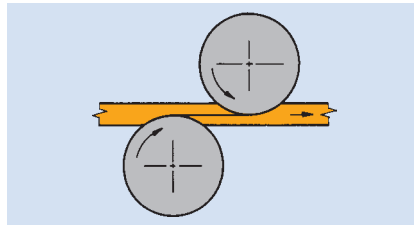
## 2. Panel processing

### 2.1 Edge processing

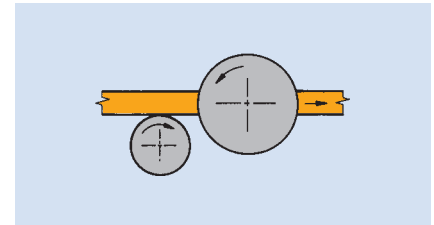
#### 2.1.4 Cutting and segment hoggers

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

#### Application



Double hogging:  
Both hoggers cut with feed.



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

#### Recommended tooth shape hogger sawblades

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

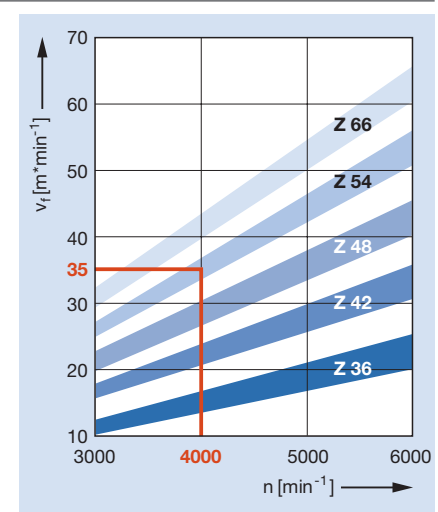
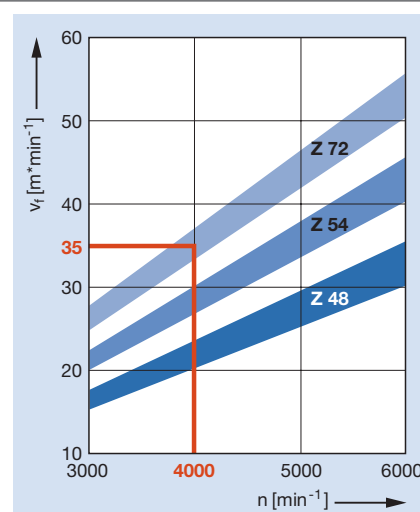
- suitable
- partly suitable

#### Cutting width and RPM

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

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

#### Segment hogger



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

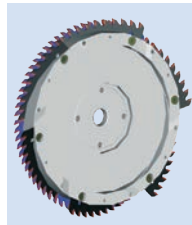
### 2.1 Edge processing

#### 2.1.4 Cutting and segment hoggers

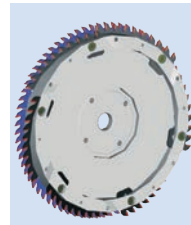
##### Segment hogger

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

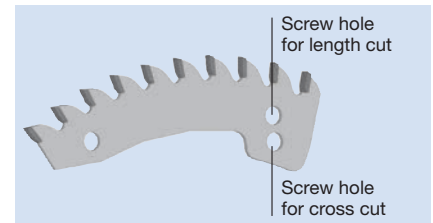
- Solid wood
- Wood derived materials without coating
- Wood derived materials with coating, with veneer, with paper etc.
- Composite materials



Cross cut



Length cut



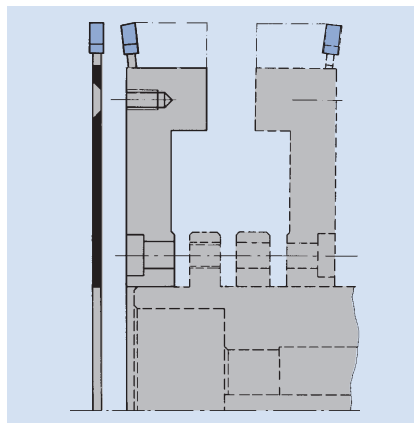
The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.

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

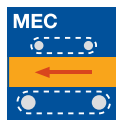
##### Saw hogger

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

##### Assembly design/examples



Segment hogger with extension hogger.



### Hoggers

#### Application:

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

#### Machine:

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

#### Workpiece material:

Solid wood and wood derived materials.

#### Technical information:

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

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

WZ 210 2 01, WZ 210 2 02

| BEZ              | D   | SB | BO | QAL | Z  | ID       | ID       |
|------------------|-----|----|----|-----|----|----------|----------|
|                  | mm  | mm | mm |     |    | LH       | RH       |
| Basic hogger     | 251 | 12 | 80 | HW  | 18 | 062602 ● | 062603 ● |
| Basic hogger     | 301 | 12 | 80 | HW  | 24 | 062604 ● | 062605 ● |
| Extension cutter | 251 | 12 | 80 | HW  | 18 | 062652 ● | 062653 ● |

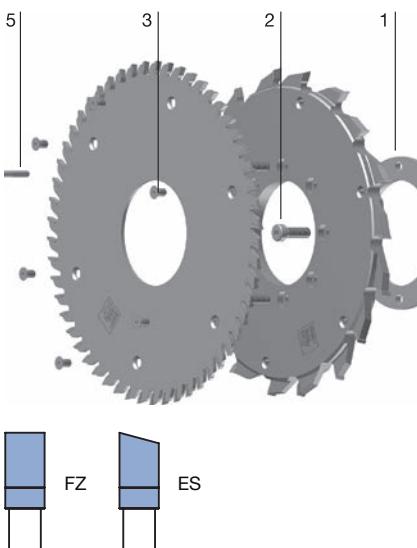
#### Spare parts:

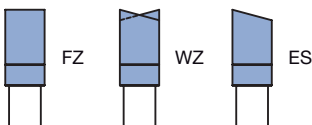
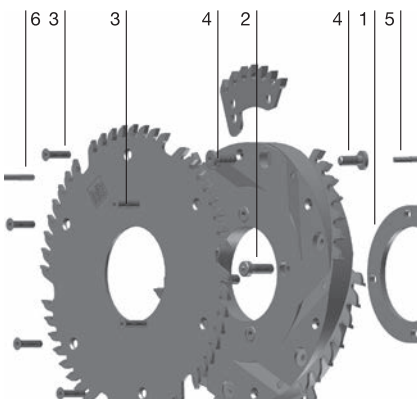
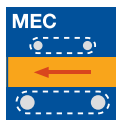
| Part- no. | BEZ                         | ABM      | BEM                        | ID       |
|-----------|-----------------------------|----------|----------------------------|----------|
|           |                             | mm       |                            |          |
| 1         | Spacer                      | 115x5x80 |                            | 028046 ● |
| 2         | Cylindrical screw with ISK  | M8x20    |                            | 005946 ● |
| 3         | Countersink screw, Torx® 20 | M6x10    | Torx® 20                   | 006083 ● |
| 4         | Screw with ISK              | M8x17    | for D = 250, 350, 305, 355 | 006237 ● |
| 5         | Allen key                   | SW 6     |                            | 005447 ● |
| 6         | Torx® key                   | Torx® 20 |                            | 117503 ● |

#### Circular sawblade

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

| D   | SB  | BO | Z  | ZF | QAL | ID       | ID       |
|-----|-----|----|----|----|-----|----------|----------|
| mm  | mm  | mm |    |    |     | LH       | RH       |
| 250 | 4,4 | 80 | 54 | FZ | HW  | 061825 ● | 061826 ● |
| 250 | 4,4 | 80 | 54 | ES | HW  | 061837 ● | 061838 ● |
| 250 | 4,4 | 80 | 72 | FZ | HW  | 061945 ● | 061946 ● |
| 260 | 4,4 | 80 | 72 | ES | HW  | 061860 □ | 061861 □ |
| 260 | 4,4 | 80 | 72 | FZ | HW  | 061947 ● | 061948 ● |
| 300 | 4,4 | 80 | 48 | FZ | HW  | 061827 ● | 061828 ● |





### Segment hogsers

#### Application:

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

#### Machine:

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

#### Workpiece material:

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

#### Technical information:

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

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

WZ 300 2

| D   | SB   | BO | Z    | ZF | QAL | ID              | ID              |
|-----|------|----|------|----|-----|-----------------|-----------------|
| mm  | mm   | mm |      |    |     | LH              | RH              |
| 250 | 26,0 | 80 | 6x7  | FZ | HW  | <b>064410 •</b> | <b>064411 •</b> |
| 300 | 31,5 | 30 | 6x9  | FZ | HW  | <b>064412 •</b> | <b>064413 •</b> |
| 350 | 36,5 | 30 | 6x10 | FZ | HW  | <b>064414 •</b> | <b>064415 •</b> |

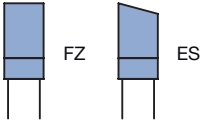
#### Spare parts:

| Part-<br>no. | BEZ                            | ABM<br>mm | SB<br>mm | QAL | ZF | Z  | BEM                           | ID              |
|--------------|--------------------------------|-----------|----------|-----|----|----|-------------------------------|-----------------|
|              | Hogging segment                | D 250     | 5,7      | HW  | FZ | 7  |                               | <b>064958 •</b> |
|              | Hogging segment                | D 250     | 5,7      | HW  | FZ | 7  |                               | <b>064959 •</b> |
|              | Hogging segment                | D 300     | 5,7      | HW  | FZ | 9  |                               | <b>064960 •</b> |
|              | Hogging segment                | D 300     | 5,7      | HW  | FZ | 9  |                               | <b>064961 •</b> |
|              | Hogging segment                | D 350     | 5,7      | HW  | FZ | 10 |                               | <b>064962 •</b> |
|              | Hogging segment                | D 350     | 5,7      | HW  | FZ | 10 |                               | <b>064963 •</b> |
| 1            | Spacer                         | 115x5x80  |          |     |    |    |                               | <b>028046 •</b> |
| 2            | Cylindrical screw<br>with ISK  | M8x20     |          |     |    |    |                               | <b>005946 •</b> |
| 3            | Countersink screw,<br>Torx® 20 | M6x10     |          |     |    |    | Torx® 20                      | <b>006083 •</b> |
| 4            | Screw with ISK                 | M8x17     |          |     |    |    | for D = 250, 350,<br>305, 355 | <b>006237 •</b> |
| 5            | Allen key                      | SW 6      |          |     |    |    |                               | <b>005447 •</b> |
| 6            | Torx® key                      | Torx® 20  |          |     |    |    |                               | <b>117503 •</b> |

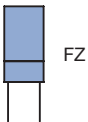
#### Spare circular sawblade for segment hogging set

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

| D   | SB  | BO | Z  | ZF | QAL | ID              | ID              |
|-----|-----|----|----|----|-----|-----------------|-----------------|
| mm  | mm  | mm |    |    |     | LH              | RH              |
| 250 | 4,4 | 80 | 48 | FZ | HW  | <b>061831 •</b> | <b>061832 •</b> |
| 250 | 4,4 | 80 | 48 | ES | HW  | <b>061878 •</b> | <b>061879 •</b> |
| 250 | 4,4 | 80 | 66 | FZ | HW  | <b>061953 •</b> | <b>061954 •</b> |
| 260 | 4,4 | 80 | 48 | ES | HW  | <b>061963 •</b> | <b>061964 •</b> |
| 260 | 4,4 | 80 | 66 | ES | HW  | <b>061965 •</b> | <b>061966 •</b> |
| 300 | 4,4 | 30 | 42 | FZ | HW  | <b>061833 •</b> | <b>061834 •</b> |
| 300 | 4,4 | 30 | 66 | FZ | HW  | <b>061055 •</b> | <b>061056 •</b> |
| 350 | 3,2 | 30 | 66 | WZ | HW  | <b>058223 •</b> | <b>058224 •</b> |



DFC segment hogger available on special request.



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

WK 801 2, WK 801 2 05

| D   | SB  | BO | Z  | ZF | QAL | ID              | ID              |
|-----|-----|----|----|----|-----|-----------------|-----------------|
| mm  | mm  | mm |    |    |     | LH              | RH              |
| 250 | 4,4 | 80 | 54 | ES | HW  | <b>061837 ●</b> | <b>061838 ●</b> |
| 260 | 4,4 | 80 | 72 | ES | HW  | <b>061860 □</b> | <b>061861 □</b> |

##### Circular sawblades:

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

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

TM 170 0

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

DFC segment hogger available on special request.

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

WK 800 2 46

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

Type 1 for Leuco.

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

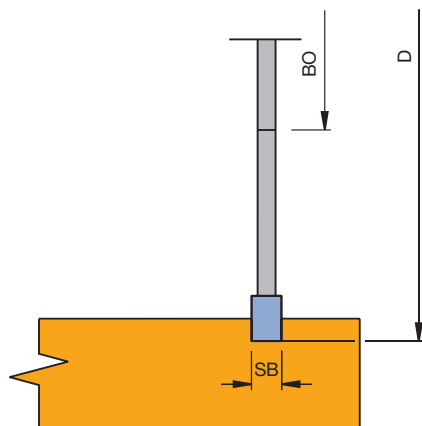
TM 170 0

| Typ | für D   | SB | Z | ZF | QAL | ID              | ID              |
|-----|---------|----|---|----|-----|-----------------|-----------------|
|     | mm      | mm |   |    |     | LH              | RH              |
| 1   | 200/250 | 4  | 4 | FZ | HW  | <b>064976 ●</b> | <b>064976 ●</b> |

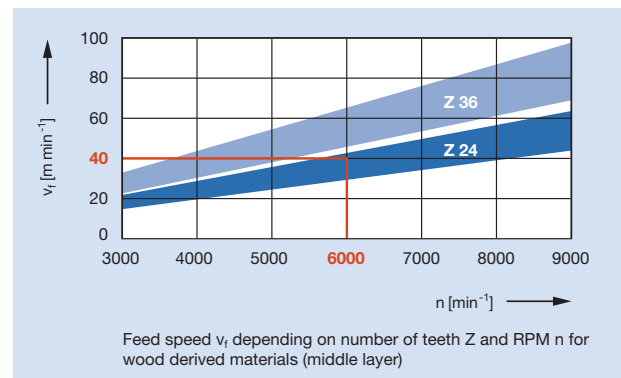
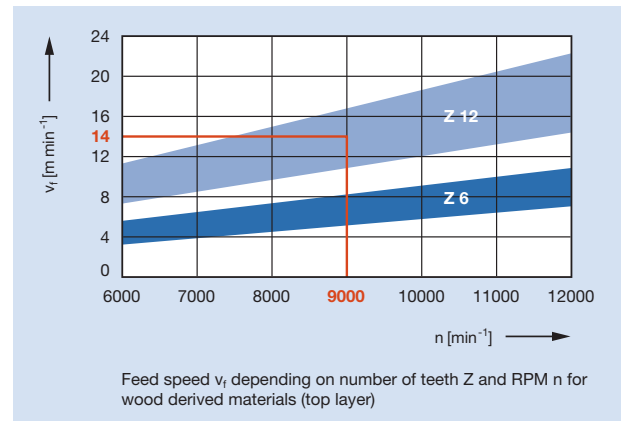
Type 1 for Leuco.

##### Grooving with feed

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



Cutting rear panel grooves

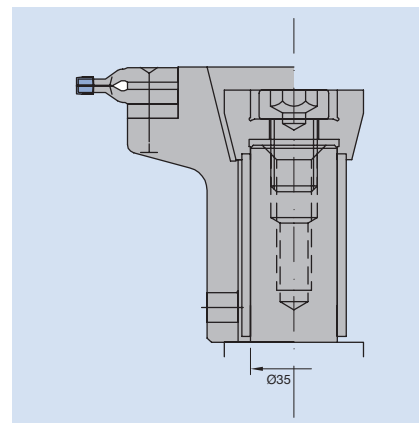


##### Grooving against feed

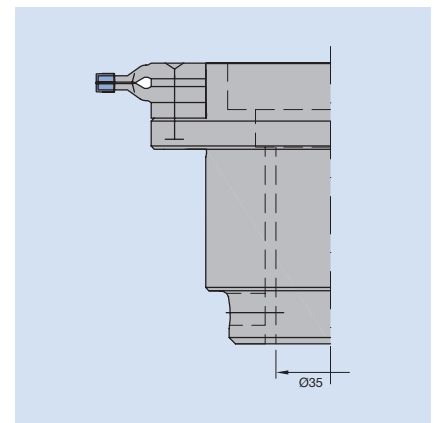
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

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

Tools for grooving against feed available on request.



Assembly example:  
Spindle 30 KN or DKN



Assembly example:  
Spindle 35 KN or DKN



### Grooving cutter for mechanical feed

#### Application:

Grooving with feed (climb cut).

#### Machine:

Moulders and double-end tenoners.

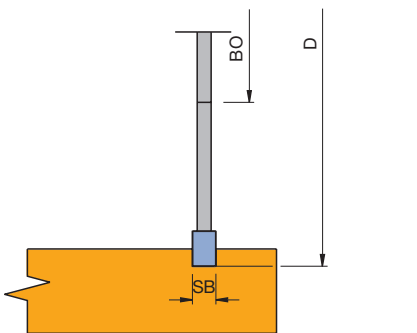
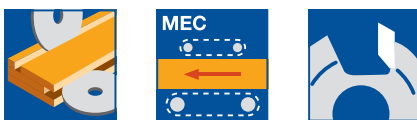
#### Workpiece material:

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

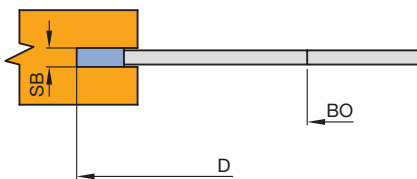
#### HW tipped

WF 100 2, WF 100 2 02, WF 100 2 03

| D   | SB   | TDI | BO     | BO <sub>max</sub> | Z  | n <sub>max</sub>  | ID       |
|-----|------|-----|--------|-------------------|----|-------------------|----------|
| mm  | mm   | mm  | mm     | mm                |    | min <sup>-1</sup> |          |
| 80  | 4,0  |     | 16 DKN |                   | 3  | 12000             | 182000   |
| 125 | 1,5  | 0,8 | 30     | 50                | 12 | 13700             | 020145 ● |
| 125 | 2,0  | 1,2 | 30     | 50                | 12 | 13700             | 020147 ● |
| 125 | 2,5  | 1,4 | 30     | 50                | 12 | 13700             | 020149 ● |
| 125 | 3,0  | 2,0 | 30     | 50                | 12 | 13700             | 020150 ● |
| 125 | 3,5  | 2,2 | 30     | 50                | 12 | 13700             | 020151 ● |
| 125 | 4,0  | 2,5 | 30     | 50                | 12 | 13700             | 020152 ● |
| 125 | 4,5  | 3,0 | 30     | 50                | 12 | 13700             | 020153 ● |
| 125 | 5,0  | 3,5 | 30     | 50                | 12 | 13700             | 020191 ● |
| 125 | 6,0  | 4,5 | 30     | 50                | 12 | 13700             | 020192 ● |
| 125 | 7,0  | 5,0 | 30     | 50                | 12 | 13700             | 020193 ● |
| 125 | 8,0  | 6,0 | 30     | 50                | 12 | 13700             | 020194 ● |
| 125 | 10,0 | 7,0 | 30     | 50                | 12 | 13700             | 020196 ● |
| 150 | 1,5  | 0,8 | 30     | 60                | 18 | 11400             | 020164 ● |
| 150 | 2,0  | 1,2 | 30     | 60                | 18 | 11400             | 020166 ● |
| 150 | 2,5  | 1,4 | 30     | 60                | 18 | 11400             | 020168 ● |
| 150 | 3,0  | 2,0 | 30     | 60                | 12 | 11400             | 020154 ● |
| 150 | 3,0  | 2,0 | 30     | 60                | 18 | 11400             | 020169 ● |
| 150 | 3,5  | 2,2 | 30     | 60                | 12 | 11400             | 020155 ● |
| 150 | 4,0  | 2,5 | 30     | 60                | 12 | 11400             | 020156 ● |
| 150 | 4,0  | 2,5 | 30     | 60                | 18 | 11400             | 020170 ● |
| 150 | 4,5  | 3,0 | 30     | 60                | 12 | 11400             | 020157 ● |
| 150 | 5,0  | 3,5 | 30     | 60                | 12 | 11400             | 020158 ● |
| 150 | 5,0  | 3,5 | 30     | 60                | 18 | 11400             | 020171 ● |
| 150 | 6,0  | 4,5 | 30     | 60                | 12 | 11400             | 020159 ● |
| 150 | 6,0  | 4,5 | 30     | 60                | 18 | 11400             | 020172 ● |
| 150 | 7,0  | 5,0 | 30     | 60                | 12 | 11400             | 020160 ● |
| 150 | 8,0  | 6,0 | 30     | 60                | 12 | 11400             | 020161 ● |
| 150 | 8,0  | 6,0 | 30     | 60                | 18 | 11400             | 020173 ● |
| 150 | 8,5  | 7,0 | 30     | 60                | 18 | 11400             | 020319   |
| 150 | 10,0 | 7,0 | 30     | 60                | 12 | 11400             | 020163 ● |
| 150 | 10,0 | 7,0 | 30     | 60                | 18 | 11400             | 020174 ● |
| 180 | 2,0  | 1,2 | 30     | 70                | 18 | 9500              | 020202 ● |
| 180 | 2,5  | 1,4 | 30     | 70                | 18 | 9500              | 020203 ● |
| 180 | 3,0  | 2,0 | 30     | 70                | 18 | 9500              | 020204 ● |
| 180 | 3,5  | 2,2 | 30     | 70                | 18 | 9500              | 020205 ● |
| 180 | 4,0  | 2,5 | 30     | 60                | 18 | 9500              | 020197 ● |
| 180 | 5,0  | 3,5 | 30     | 60                | 18 | 9500              | 020198 ● |
| 180 | 6,0  | 4,5 | 30     | 60                | 18 | 9500              | 020199 ● |
| 180 | 8,0  | 6,0 | 30     | 60                | 18 | 9500              | 020200 ● |
| 180 | 8,5  | 6,0 | 30     | 60                | 18 | 9500              | 020320 ● |
| 180 | 10,0 | 7,0 | 30     | 60                | 18 | 9500              | 020201 ● |
| 200 | 2,0  | 1,2 | 35     | 80                | 18 | 8500              | 020299   |
| 200 | 3,0  | 2,0 | 35     | 80                | 18 | 8500              | 020302 ● |
| 200 | 4,0  | 2,5 | 35     | 80                | 18 | 8500              | 020303 ● |
| 200 | 5,0  | 3,5 | 35     | 80                | 18 | 8500              | 020304 ● |
| 200 | 6,0  | 4,5 | 35     | 80                | 18 | 8500              | 020305 ● |
| 200 | 8,0  | 6,0 | 35     | 80                | 18 | 8500              | 020306 ● |
| 200 | 8,5  | 6,0 | 30     | 80                | 18 | 8500              | 020321   |
| 200 | 10,0 | 7,0 | 35     | 80                | 18 | 8500              | 020307 ● |



Cutting the back panel groove



Grooving the edge

DP

**DP tipped**

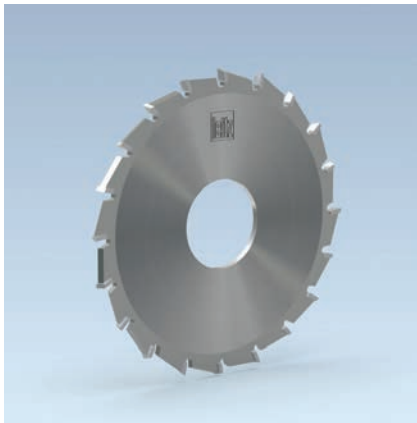
WF 100 2, WF 100 2 DP

| D   | SB  | TDI     | BO | BO <sub>max</sub> | NLA     | Z  | ZF     | QAL | n <sub>max</sub><br>min <sup>-1</sup> | ID            |
|-----|-----|---------|----|-------------------|---------|----|--------|-----|---------------------------------------|---------------|
| mm  | mm  | mm      | mm | mm                | mm      |    |        |     |                                       |               |
| 80  | 4,0 |         | 16 |                   |         | 3  | FZ     | DP  |                                       | <b>192334</b> |
| 150 | 4,0 | 2,5     | 30 | 60                |         | 18 | FZ     | DP  | 15200                                 | <b>192304</b> |
| 180 | 4,0 | 2,5     | 30 | 60                |         | 24 | FZ     | DP  | 12700                                 | <b>192305</b> |
| 180 | 8,5 | 6,5/8,5 | 80 |                   | 4/9/100 | 35 | WZ/WZ/ | DP  | 9500                                  | <b>190755</b> |
|     |     |         |    |                   | 4/9/100 |    | FZ     |     |                                       |               |
| 200 | 4,0 | 2,5     | 30 | 80                |         | 24 | FZ     | DP  | 11400                                 | <b>192306</b> |

**DP tipped, mounted on flanged sleeve ID 61681**

SF 500 2

| D   | SB  | BO | DKN   | Z  | ZF       | QAL | n <sub>max</sub><br>min <sup>-1</sup> | ID              |
|-----|-----|----|-------|----|----------|-----|---------------------------------------|-----------------|
| mm  | mm  | mm | mm    |    |          |     |                                       |                 |
| 180 | 8,5 | 35 | 10x43 | 35 | WZ/WZ/FZ | DP  | 9500                                  | <b>190756</b> □ |



### Circular sawblade for end trim on edgebanding machines

#### Application:

For low noise edgebanding trim cuts.

#### Machine:

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

#### Workpiece material:

Veneered, melamine and plastic edging.

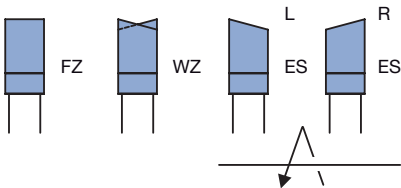
#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

Veneered and plastic edging:

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

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



#### Circular sawblade - LowNoise, ES

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

| Machine    | D   | SB  | BO | NLA      | Z  | ZF         | ID       | ID       |
|------------|-----|-----|----|----------|----|------------|----------|----------|
|            | mm  | mm  | mm | mm       |    |            | LH       | RH       |
| Biesse     | 115 | 3,2 | 52 | 3/7,1/64 | 30 | ES pos.    | 166420   | 166421   |
| Biesse     | 130 | 3,6 | 30 | 4/7,4/46 | 24 | ES pos.    | 166424 ● | 166425 ● |
| Biesse     | 140 | 3,2 | 30 | 3/8/56   | 36 | ES pos.    | 166427 ● | 166426 ● |
| Biesse     | 150 | 3,5 | 30 | 3/8/56   | 36 | ES neg.    | 166484 ● | 166485 ● |
| Brandt     | 100 | 2,6 | 32 |          | 30 | ES neg.    | 166400 ● | 166401 ● |
| Brandt     | 100 | 2,6 | 32 |          | 30 | ES pos.    | 166429 ● | 166430 ● |
| Brandt     | 125 | 2,6 | 32 |          | 30 | ES neg.    | 166403 ● | 166404 ● |
| Cehisa     | 100 | 3,0 | 32 |          | 30 | ES pos.    | 166436   | 166437   |
| Fravol     | 100 | 3,2 | 22 |          | 24 | ES pos.    | 166407 ● | 166406 ● |
| Fravol     | 100 | 2,6 | 30 |          | 30 | ES pos.    | 166476 ● | 166477 ● |
| Fravol     | 125 | 3,2 | 22 |          | 30 | ES pos.    | 166411 ● | 166410 ● |
| Holz-Her   | 110 | 3,6 | 22 |          | 16 | ES pos.    | 166439 ● | 166440 ● |
| Homag      | 80  | 3,2 | 34 | 8/4,2/44 | 30 | ES pos.    | 166443 ● | 166444 ● |
| * Homag    | 100 | 3,0 | 32 |          | 20 | ES pos.    | 166445 ● | 166446 ● |
| Homag      | 100 | 3,2 | 32 |          | 20 | ES neg.    | 166449   | 166450 ● |
| Homag      | 100 | 2,6 | 32 |          | 30 | ES neg.    | 166400 ● | 166401 ● |
| Homag      | 100 | 2,6 | 32 |          | 30 | ES pos.    | 166429 ● | 166430 ● |
| Homag      | 110 | 1,7 | 40 | 4/5,5/52 | 30 | FZ/TR pos. | 166453   | 166453   |
| * Homag    | 120 | 3,2 | 40 |          | 30 | ES pos.    | 166454   | 166455   |
| Homag      | 125 | 2,6 | 32 |          | 30 | ES neg.    | 166403 ● | 166404 ● |
| SCM        | 150 | 3,8 | 35 | 4/6,5/50 | 30 | ES pos.    | 166468 ● | 166469 ● |
| Wilmsmeyer | 100 | 3,2 | 32 |          | 20 | ES neg.    | 166449   | 166450 ● |

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

#### Workpiece material:

Softwood, hardwood edging.

#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

Solid wood edging and multi-purpose application:

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

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

#### Circular sawblade - LowNoise, WZ

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

| Machine    | D   | SB  | BO | NLA      | Z  | ZF      | ID       | ID       |
|------------|-----|-----|----|----------|----|---------|----------|----------|
|            | mm  | mm  | mm | mm       |    |         | LH       | RH       |
| Biesse     | 100 | 3,2 | 30 |          | 20 | WZ pos. | 166478 ● | 166478 ● |
| Biesse     | 160 | 3,2 | 20 |          | 48 | WZ pos. | 166428 ● | 166428 ● |
| Brandt     | 100 | 2,6 | 32 |          | 30 | WZ pos. | 166431 ● | 166431 ● |
| Brandt     | 125 | 2,4 | 32 |          | 24 | WZ pos. | 166402 ● | 166402 ● |
| EBM        | 100 | 2,4 | 22 | 2/4/30   | 20 | WZ neg. | 166405 ● | 166405 ● |
| Felder     | 100 | 3,2 | 22 |          | 20 | WZ pos. | 166438 ● | 166438 ● |
| Felder     | 110 | 3,2 | 30 |          | 20 | WZ pos. | 166475 ● | 166475 ● |
| Hebrock    | 100 | 2,4 | 22 | 2/4/30   | 20 | WZ neg. | 166405 ● | 166405 ● |
| Holz-Her   | 110 | 3,6 | 22 |          | 20 | WZ pos. | 065663 ● | 065663 ● |
| Holz-Her   | 120 | 3,2 | 22 |          | 20 | WZ pos. | 166474 ● | 166474 ● |
| Holz-Her   | 140 | 3,2 | 22 |          | 36 | WZ pos. | 166441 ● | 166441 ● |
| Holz-Her   | 160 | 3,2 | 20 |          | 48 | WZ pos. | 166428 ● | 166428 ● |
| Holz-Her   | 160 | 3,2 | 30 |          | 24 | WZ pos. | 065664 ● | 065664 ● |
| Homag      | 100 | 3,6 | 32 |          | 20 | WZ pos. | 166451 ● | 166451 ● |
| Homag      | 100 | 2,6 | 32 |          | 30 | WZ pos. | 166431 ● | 166431 ● |
| Homag      | 110 | 3,6 | 32 |          | 20 | WZ pos. | 166452 ● | 166452 ● |
| Homag      | 120 | 3,6 | 40 | 8/5,6/52 | 24 | WZ pos. | 166419 ● | 166419 ● |
| Homag      | 120 | 3,2 | 40 | 8/5,6/52 | 36 | WZ pos. | 166456 ● | 166456 ● |
| Homag      | 120 | 3,6 | 40 | 8/5,6/52 | 36 | WZ pos. | 166457 ● | 166457 ● |
| Homag      | 125 | 2,4 | 30 | 8/6,5/48 | 36 | WZ pos. | 058234 ● | 058234 ● |
| Homag      | 125 | 2,4 | 32 |          | 24 | WZ pos. | 166402 ● | 166402 ● |
| Homag      | 170 | 3,2 | 30 | 8/5,6/52 | 36 | WZ pos. | 166412 ● | 166412 ● |
| Homag      | 180 | 3,2 | 30 | 4/5,6/52 | 54 | WZ pos. | 166460 ● | 166460 ● |
| IMA        | 160 | 3,2 | 22 |          | 48 | WZ neg. | 166414 ● | 166414 ● |
| IMA        | 180 | 3,2 | 22 |          | 48 | WZ neg. | 166464 ● | 166464 ● |
| IMA 08.415 | 180 | 3,5 | 22 |          | 42 | WZ neg. | 166415 ● | 166415 ● |
| IMA 08.492 | 160 | 3,0 | 22 |          | 36 | WZ pos. | 166413 ● | 166413 ● |
| Ott        | 140 | 3,2 | 16 |          | 36 | WZ pos. | 166466 ● | 166466 ● |
| Raimann    | 100 | 3,6 | 32 |          | 20 | WZ pos. | 166451 ● | 166451 ● |
| SCM        | 90  | 2,6 | 20 |          | 20 | WZ      | 166483 ● | 166483 ● |
| SCM        | 107 | 6,0 | 40 |          | 12 | R3      | 166481 ● | 166482 ● |
| SCM        | 115 | 3,2 | 30 |          | 30 | WZ pos. | 166416 ● | 166416 ● |
| SCM        | 125 | 3,2 | 30 |          | 24 | WZ      | 166480 ● | 166480 ● |

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools

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



### Pre / finishing edge trimming cutter

#### Application:

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

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

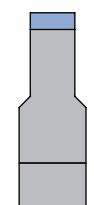
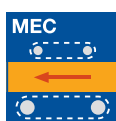
#### Technical information:

HW/DP tipped tools with cylindrical bore.

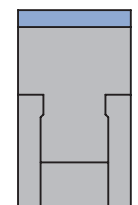
#### Joining cutter

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

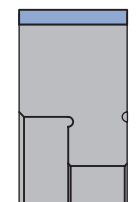
| Machine | D<br>mm | SB<br>mm | ND<br>mm | BO<br>mm | Type | Z | QAL | ID<br>LH | ID<br>RH |
|---------|---------|----------|----------|----------|------|---|-----|----------|----------|
| Biesse  | 70      | 10       | 12       | 16 DKN   | 1    | 6 | DP  | 090899   | 090899   |
| Biesse  | 70      | 20       | 12       | 16 DKN   | 2    | 6 | DP  | 090893   | 090893   |
| Biesse  | 80      | 22       | 12       | 16 DKN   | 3    | 6 | DP  | 192103 ● | 192102 ● |
| Brandt  | 70      | 10       | 12       | 16 DKN   | 1    | 6 | DP  | 090899   | 090899   |
| Brandt  | 70      | 20       | 12       | 16 DKN   | 2    | 6 | DP  | 090893   | 090893   |
| Brandt  | 70      | 25       | 25       | 16 DKN   | 3    | 4 | HW  | 065588 ● | 065589 ● |
| Fravol  | 80      | 30       | 27,5     | 20 DKN   | 3    | 4 | DP  | 192270   | 192271   |
| Homag   | 70      | 10       | 12       | 16 DKN   | 1    | 6 | DP  | 090899   | 090899   |
| Homag   | 70      | 20       | 12       | 16 DKN   | 2    | 6 | DP  | 090893   | 090893   |
| Homag   | 70      | 25       | 25       | 16 DKN   | 3    | 4 | HW  | 065588 ● | 065589 ● |
| Ott     | 70      | 16,5     | 10       | 16 DKN   | 3    | 4 | DP  | 192283 ● | 192284 ● |
| SCM     | 80      | 30       | 11       | 16 DKN   | 2    | 4 | HW  | 065595 ● | 065596 ● |
| Stefani | 80      | 20       | 11       | 16 DKN   | 2    | 4 | DP  | 192110   | 192111   |



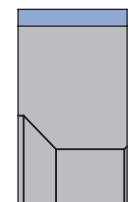
Type 1



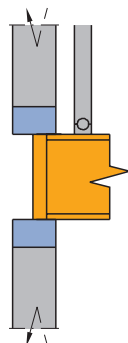
Type 2



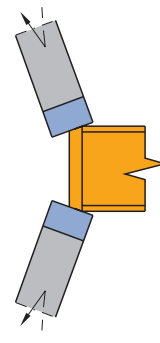
Type 3



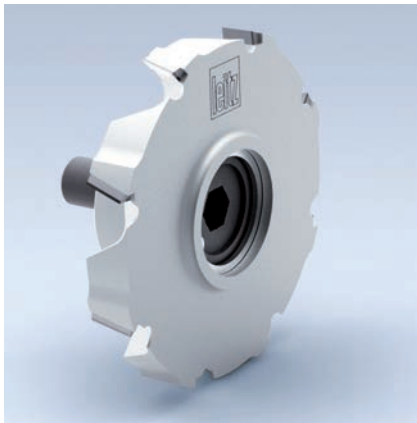
Type 4



Trimming of edges on horizontal spindle - top motor tracing.



Bevelling of edges with inclined spindle.



### Pre / finishing edge trimming cutter with optimised chip collection

#### Application:

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

#### Machine:

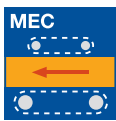
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity.



#### Joining cutter - optimised chip collection

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

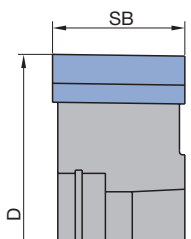
| Machine    | D<br>mm | SB<br>mm | BO<br>mm | Z | QAL | ID<br>LH        | ID<br>RH        |
|------------|---------|----------|----------|---|-----|-----------------|-----------------|
| Homag, IMA | 70      | 8        | HSK 25 R | 4 | DP  | <b>198472 ●</b> | <b>198473 ●</b> |
| Homag, IMA | 70      | 8        | HSK 25 R | 6 | DP  | <b>198474 ●</b> | <b>198475 ●</b> |
| Homag, IMA | 70      | 8        | HSK 25 R | 8 | DP  | <b>198404 ●</b> | <b>198405 ●</b> |
| Homag, IMA | 70      | 15       | HSK 25 R | 4 | DP  | <b>198406 ●</b> | <b>198407 ●</b> |
| Homag, IMA | 70      | 15       | HSK 25 R | 6 | DP  | <b>198468 □</b> | <b>198469 □</b> |
| Homag, IMA | 70      | 25       | HSK 25 R | 4 | HW  | <b>073092 ●</b> | <b>073093 ●</b> |
| SCM        | 80      | 8        | HSK 25 R | 4 | DP  | <b>192335 ●</b> | <b>192336 ●</b> |
| SCM        | 80      | 30       | HSK 25 R | 4 | HW  | <b>182001 ●</b> | <b>182002 ●</b> |
| SCM        | 80      | 30       | 16 DKN   | 4 | DP  | <b>192328 ●</b> | <b>192329 ●</b> |

#### Recommended number of teeth:

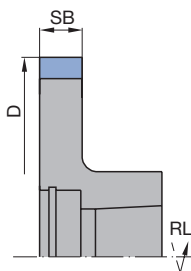
Feed rates of up to 35 m min<sup>-1</sup> Z 4

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

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



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



DP jointing cutter with HSK 25 R adaptor



### Pre / finishing edge trimming cutter cutterhead design

#### Application:

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

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

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

#### Joining cutterhead

WW 200 2 06, WW 200 2 25

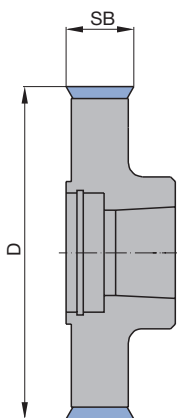
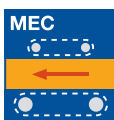
| Machine       | Type | D<br>mm | SB<br>mm | BO<br>mm | Z | ID<br>LH        | ID<br>RH        |
|---------------|------|---------|----------|----------|---|-----------------|-----------------|
| Brandt, Homag | 1    | 70      | 14,3     | 16 DKN   | 4 | <b>025130</b>   | <b>025130</b>   |
| Homag         | 1    | 70      | 14,3     | HSK 25 R | 4 | <b>073599</b>   | <b>073600</b>   |
| Homag         | 2    | 70      | 20       | 16 DKN   | 4 | <b>025079 ●</b> | <b>025079 ●</b> |

#### Spare knives:

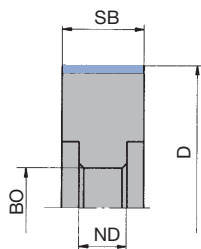
| Part-no. | BEZ             | ABM<br>mm     | QAL    | VE<br>PCS | ID              |
|----------|-----------------|---------------|--------|-----------|-----------------|
| 1        | Turnblade knife | 20x12x1,5     | HW-05F | 10        | <b>005083 ●</b> |
| 1        | Turnblade knife | 40x12x1,5     | HW-05F | 10        | <b>005085 ●</b> |
| 5        | Turnblade knife | 14,3x14,3x2,5 | HW     | 10        | <b>005426 ●</b> |

#### Spare parts:

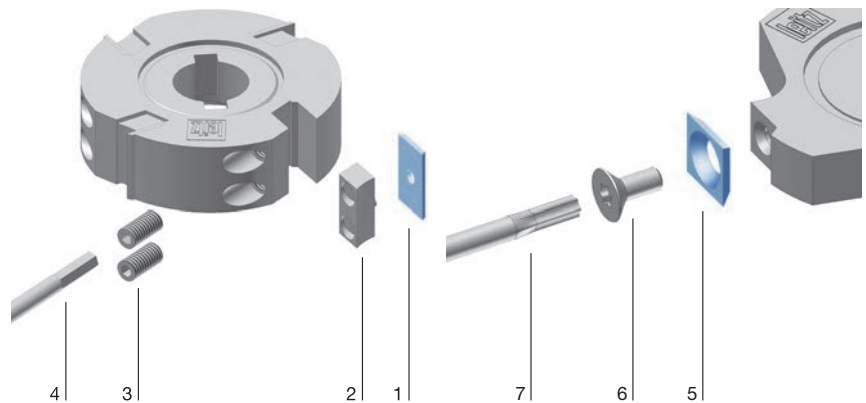
| Part-no. | BEZ                         | ABM<br>mm | ID              |
|----------|-----------------------------|-----------|-----------------|
| 2        | Clamping wedge with pin     | 18x11,5x7 | <b>005272 ●</b> |
| 3        | Allen screw                 | M6x12     | <b>006035</b>   |
| 6     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

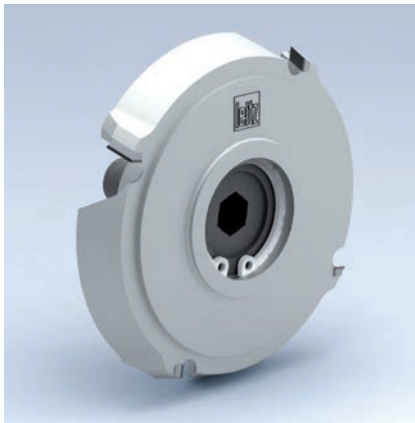


Type 1: WW 200 2 25



Type 2: WW 200 2 06





### Bevel cutter with optimised chip collection

#### Application:

To bevel edgebandings.

#### Machine:

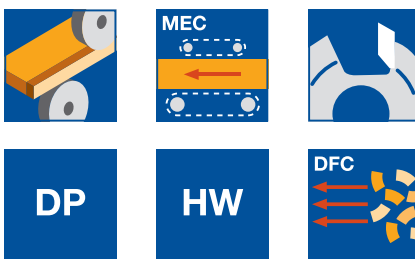
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

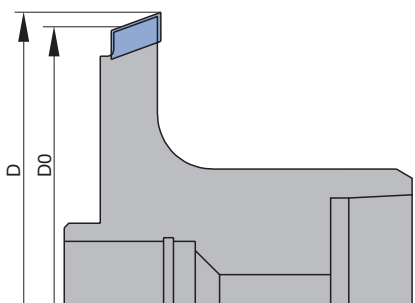
HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. Constant reference diameter. It is not recommended to sharpen the tool.



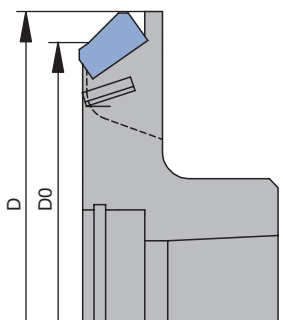
#### Various bevel angles - optimised chip collection

WF 300 2 DP, WF 350 2 DP, WF 501 2

| Machine | D     | D <sub>0</sub> | SB  | BO       | Z | QAL | FAW | NH    | ID              | ID              |
|---------|-------|----------------|-----|----------|---|-----|-----|-------|-----------------|-----------------|
|         | mm    | mm             | mm  | mm       |   |     | °   | mm    | LH              | RH              |
| Homag   | 65,14 | 62,3           | 5,7 | HSK 32   | 4 | DP  | 20  | 31,5  | <b>198200</b> ● | <b>198201</b> ● |
| Homag   | 70    | 62,3           | 5,7 | HSK 32   | 4 | DP  | 45  | 31,5  | <b>198240</b>   | <b>198241</b>   |
| Homag   | 65,14 | 62,3           | 5,7 | HSK 32   | 6 | DP  | 20  | 31,5  | <b>198202</b> ● | <b>198203</b> ● |
| Homag   | 68,3  | 62,3           | 5,7 | HSK 32   | 6 | DP  | 45  | 31,5  | <b>198242</b>   | <b>198243</b>   |
| Homag   | 72,91 | 70             | 5,5 | HSK 25 R | 4 | DP  | 20  | 19,5  | <b>198408</b> ● | <b>198409</b> ● |
| Homag   | 78    | 70             | 5,5 | HSK 25 R | 4 | DP  | 45  | 19,5  | <b>198464</b>   | <b>198465</b>   |
| Homag   | 73    | 70             | 5,5 | HSK 25 R | 6 | DP  | 20  | 19,5  | <b>198410</b>   | <b>198411</b>   |
| Homag   | 78    | 70             | 5,5 | HSK 25 R | 6 | DP  | 45  | 19,5  | <b>198466</b>   | <b>198467</b>   |
| IMA     | 72,91 | 70             | 5,5 | HSK 25 R | 4 | DP  | 20  | 19,5  | <b>198408</b> ● | <b>198409</b> ● |
| IMA     | 78    | 70             | 5,5 | HSK 25 R | 4 | DP  | 45  | 19,5  | <b>198464</b>   | <b>198465</b>   |
| IMA     | 73    | 70             | 5,5 | HSK 25 R | 6 | DP  | 20  | 19,5  | <b>198410</b>   | <b>198411</b>   |
| IMA     | 78    | 70             | 5,5 | HSK 25 R | 6 | DP  | 45  | 19,5  | <b>198466</b>   | <b>198467</b>   |
| SCM     | 69,6  | 61,7           | 6,0 | HSK 25 R | 4 | HW  | 20  | 21,35 | <b>182552</b>   | <b>182553</b>   |
| SCM     | 69,6  | 62,5           | 5,5 | HSK 25 R | 4 | DP  | 45  | 22    | <b>192707</b> □ | <b>192708</b> □ |
| SCM     | 69,6  | 62,5           | 5,5 | HSK 25 R | 4 | DP  | 30  | 22    | <b>192705</b> □ | <b>192706</b> □ |
| SCM     | 69,6  | 62,5           | 5,5 | HSK 25 R | 4 | DP  | 20  | 22    | <b>192703</b> □ | <b>192704</b> □ |



Bevel cutter with HSK 32 adaptor for FK aggregates



Bevel cutter with HSK 25 R adaptor



### Profile cutter

#### Application:

To round edgebandings.

#### Machine:

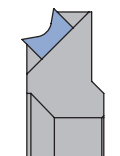
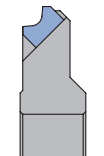
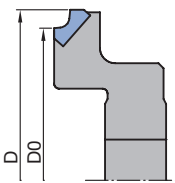
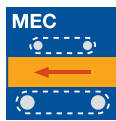
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

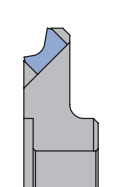
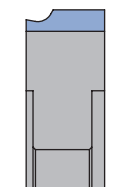
#### Technical information:

HW/DP tipped tools with cylindrical bore, HSK 25 R adaptor or HSK 32 adaptor for FK-aggregates. High concentricity.  $D_0$  = constant reference diameter. It is not recommended to resharpen the tool.



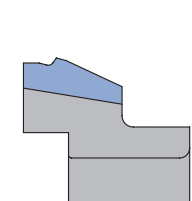
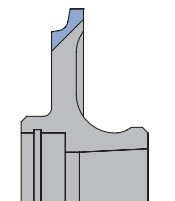
Type 3

Type 4



Type 5

Type 6



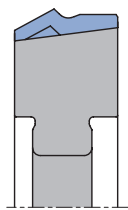
Type 7

Type 8

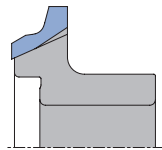
#### Various radii

WF 210 2 DP, WF 501 2, WF 501 2 DP, WF 502 2, WF 502 2 DP, WF 599 2

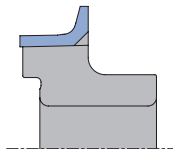
| Machine       | D<br>mm | $D_0$<br>mm | BO<br>mm   | Z | QAL | R<br>mm | FAW<br>° | Type | ID<br>LH | ID<br>RH |
|---------------|---------|-------------|------------|---|-----|---------|----------|------|----------|----------|
| Biesse        | 67      | 60          | 16 DKN     | 6 | DP  | 1,0     |          | 1    | 091960 □ | 091961 □ |
| Biesse        | 68      | 60          | 16 DKN     | 6 | DP  | 2,0     |          | 1    | 091962 □ | 091963 □ |
| Biesse        | 70      | 60          | 16 DKN     | 6 | DP  | 3,0     |          | 1    | 091964 □ | 091965 □ |
| Biesse        | 72      | 70          | 16 KN      | 6 | DP  | 1,0     |          | 5    | 192518 □ | 192519 □ |
| Biesse        | 73      | 70          | 16 KN      | 6 | DP  | 2,0     |          | 5    | 192520 □ | 192521 □ |
| Biesse        | 75      | 70          | 16 KN      | 6 | DP  | 3,0     |          | 5    | 192522 □ | 192523 □ |
| ** Brandt     | 58      | 50          | 16         | 4 | DP  | 1,0     |          | 2    |          | 192604 □ |
| ** Brandt     | 58      | 50          | 16         | 4 | DP  | 1,5     |          | 2    |          | 192602 □ |
| * Brandt      | 58      | 50          | 16         | 4 | DP  | 2,0     |          | 2    |          | 091966   |
| ** Brandt     | 58      | 50          | 16         | 4 | DP  | 2,0     |          | 2    |          | 192603 □ |
| Brandt        | 70      | 62          | HSK 25 R 4 | 4 | DP  | 1,0     |          | 7    | 192588 □ | 192589 □ |
| Brandt        | 70      | 62          | HSK 25 R 4 | 4 | DP  | 1,3     |          | 7    | 192590 □ | 192591 □ |
| Brandt        | 70      | 62          | HSK 25 R 4 | 4 | DP  | 1,5     |          | 7    | 192592 □ | 192593 □ |
| Brandt        | 70      | 62          | HSK 25 R 4 | 4 | DP  | 2,0     |          | 7    | 192594 □ | 192595 □ |
| Brandt        | 70      | 62          | HSK 25 R 4 | 4 | DP  | 3,0     |          | 7    | 192596 □ | 192597 □ |
| EBM           | 32      | 24          | 14 DKN     | 2 | DP  | 2,0     |          | 3    | 074526   |          |
| Fraval        | 73      | 71,15       | 20 DKN     | 4 | DP  | 1-3     |          | 8    | 192645 ● | 192646 ● |
| Fraval        | 76,8    | 74,71       | 20 DKN     | 4 | DP  | 1-3     |          | 9    | 192647   | 192648   |
| Fraval        | 50      | 40,1        | 15 KN      | 4 | DP  | 1-3     |          | 10   | 192663   | 192664 ● |
| Fraval        | 50      | 39,91       | 15 KN      | 4 | DP  | 1-3     |          | 11   |          | 192665   |
| Fraval        | 50      | 39,91       | 15 KN      | 4 | HW  | 1-3     |          | 11   |          | 065597   |
| Hebrock       | 32      | 24          | 14 DKN     | 2 | DP  | 2,0     |          | 3    | 074526   |          |
| Holz-Her 1825 | 57      | 50          | 16 DKN     | 2 | DP  | 2,0     |          | 3    | 192536 □ | 192537 □ |
| Holz-Her 1825 | 57      | 50          | 16 DKN     | 2 | DP  | 2,5     |          | 3    | 192538 □ | 192539 □ |
| Holz-Her 1825 | 57      | 50          | 16 DKN     | 2 | DP  | 3,0     |          | 3    | 192540 □ | 192541 □ |
| Holz-Her 1827 | 56      | 50          | 20 DKN     | 2 | DP  | 2,0     |          | 11   | 192506 ● | 192507 ● |
| Holz-Her 1827 | 56      | 50          | 20 DKN     | 2 | DP  | 2,5     |          | 11   | 192508 □ | 192509 □ |
| Holz-Her 1827 | 57      | 50          | 20 DKN     | 2 | DP  | 3,0     |          | 11   | 192510 □ | 192511 □ |
| Holz-Her 1832 | 58,7    | 50          | 16 DKN     | 3 | DP  | 2,0     |          | 3    | 192512 □ | 192513 □ |
| Holz-Her 1832 | 58,7    | 50          | 16 DKN     | 3 | DP  | 2,5     |          | 3    | 192514 □ | 192515 □ |
| Holz-Her 1832 | 58,7    | 50          | 16 DKN     | 3 | DP  | 3,0     |          | 3    | 192516 □ | 192517 □ |
| Holz-Her 1833 | 72,5    | 61          | 20 DKN     | 4 | DP  | 2,0     |          | 4    | 192500 □ | 192501 □ |
| Holz-Her 1833 | 72,5    | 61          | 20 DKN     | 4 | DP  | 2,5     |          | 4    | 192502 □ | 192503 □ |
| Holz-Her 1833 | 72,5    | 61          | 20 DKN     | 4 | DP  | 3,0     |          | 4    | 192504 □ | 192505 □ |



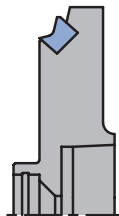
Type 9



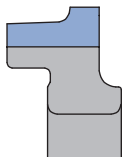
Type 10



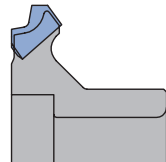
Type 11



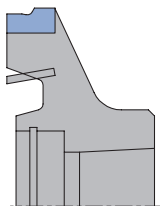
Type 12



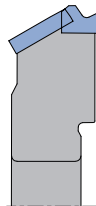
Type 13



Type 14



Type 15



Type 16

| Machine           | D<br>mm | D <sub>0</sub><br>mm | BO<br>mm   | Z   | QAL | R<br>mm | FAW<br>° | Type | ID<br>LH | ID<br>RH |
|-------------------|---------|----------------------|------------|-----|-----|---------|----------|------|----------|----------|
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  |         | 45       | 1    | 192731 □ | 192732 □ |
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  | 1,0     |          | 13   | 192733 □ | 192734 □ |
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  | 1,3     |          | 13   | 192735 □ | 192736 □ |
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  | 2,0     |          | 13   | 192737 □ | 192738 □ |
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  | 2,5     |          | 13   | 192739 □ | 192740 □ |
| Holz-Her<br>FR201 | 57      | 50                   | 16 DKN     | 2   | DP  | 3,0     |          | 13   | 192741 □ | 192742 □ |
| Holz-Her<br>FR701 | 72      | 68                   | 16 DKN     | 2+2 | DP  |         | 45       | 16   | 192727 □ | 192728 □ |
| Holz-Her<br>FR701 | 72      | 68                   | 16 DKN     | 2+2 | DP  | 1       |          | 16   | 192719 □ | 192720 □ |
| Holz-Her<br>FR701 | 72      | 68                   | 16 DKN     | 2+2 | DP  | 1,3     |          | 16   | 192721 □ | 192722 □ |
| Holz-Her<br>FR701 | 72      | 68                   | 16 DKN     | 2+2 | DP  | 2       |          | 16   | 192723 □ | 192724 □ |
| Holz-Her<br>FR701 | 72      | 68                   | 16 DKN     | 2+2 | DP  | 3       |          | 16   | 192725 □ | 192726 □ |
| ** Homag          | 58      | 50                   | 16         | 4   | DP  | 1,0     |          | 2    |          | 192604 □ |
| ** Homag          | 58      | 50                   | 16         | 4   | DP  | 1,5     |          | 2    |          | 192602 □ |
| * Homag           | 58      | 50                   | 16         | 4   | DP  | 2,0     |          | 2    |          | 091966   |
| ** Homag          | 58      | 50                   | 16         | 4   | DP  | 2,0     |          | 2    |          | 192603 □ |
| Homag             | 70      | 62                   | HSK 25 R 4 | 4   | DP  | 1,0     |          | 7    | 192588 □ | 192589 □ |
| Homag             | 70      | 62                   | HSK 25 R 4 | 4   | DP  | 1,3     |          | 7    | 192590 □ | 192591 □ |
| Homag             | 70      | 62                   | HSK 25 R 4 | 4   | DP  | 1,5     |          | 7    | 192592 □ | 192593 □ |
| Homag             | 70      | 62                   | HSK 25 R 4 | 4   | DP  | 2,0     |          | 7    | 192594 □ | 192595 □ |
| Homag             | 70      | 62                   | HSK 25 R 4 | 4   | DP  | 3,0     |          | 7    | 192596 □ | 192597 □ |
| Homag             | 67,1    | 62                   | HSK 32     | 4   | DP  | 1,0     |          | 12   | 091500 □ | 091501 □ |
| Homag             | 68,1    | 62                   | HSK 32     | 4   | DP  | 1,5     |          | 12   | 091502 □ | 091503 □ |
| Homag             | 69,1    | 62                   | HSK 32     | 4   | DP  | 2,0     |          | 12   | 091504 □ | 091505 □ |
| Ott               | 69      | 61                   | 16 DKN     | 3   | DP  | 2,0     |          | 1    | 192649 ● | 192650 ● |
| Ott               | 69      | 61                   | 16 DKN     | 4   | DP  | 2,0     |          | 1    | 192651 ● | 192652 ● |
| SCM               | 55,3    | 49,33                | 16 DKN     | 3   | DP  | 2,0     |          | 13   | 192701   |          |
| SCM               | 55,3    | 49,33                | 16 DKN     | 3   | DP  | 2,0     |          | 13   |          | 192702   |
| SCM               | 55,3    | 49,33                | 16 DKN     | 3   | HW  | 2,0     |          | 13   | 182510 ● | 182511 ● |
| SCM               | 55,7    | 48                   | 16 DKN     | 3   | HW  | 1,0     |          | 14   | 182512 ● | 182513 ● |
| SCM               | 55,7    | 48                   | 16 DKN     | 3   | HW  | 1,5     |          | 14   | 182514 ● | 182515 ● |
| SCM               | 55,7    | 48                   | 16 DKN     | 3   | HW  | 2,0     |          | 14   | 182516 ● | 182517 ● |
| SCM               | 55,7    | 48                   | 16 DKN     | 3   | HW  | 3,0     |          | 14   | 182518 ● | 182519 ● |
| SCM               | 65,82   | 63,88                | HSK 25 R 4 | 4   | HW  | 1,0     |          | 15   | 182526   | 182527   |
| SCM               | 66,44   | 63,88                | HSK 25 R 4 | 4   | HW  | 1,5     |          | 15   | 182528   | 182529   |
| SCM               | 67,09   | 63,88                | HSK 25 R 4 | 4   | HW  | 2,0     |          | 15   | 182530   | 182531   |
| SCM               | 67,55   | 63,88                | HSK 25 R 4 | 4   | HW  | 2,5     |          | 15   | 182532   | 182533   |
| SCM               | 68      | 63,88                | HSK 25 R 4 | 4   | HW  | 3,0     |          | 15   | 182534   | 182535   |
| Stefani           | 70      | 60                   | 16 DKN     | 4   | DP  | 1,0     |          | 6    | 192524 □ | 192525 □ |
| Stefani           | 70      | 60                   | 16 DKN     | 4   | DP  | 2,0     |          | 6    | 192526 □ | 192527 □ |
| Stefani           | 70      | 60                   | 16 DKN     | 4   | DP  | 3,0     |          | 6    | 192528 □ | 192529 □ |
| Stefani           | 51,5    | 49,71                | 16 DKN     | 4   | HW  | 1,0     |          | 8    | 192657   | 192658   |
| Stefani           | 51,5    | 49,71                | 16 DKN     | 4   | HW  | 1,5     |          | 8    | 192659   | 192660   |
| Stefani           | 51,5    | 49,71                | 16 DKN     | 4   | HW  | 2,0     |          | 8    | 192661   | 192662   |
| Törk Makine       | 46      | 39                   | 16         | 4   | DP  | 2,0     |          | 3    | 192643   | 192644   |

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

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



### Profile cutter with optimised chip collection

#### Application:

To round edgebandings.

#### Machine:

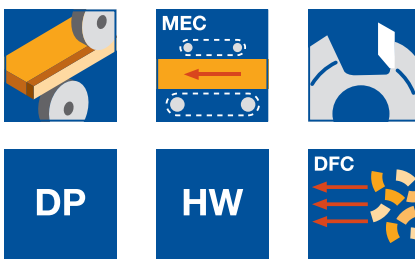
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

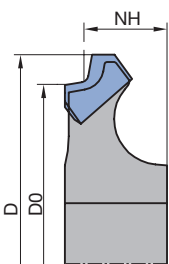
HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter. It is not recommended to sharpen the tool.



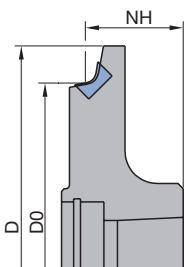
#### Various radii - optimised chip collection

WF 210 2 DP, WF 501 2, WF 501 2 DP

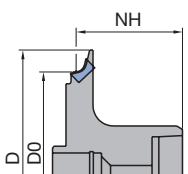
| Machine    | D    | D <sub>0</sub> | NH    | BO       | Z | QAL | R   | ID       | ID       |
|------------|------|----------------|-------|----------|---|-----|-----|----------|----------|
|            | mm   | mm             | mm    | mm       |   |     | mm  | LH       | RH       |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 4 | DP  | 1,0 | 198212 ● | 198213 ● |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 4 | DP  | 1,5 | 198214 □ | 198215 □ |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 4 | DP  | 2,0 | 198216 ● | 198217 ● |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 4 | DP  | 2,5 | 198220 □ | 198221 □ |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 4 | DP  | 3,0 | 198222   | 198223   |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 6 | DP  | 1,0 | 198246 □ | 198247 □ |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 6 | DP  | 1,5 | 198244 ● | 198245 ● |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 6 | DP  | 2,0 | 198218 □ | 198219 □ |
| Homag      | 75   | 62             | 31,5  | HSK 32   | 6 | DP  | 3,0 | 198224   | 198225   |
| Homag, IMA | 76   | 70             | 17,5  | HSK 25 R | 4 | DP  | 1,0 | 198494 ● | 198484 ● |
| Homag, IMA | 76   | 70             | 17,5  | HSK 25 R | 4 | DP  | 1,5 | 198495 ● | 198485 ● |
| Homag, IMA | 76   | 70             | 18,5  | HSK 25 R | 4 | DP  | 2,0 | 198496 ● | 198486 ● |
| Homag, IMA | 76   | 70             | 17,5  | HSK 25 R | 6 | DP  | 1,0 | 198499 ● | 198489 □ |
| Homag, IMA | 76   | 70             | 17,5  | HSK 25 R | 6 | DP  | 1,5 | 198500 ● | 198490 ● |
| Homag, IMA | 76   | 70             | 18,5  | HSK 25 R | 6 | DP  | 2,0 | 198501 ● | 198491 ● |
| Homag, IMA | 78   | 70             | 19    | HSK 25 R | 4 | DP  | 2,5 | 198497 □ | 198487 □ |
| Homag, IMA | 78   | 70             | 19,5  | HSK 25 R | 4 | DP  | 3,0 | 198498 ● | 198488 ● |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | DP  | 1,0 | 192699   | 192700   |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | HW  | 1,0 | 182502 ● | 182503 ● |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | HW  | 1,5 | 182504 ● | 182505 ● |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | DP  | 2,0 | 192697 ● | 192698 ● |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | HW  | 2,0 | 182506 ● | 182507 ● |
| SCM        | 55,3 | 48             | 11,4  | 16 DKN   | 3 | HW  | 3,0 | 182508 ● | 182509 ● |
| SCM        | 69,6 | 61,7           | 21,35 | HSK 25 R | 4 | HW  | 1,0 | 182546   | 182547   |
| SCM        | 69,6 | 61,7           | 21,35 | HSK 25 R | 4 | HW  | 1,5 | 182548   | 182549   |
| SCM        | 69,6 | 61,7           | 21,35 | HSK 25 R | 4 | HW  | 2,0 | 182550   | 182551   |
| SCM        | 69,6 | 61,7           | 21,35 | HSK 25 R | 4 | HW  | 2,5 | 182554   | 182555   |
| SCM        | 69,6 | 61,7           | 21,35 | HSK 25 R | 4 | HW  | 3,0 | 182556   | 182557   |
| SCM        | 69,9 | 62,3           | 22    | HSK 25 R | 4 | DP  | 1,0 | 192709 □ | 192710 □ |
| SCM        | 69,9 | 62,3           | 22    | HSK 25 R | 4 | DP  | 1,5 | 192711 □ | 192712 □ |
| SCM        | 69,9 | 62,3           | 22    | HSK 25 R | 4 | DP  | 2,0 | 192713 □ | 192714 □ |
| SCM        | 69,9 | 62,3           | 22    | HSK 25 R | 4 | DP  | 2,5 | 192715 □ | 192716 □ |
| SCM        | 69,9 | 62,3           | 22    | HSK 25 R | 4 | DP  | 3,0 | 192717 □ | 192718 □ |



Radius cutter with cylindrical bore



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 adaptor for FK aggregates



### Multi-profile cutter

#### Application:

For a choice of radii or bevels on edgebandings.

#### Machine:

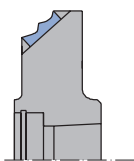
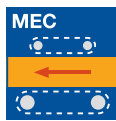
Single or double-sided edgebanding machines.

#### Workpiece material:

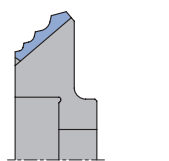
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

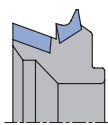
HW/DP tipped tools with cylindrical bore or HSK 25 R adaptor. Profiling with e.g. radii 2.0 and 3.0 mm and bevel 20°.  $D_0$  = constant reference diameter. It is not recommended to resharpen the tool.



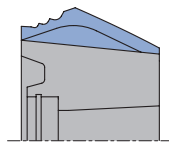
Type 1



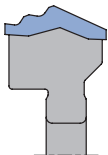
Type 2



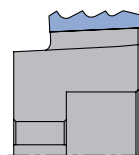
Type 3



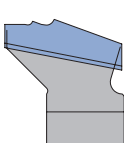
Type 4



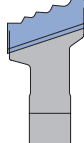
Type 5



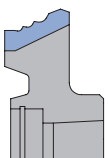
Type 6



Type 7



Type 8



Type 9

#### Multi-profile cutter

WF 210 2, WF 210 2 DP, WF 501 2, WF 501 2 DP, WF 501 2 DP, WF 502 2, WF 502 2 DP, WF 502 2 DP

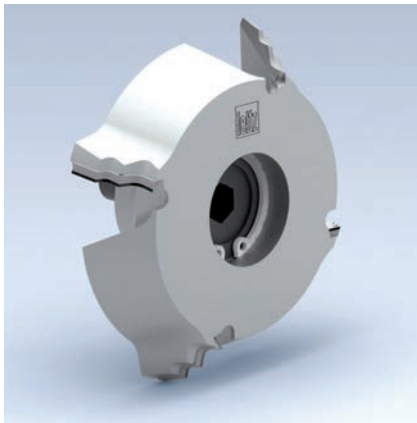
| Machine  | D     | $D_0$ | BO       | Z | QAL | R           | FAW | Type | ID     | ID     |
|----------|-------|-------|----------|---|-----|-------------|-----|------|--------|--------|
|          | mm    | mm    | mm       |   |     | mm          | °   |      | LH     | RH     |
| Biesse   | 75,4  | 60    | 16 DKN   | 6 | DP  | 1/2/3       | 25  | 2    | 091996 | 091995 |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 2           |     | 3    | 192530 | 192531 |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 2,5         |     | 3    | 192532 | 192533 |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 3           |     | 3    | 192534 | 192535 |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 2           |     | 3    | 192530 | 192531 |
| 1826     |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 2,5         |     | 3    | 192532 | 192533 |
| 1826     |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 58    | 50    | 20 DKN   | 2 | DP  | 3           |     | 3    | 192534 | 192535 |
| 1826     |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 3/2/1,3     | 45  | 6    | 192673 | 192674 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 1,3/1/0,8   | 45  | 6    | 192681 | 192682 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 3/2/1,3     | 10  | 6    | 192679 | 192680 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 2/1,3/1,3   | 45  | 6    | 192677 | 192678 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 2/2/1,3     | 45  | 6    | 192675 | 192676 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 3/2/2       | 45  | 6    | 192743 | 192744 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71    | 68    | 16 DKN   | 4 | DP  | 2/1,3       | 45  | 6    | 192745 | 192746 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71,5  | 68    | 16 DKN   | 4 | DP  | 2/1,3/2/1,3 |     | 6    | 192691 | 192692 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Holz-Her | 71,5  | 68    | 16 DKN   | 4 | DP  | 2/1,3       | 31  | 6    | 192693 | 192694 |
| FR701    |       |       |          |   |     |             |     |      |        |        |
| Homag    | 74,33 | 65,7  | HSK 25 R | 4 | DP  | 1/2         |     | 4    | 198506 | 198507 |
| Homag    | 74,67 | 65,7  | HSK 25 R | 4 | DP  | 1,3/2       |     | 4    | 198508 | 198509 |
| Homag    | 74,33 | 62,99 | 16 DKN   | 4 | DP  | 1/2         |     | 5    | 192683 | 192684 |
| Homag    | 74,66 | 65,69 | 16 DKN   | 4 | DP  | 1,3/2       |     | 5    | 192685 | 192686 |
| SCM      | 74,5  | 63,9  | HSK 25 R | 4 | HW  | 1/1,5/2     |     | 9    | 182538 | 182539 |
| SCM      | 74,5  | 63,9  | HSK 25 R | 4 | HW  | 1/1,5/3     |     | 9    | 182540 | 182541 |
| SCM      | 74,5  | 63,9  | HSK 25 R | 4 | HW  | 1/2/3       |     | 9    | 182542 | 182543 |
| SCM      | 75,7  | 63,9  | HSK 25 R | 4 | HW  | 1,5/2/3     |     | 9    | 182544 | 182545 |
| SCM      | 75,7  | 63,9  | HSK 25 R | 4 | HW  | 1/1,5/2,5   |     | 9    | 182558 | 182559 |
| SCM      | 75,7  | 63,9  | HSK 25 R | 4 | HW  | 2/2,5/3     |     | 9    | 182560 | 182561 |
| SCM      | 62,03 | 49,44 | 16 DKN   | 4 | HW  | 1/1,5       |     | 7    | 182522 | 182523 |
| SCM      | 62,47 | 50,12 | 16 DKN   | 4 | HW  | 1/2         |     | 7    | 182520 | 182521 |
| SCM      | 73    | 60    | 16 DKN   | 4 | HW  | 2/3         |     | 8    | 182501 | 182500 |
| SCM      | 73    | 60    | 16 DKN   | 4 | DP  | 2/3         |     | 8    | 192696 | 192695 |
| SCM      | 77,4  | 63,1  | 16 DKN   | 4 | HW  | 1/1,5/2     |     | 8    | 182524 | 182525 |
| Stefani  | 74,5  | 63,88 | HSK 25 R | 4 | DP  | 1/1,5/2     | 20  | 1    | 192653 | 192654 |
| Stefani  | 74,5  | 63,88 | HSK 25 R | 4 | DP  | 1/1,5/2     | 20  | 4    | 192655 | 192656 |

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

● available ex stock

□ available at short notice

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



### Multi-profile cutter with optimised chip collection

#### Application:

For a choice of radii or bevels on edgebandings.

#### Machine:

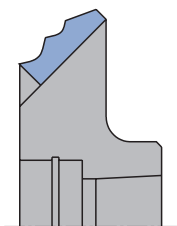
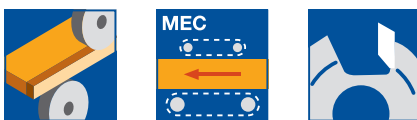
Single or double-sided edgebanding machines.

#### Workpiece material:

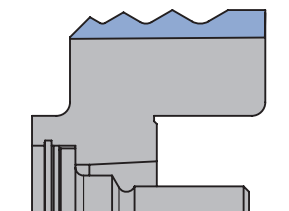
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

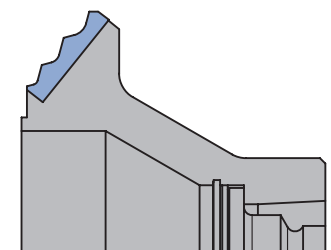
DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. It is not recommended to resharpen the tool.



Type 1



Type 2



Type 3

#### Multi-profile cutter - optimised chip collection

WF 501 2 DP, WF 502 2 DP

| Machine                | D  | D <sub>0</sub> | B  | BO            | Z       | QAL | R  | FAW | Type | ID       | ID       |
|------------------------|----|----------------|----|---------------|---------|-----|----|-----|------|----------|----------|
|                        | mm | mm             | mm | mm            |         |     | mm | °   |      | LH       | RH       |
| Homag, IMA 85          | 62 |                |    | HSK 25 R 4 DP | 2/3     |     | 20 | 1   |      | 198444 □ | 198445 □ |
| Homag, IMA 85          | 62 |                |    | HSK 25 R 4 DP | 1,5/2   |     | 20 | 1   |      | 198504 ● | 198505 ● |
| Homag, IMA 85          | 62 |                |    | HSK 25 R 6 DP | 2/3     |     | 20 | 1   |      | 198456 □ | 198457 □ |
| IMA Multi-profiler     | 75 |                | 30 | HSK 25 R 6 DP | 1/2/3   |     | 15 | 2   |      | 091916 ● | 091917 ● |
| IMA Multi-profiler     | 75 |                | 30 | HSK 25 R 6 DP | 1/1,5/2 |     | 20 | 2   |      | 091922 ● | 091923 ● |
| IMA Multi-profiler KFA | 75 |                | 28 | HSK 25 R 6 DP | 1/2/3   |     | 15 | 2   |      | 091912 □ | 091913 □ |
| IMA Multi-profiler KFA | 75 |                | 28 | HSK 25 R 6 DP | 1/1,5/2 |     | 20 | 2   |      | 091924 ● | 091925 □ |
| IMA Multi-profiler KFA | 75 |                | 28 | HSK 25 R 6 DP | 1/2/3   |     | 45 | 2   |      | 091926 ● | 091927 □ |
| IMA MFA                | 89 | 62             |    | HSK 25 R 6 DP | 1/2     |     | 15 | 3   |      | 091918   | 091919   |
| IMA MFA                | 89 | 57             |    | HSK 25 R 6 DP | 1/2/3   |     | 15 | 3   |      | 091920   | 091921   |

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



### Profile cutterhead ProfilCut Q Diamond

#### Application:

For processing edgebandings.

#### Machine:

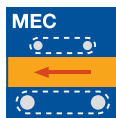
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Low tool life cost thanks to resharpenable exchangeable knives. Plug & play – no adjustment work required after service. Reusable tool body. Six tool lives per diamond knife.



#### Pre / finishing edge trimming cutter - ProfilCut Q Diamond

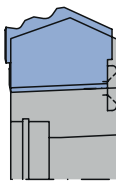
WE 500 2 54

| Machine    | D<br>mm | SB<br>mm | BO<br>mm | Z | QAL | ID<br>LH      | ID<br>RH      |
|------------|---------|----------|----------|---|-----|---------------|---------------|
| Homag, IMA | 70      | 10       | HSK 25 R | 4 | DP  | <b>198510</b> | <b>198511</b> |
| Homag, IMA | 70      | 10       | HSK 25 R | 6 | DP  | <b>198512</b> | <b>198513</b> |

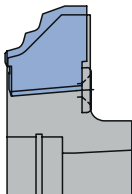
#### Profile cutter - ProfilCut Q Diamond

WE 500 2 54

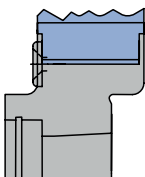
| Machine    | D<br>mm | D <sub>0</sub><br>mm | NH<br>mm | BO<br>mm | Z | QAL | R<br>mm | ID<br>LH      | ID<br>RH      |
|------------|---------|----------------------|----------|----------|---|-----|---------|---------------|---------------|
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 4 | DP  | 1,0     | <b>198514</b> | <b>198515</b> |
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 4 | DP  | 1,5     | <b>198516</b> | <b>198517</b> |
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 4 | DP  | 2,0     | <b>198518</b> | <b>198519</b> |
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 6 | DP  | 1,0     | <b>198520</b> | <b>198521</b> |
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 6 | DP  | 1,5     | <b>198522</b> | <b>198523</b> |
| Homag, IMA | 76      | 70                   | 17,5     | HSK 25 R | 6 | DP  | 2,0     | <b>198524</b> | <b>198525</b> |



Type 1



Type 2

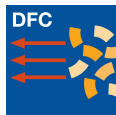
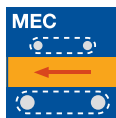


Type 3

#### Multi-profile cutter - ProfilCut Q Diamond

WE 500 2 54

| Machine    | D<br>mm | B<br>mm | BO<br>mm | Z | QAL | R<br>mm | FAW<br>° | Type | ID<br>LH      | ID<br>RH      |
|------------|---------|---------|----------|---|-----|---------|----------|------|---------------|---------------|
| Homag      | 74,33   | 24,3    | HSK 25 R | 4 | DP  | 1/2     |          | 1    | <b>198526</b> | <b>198527</b> |
| Homag, IMA | 81,6    | 27      | HSK 25 R | 4 | DP  | 1,5/2   | 20       | 2    | <b>198528</b> | <b>198529</b> |
| IMA        | 75      | 30      | HSK 25 R | 6 | DP  | 1/2/3   | 15       | 3    | <b>198530</b> | <b>198531</b> |
| IMA        | 75      | 30      | HSK 25 R | 6 | DP  | 1/1,5/2 | 20       | 3    | <b>198532</b> | <b>198533</b> |
| IMA        | 75      | 28      | HSK 25 R | 6 | DP  | 1/1,5/2 | 20       | 3    | <b>198534</b> | <b>198535</b> |
| IMA        | 75      | 28      | HSK 25 R | 6 | DP  | 1/2/3   | 45       | 3    | <b>198536</b> | <b>198537</b> |



### Multi-profile cutter with optimised chip collection

#### Application:

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

#### Machine:

Homag edgebanding machines with profile FK31 trimming aggregate.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Three profiles in one tool. DFC design for highly efficient chip clearance of more than 97%.  $D_0$  = constant reference diameter. Low noise DP tool. Maximum concentricity. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.

#### Diamaster PRO, FK31 aggregate

WF 501 2 DP

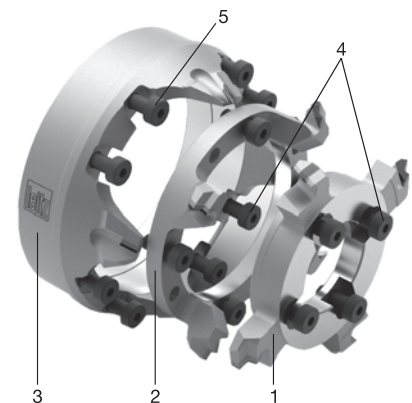
| Machine | Tool no. | D mm | $D_0$ mm | BO mm | Z | QAL | R mm | FAW ° | ID LH    | ID RH    |
|---------|----------|------|----------|-------|---|-----|------|-------|----------|----------|
| Homag   | 1        | 88   | 80,1     | 46    | 4 | DP  | 1,5  |       | 192558 □ | 192559 □ |
| Homag   | 1        | 88   | 80,1     | 46    | 4 | DP  | 2,0  |       | 192556 ● | 192557 ● |
| Homag   | 1        | 88   | 80,1     | 46    | 4 | DP  | 2,5  |       | 192554 □ | 192555 □ |
| Homag   | 1        | 88   | 80,1     | 46    | 4 | DP  | 3,0  |       | 192552 □ | 192553 □ |
| Homag   | 2        | 87   | 80,1     | 55    | 4 | DP  | 1,0  |       | 192568 ● | 192569 □ |
| Homag   | 2        | 87   | 80,1     | 55    | 4 | DP  | 1,5  |       | 192566 □ | 192567 □ |
| Homag   | 2        | 87   | 80,1     | 55    | 4 | DP  | 2,0  |       | 192564 □ | 192565 □ |
| Homag   | 3        | 92   | 80,1     | 73    | 4 | DP  | 1,0  |       | 192574 □ | 192575 ● |
| Homag   | 3        | 92   | 80,1     | 73    | 4 | DP  | 1,5  |       | 192572 □ | 192573 □ |
| Homag   | 3        | 92   | 80,1     | 73    | 4 | DP  | 2,0  |       | 192570 □ | 192571 □ |
| Homag   | 3        | 92   | 80,1     | 73    | 4 | DP  |      | 20    |          | 192119   |
| Homag   | 3        | 92   | 80,1     | 73    | 4 | DP  |      | 45    | 192116 ● | 192117 ● |

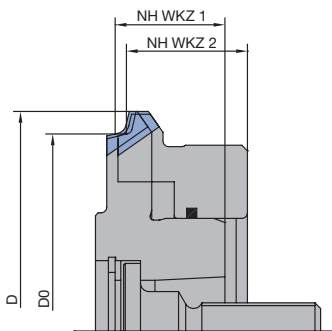
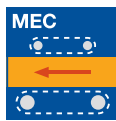
Differing radii available at short notice from a tool bank. Tool 1 radius must be greater than tool 2 and 3. The larger radius defines the maximal bevel size of the moveable bevel tools 2 and 3.

#### Spare parts:

| Part-no. | BEZ                        | ABM mm | ID       |
|----------|----------------------------|--------|----------|
| 4        | Cylindrical screw with ISK | M5x12  | 114046 ● |
| 5        | Cylindrical screw with ISK | M5x30  | 114045 ● |

Tools supplied with mounting screws.





### Profile cutter flexTrim

#### Application:

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

#### Machine:

Homag edgebanding machines with cutting unit type FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Two profiles in one tool. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running.  $D_0$  = constant reference diameter,  $RPM n_{max} = 18000 \text{ min}^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.

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

SF 542 2 15

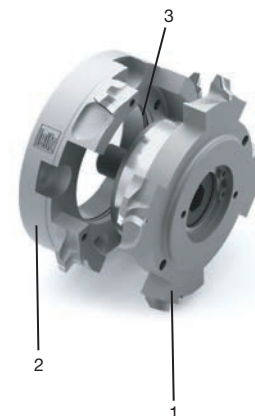
| Machine | D  | D <sub>0</sub> | NH   | BO         | Z  | QAL | R       | FAW | ID       | ID       |
|---------|----|----------------|------|------------|----|-----|---------|-----|----------|----------|
|         | mm | mm             | mm   | mm         |    |     | mm      | °   | LH       | RH       |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 1,5/1,0 |     | 194300 □ | 194301 □ |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 2,0/1,0 |     | 194302 ● | 194303 ● |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 2,0/1,5 |     | 194304 □ | 194305 □ |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 3,0/2,0 |     | 194306 □ | 194307 □ |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 2,0     | 20  | 194308 □ | 194309 □ |
| Homag   | 78 | 70             | 19,5 | HSK 25 R 4 | DP |     | 2,0     | 45  | 194310 ● | 194311 ● |

Tool 1 fix + tool 2 flexible

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

#### Spare parts:

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



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



### Profile cutter flexTrim

#### Application:

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

#### Machine:

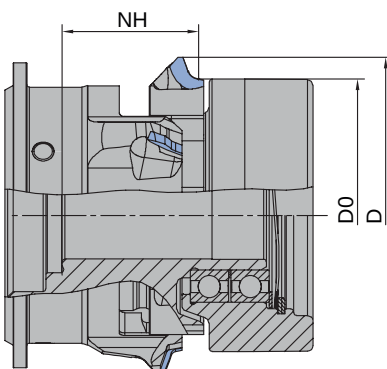
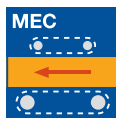
Homag edgebanding machines with cutting unit type FF6210.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running.  $D_0$  = constant reference diameter,  $RPM\ n_{max} = 12000\ min^{-1}$ . It is not possible to sharpen the tool.

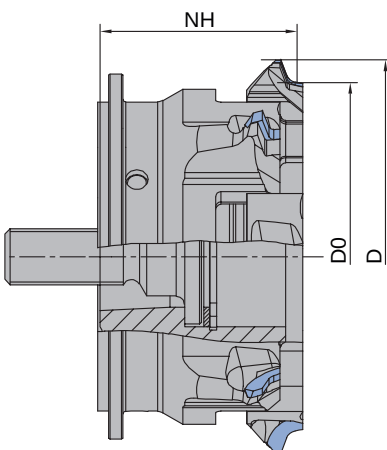
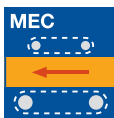


#### Multi-profile cutterset flexTrim - Diamaster PRO, aggregate FF6210

SF 542 2 18, WF 501 2 18

| Machine | D<br>mm | $D_0$<br>mm | NH<br>mm | BO<br>mm | Z | QAL | R<br>mm | FAW<br>° | ID<br>RH |
|---------|---------|-------------|----------|----------|---|-----|---------|----------|----------|
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 3,0/1,0 |          | 194700 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 3,0/1,3 |          | 194701 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 3,0/2,0 |          | 194702 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 2,0/1,0 |          | 194703 ● |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 2,0/1,3 |          | 194704 ● |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 2,0/1,5 |          | 194705 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 2,0     | 45       | 194706 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 1,5/1,5 |          | 194707 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 3,0     |          | 194724 ● |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 2,0     |          | 194725 ● |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 1,5     |          | 194726 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 1,3     |          | 194727 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  | 1,0     |          | 194728 ● |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  |         | 45       | 194729 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  |         | 30       | 194730 □ |
| Homag   | 58      | 50          | 25       | 16       | 3 | DP  |         | 15       | 194731 □ |

Further profile variants and combinations possible on request.



### Profile cutter flexTrim

#### Application:

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

#### Machine:

Homag edgebanding machines with cutting unit type MF50, MF60.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running.  $D_0$  = constant reference diameter,  $RPM \ n_{max} = 12000 \text{ min}^{-1}$ . It is not possible to sharpen the tool.

#### Multi-profile cutterset flexTrim - Diamaster PRO, aggregate MF50, MF60

SF 542 2 18, WF 501 2 18

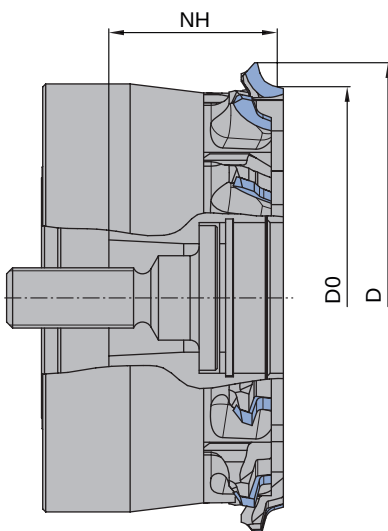
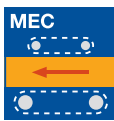
| Machine | D  | D <sub>0</sub> | NH | BO       | Z | QAL | R       | FAW | ID       | ID       |
|---------|----|----------------|----|----------|---|-----|---------|-----|----------|----------|
|         | mm | mm             | mm | mm       |   |     | mm      | °   | LH       | RH       |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 3,0/1,0 |     | 194708 ● | 194709 ● |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 3,0/1,3 |     | 194710 ● | 194711 ● |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 3,0/2,0 |     | 194712 □ | 194713 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 2,0/1,0 |     | 194714 ● | 194715 ● |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 2,0/1,3 |     | 194716 ● | 194717 ● |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 2,0/1,5 |     | 194718 □ | 194719 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 2,0     | 45  | 194720 □ | 194721 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 1,5/1,5 |     | 194722 □ | 194723 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 1,3/1,0 |     | 194732 □ | 194733 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 3,0     |     | 194740 □ | 194741 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 2,0     |     | 194742 ● | 194743 ● |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 1,5     |     | 194744 □ | 194745 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 1,3     |     | 194746 □ | 194747 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  | 1,0     |     | 194748 □ | 194749 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  |         | 45  | 194750 □ | 194751 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  |         | 30  | 194752 □ | 194753 □ |
| Homag   | 70 | 62             | 35 | HSK 25 R | 4 | DP  |         | 15  | 194754 □ | 194755 □ |

Further profile variants and combinations possible on request.

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



### Profile cutter flexTrim3

#### Application:

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

#### Machine:

Homag edgebanding machines with cutting unit type FF32 with flexTrim cutting head.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

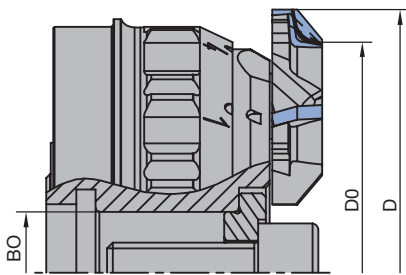
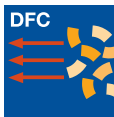
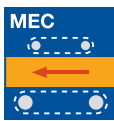
Three profiles in one tool. Maximum processing quality through high running accuracy and quiet running.  $D_0$  = constant reference diameter,  $RPM\ n_{max} = 12.000\ min^{-1}$ . Replacement of tool components only by qualified personnel of the tool or machine manufacturer. It is not possible to sharpen the tool.

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

SF 541 2 17

| Machine | D  | D <sub>0</sub> | NH | BO       | Z | QAL | R       | FAW | ID              | ID              |
|---------|----|----------------|----|----------|---|-----|---------|-----|-----------------|-----------------|
|         | mm | mm             | mm | mm       |   |     | mm      | °   | LH              | RH              |
| Homag   | 78 | 70             | 28 | HSK 25 R | 4 | DP  | 2/1,5/1 |     | <b>194500</b> □ | <b>194501</b> □ |
| Homag   | 78 | 70             | 28 | HSK 25 R | 4 | DP  | 2/1,3/1 |     | <b>194502</b> □ | <b>194503</b> □ |
| Homag   | 78 | 70             | 28 | HSK 25 R | 4 | DP  | 2/1     | 45  | <b>194514</b> □ | <b>194515</b> □ |
| Homag   | 78 | 70             | 28 | HSK 25 R | 4 | DP  | 2/1,3   | 45  | <b>194518</b> □ | <b>194519</b> □ |

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



### Profile cutter QuattroForm

#### Application:

For multi-profile cutting with radii and bevelling of edges. Combination of four profiles for automatic profile resetting.

#### Machine:

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

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP composite tool with four profiles and mounting screw. Profiles automatically adjustable by the machine control. Patented system.  $D_0$  = constant reference diameter,  $RPM\ n = 18000\ min^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.

#### Multi-profile cutter QuattroForm - Diamaster PRO

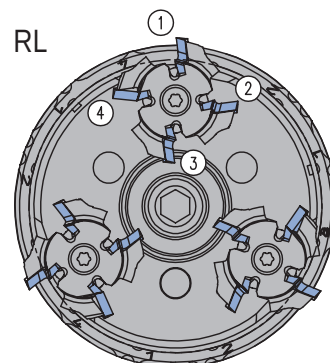
SF 540 2 10

| Machine               | D  | D <sub>0</sub> | BO | Z | R             | FAW | ID       | ID       |
|-----------------------|----|----------------|----|---|---------------|-----|----------|----------|
|                       | mm | mm             | mm |   | mm            | °   | LH       | RH       |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 2/1,3/2       | 45  | 193901 ● | 193900 ● |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 3/1,3/2       | 45  | 193903 □ | 193902 □ |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 3/1,3/2       | 10  | 193905 □ | 193904 □ |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 2/1,3/1,3     | 45  | 193907 ● | 193906 ● |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 2/1,5/1       | 45  | 193909 □ | 193908 □ |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 2/1,3/2/1,3   |     | 193917 ● | 193916 ● |
| Holz-Her FF 701 Multi | 70 | 61             | 16 | 3 | 2/1,3/1,3/1,3 |     | 193921 □ | 193920 □ |

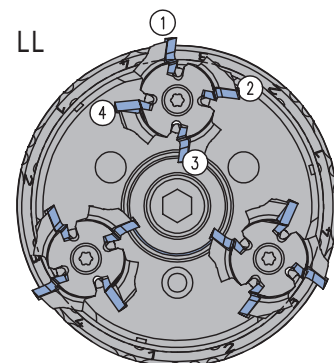
All tools and further profile variants are available in various dimensions from blanks at short notice. Profile radius maximum 3 mm.

#### Spare parts:

| BEZ                          | ID       |
|------------------------------|----------|
| Maintenance set Quattro Form | 008383 ● |



| ①  | ②    | ③    | ④    | Leitz-Id. | Holzher |
|----|------|------|------|-----------|---------|
| R2 | R1.3 | R2   | F45° | 193900    | 5073458 |
| R3 | R1.3 | R2   | F45° | 193902    | 5073461 |
| R3 | R1.3 | R2   | F10° | 193904    | 5073463 |
| R2 | R1.3 | R1.3 | F45° | 193906    | 5073466 |
| R2 | R1.5 | R1   | F45° | 193908    | 5073468 |
| R2 | R1.3 | R2   | R1.3 | 193916    | 5073449 |
| R2 | R1.3 | R1.3 | R1.3 | 193920    | 5073456 |



| ①  | ②    | ③    | ④    | Leitz-Id. | Holzher |
|----|------|------|------|-----------|---------|
| R2 | R1.3 | R2   | F45° | 193901    | 5073457 |
| R3 | R1.3 | R2   | F45° | 193903    | 5073459 |
| R3 | R1.3 | R2   | F10° | 193905    | 5073462 |
| R2 | R1.3 | R1.3 | F45° | 193907    | 5073465 |
| R2 | R1.5 | R1   | F45° | 193909    | 5073467 |
| R2 | R1.3 | R2   | R1.3 | 193917    | 5073447 |
| R2 | R1.3 | R1.3 | R1.3 | 193921    | 5073454 |



### Profile cutter Multi-Edge

#### Application:

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

#### Machine:

Stefani.

#### Workpiece material:

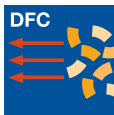
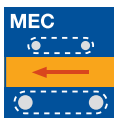
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Three profiles in one tool. DFC design for efficient chip collection.

Maximum processing quality through high running accuracy and smooth running.

$D_0$  = constant reference diameter,  $RPM\ n_{max} = 18000\ min^{-1}$ . Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.



#### Diamaster PRO

WF 501 2 16

| Machine | Tool no. | D mm | $D_0$ mm | BO mm  | Z | QAL | R mm | FAW ° | ID LH    | ID RH    |
|---------|----------|------|----------|--------|---|-----|------|-------|----------|----------|
| Stefani | 1        | 68   | 61,7     | 10 DKN | 4 | DP  | 1,0  |       | 192606 □ | 192605 □ |
| Stefani | 1        | 68   | 61,7     | 10 DKN | 4 | DP  | 1,5  |       | 192610 ● | 192609 ● |
| Stefani | 1        | 68   | 61,7     | 10 DKN | 4 | DP  | 2,0  |       | 192612 ● | 192611 ● |
| Stefani | 1        | 68   | 61,7     | 10 DKN | 4 | DP  | 2,5  |       | 192614 □ | 192613 □ |
| Stefani | 1        | 68   | 61,7     | 10 DKN | 4 | DP  | 3,0  |       | 192616 ● | 192615 ● |
| Stefani | 2        | 68   | 61,7     | 23     | 4 | DP  | 1,0  |       | 192618 ● | 192617 ● |
| Stefani | 2        | 68   | 61,7     | 23     | 4 | DP  | 1,5  |       | 192622 ● | 192621 ● |
| Stefani | 2        | 68   | 61,7     | 23     | 4 | DP  | 2,0  |       | 192624 □ | 192623 □ |
| Stefani | 3        | 68   | 61,5     | 38     | 4 | DP  | 1,0  |       | 192672 □ | 192671 □ |
| Stefani | 3        | 68   | 61,7     | 38     | 4 | DP  | 1,0  |       | 192629 □ | 192630 □ |
| Stefani | 3        | 68   | 61,7     | 38     | 4 | DP  | 2,0  |       | 192636 □ | 192635 □ |
| Stefani | 3        | 68   | 61,7     | 38     | 4 | DP  |      | 45    | 192730 □ | 192729 □ |

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



### Profile cutterhead / bevel cutterhead

#### Application:

To round edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

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

#### Various radii - Hebrock/EBM

WE 500 2

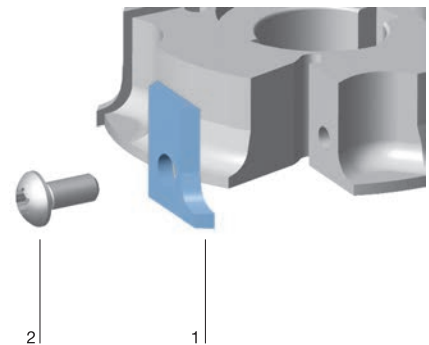
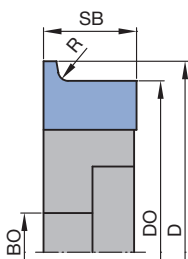
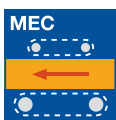
| Machine      | D  | $D_0$ | SB   | BO     | Z | R   | ID            | ID            |
|--------------|----|-------|------|--------|---|-----|---------------|---------------|
|              | mm | mm    | mm   | mm     |   | mm  | LH            | RH            |
| Hebrock, EBM | 56 | 49,7  | 14,5 | 16 DKN | 4 | 2,0 | <b>074559</b> | <b>074560</b> |
| Hebrock, EBM | 56 | 49,7  | 14,5 | 16 DKN | 4 | 2,5 | <b>074557</b> | <b>074558</b> |

#### Spare knives:

| Part-no. | Type | BEZ                  | ABM         | QAL | R   | VE  | ID              | ID              |
|----------|------|----------------------|-------------|-----|-----|-----|-----------------|-----------------|
|          |      |                      | mm          |     | mm  | PCS | LH              | RH              |
| 1        | 1    | Combi exchange knife | 14.5x14.5x2 | HW  | 2,0 | 2   | <b>074632</b> ● | <b>074633</b> ● |
| 1        | 1    | Combi exchange knife | 14.5x14.5x2 | HW  | 2,5 | 2   | <b>074630</b> ● | <b>074631</b> ● |

#### Spare parts:

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





### Profile cutterhead / bevel cutterhead

#### Application:

To round and bevel edgebandings.

#### Machine:

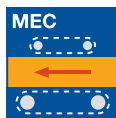
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

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



#### Various profiles - DFC, Brandt, Homag

WE 500 2

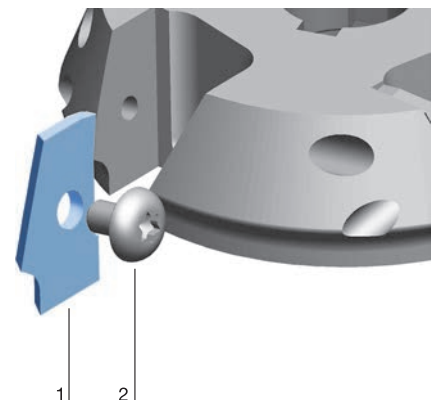
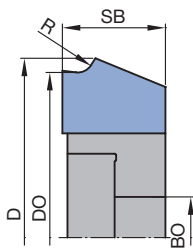
| Machine       | D<br>mm | SB<br>mm | BO<br>mm | Z | R<br>mm | FAW<br>° | ID<br>LH | ID<br>RH |
|---------------|---------|----------|----------|---|---------|----------|----------|----------|
| Brandt, Homag | 69,98   | 20,28    | 16 DKN   | 4 |         | 45       | 075016 □ | 075017 □ |
| Brandt, Homag | 70,57   | 20,28    | 16 DKN   | 4 | 1,0     |          | 075018 ● | 075019 ● |
| Brandt, Homag | 70,57   | 20,28    | 16 DKN   | 4 | 1,3     |          | 075072 ● | 075073 ● |
| Brandt, Homag | 70,57   | 20,28    | 16 DKN   | 4 | 1,5     |          | 075022 □ | 075023 □ |
| Brandt, Homag | 70,57   | 20,28    | 16 DKN   | 4 | 2,0     |          | 075024 ● | 075025 ● |
| Brandt, Homag | 70,57   | 20,28    | 16 DKN   | 4 | 3,0     |          | 075028 ● | 075029 ● |

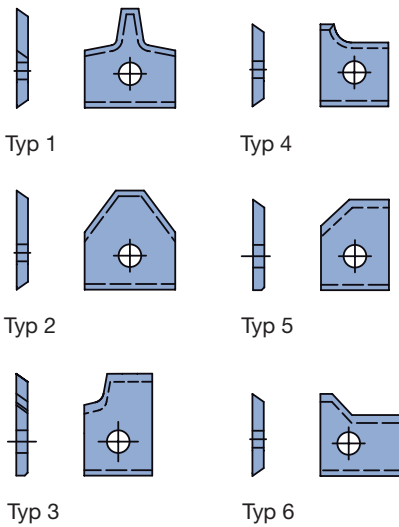
#### Spare knives:

| Part-<br>no. | Type | BEZ            | ABM<br>mm | QAL | R<br>mm | FAW<br>° | VE<br>PCS | ID<br>LH | ID<br>RH |
|--------------|------|----------------|-----------|-----|---------|----------|-----------|----------|----------|
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 1,0     |          | 2         | 075315 ● | 075314 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 1,2     |          | 2         | 075317 □ | 075316 □ |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 1,3     |          | 2         | 075272 ● | 075271 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 1,5     |          | 2         | 075319 ● | 075318 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 2,0     |          | 2         | 075307 ● | 075306 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  | 3,0     |          | 2         | 075309 ● | 075308 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  |         | 15       | 2         | 075311 ● | 075310 ● |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  |         | 30       | 2         | 075331 □ | 075332 □ |
| 1            | 1    | Exchange knife | 22,3x14x2 | HW  |         | 45       | 2         | 075313 ● | 075312 ● |

#### Spare parts:

| Part-no. | BEZ                      | ABM<br>mm | ID       |
|----------|--------------------------|-----------|----------|
| 2        | Oval head screw Torx® 15 | M4x6      | 006225 ● |
|          | Torx® key                | Torx® 15  | 117507 ● |





### Profile cutterhead / bevel cutterhead

#### Profile knives for edge finishing

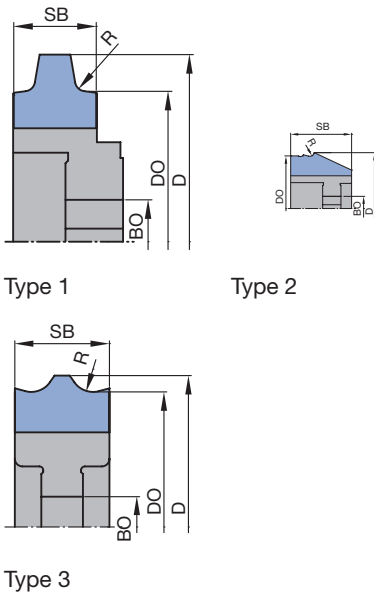
TM 135 0

| SB   | H    | DIK | QAL | Knife | R   | FAW | VE  | ID       | ID       |
|------|------|-----|-----|-------|-----|-----|-----|----------|----------|
| mm   | mm   | mm  |     |       | mm  | °   | PCS | LH       | RH       |
| 16   | 17,5 | 2   | HW  | 1     | 2,0 |     | 2   | 005132 ● | 005132 ● |
| 16   | 17,5 | 2   | HW  | 1     | 3,0 |     | 2   | 005133 ● | 005133 ● |
| 16   | 17,5 | 2   | HW  | 1     | 4,0 |     | 2   | 005134 ● | 005134 ● |
| 16   | 17,5 | 2   | HW  | 1     | 5,0 |     | 2   | 005135 ● | 005135 ● |
| 16   | 17,5 | 2   | HW  | 2     |     | 45  | 2   |          | 009525 ● |
| 12   | 17   | 2   | HW  | 3     | 2,0 |     | 2   | 073554 ● | 073555 ● |
| 12   | 18   | 2   | HW  | 3     | 2,0 |     | 2   | 074033 □ | 074034 □ |
| 12   | 17   | 2   | HW  | 3     | 3,0 |     | 2   | 073558 ● | 073559 ● |
| 12   | 18   | 2   | HW  | 3     | 3,0 |     | 2   | 074035 □ | 074036 □ |
| 13   | 15   | 2   | HW  | 3     | 2,0 |     | 2   | 073505 ● | 073504 ● |
| 13   | 15   | 2   | HW  | 3     | 3,0 |     | 2   | 073509 ● | 073508 ● |
| 12   | 14,5 | 2   | HW  | 4     | 2,0 |     | 2   | 075342 ● | 075341 ● |
| 14,5 | 14,5 | 2   | HW  | 4     | 2,5 |     | 2   |          | 073544 ● |
| 12   | 14,5 | 2   | HW  | 4     | 3,0 |     | 2   | 075301 □ | 075300 □ |
| 12   | 16   | 2   | HW  | 5     |     | 45  | 2   | 073541 ● | 073540 ● |

#### Profile knives for system Biesse

TM 135 0

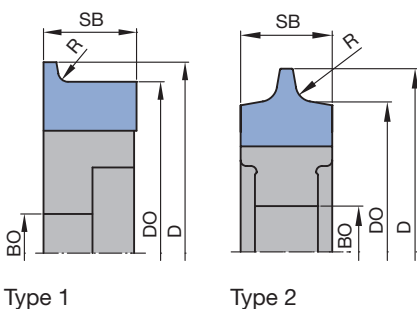
| Type | BEZ            | ABM     | QAL | R   | VE  | ID       | ID       |
|------|----------------|---------|-----|-----|-----|----------|----------|
|      |                | mm      |     | mm  | PCS | LH       | RH       |
| 1    | Exchange knife | 16x17x2 | HW  | 1,0 | 2   | 074600 □ | 074600 □ |
| 1    | Exchange knife | 16x17x2 | HW  | 1,5 | 2   | 074601 □ | 074601 □ |
| 1    | Exchange knife | 16x17x2 | HW  | 2,0 | 2   | 074602 ● | 074602 ● |
| 1    | Exchange knife | 16x17x2 | HW  | 2,5 | 2   | 074603 □ | 074603 □ |
| 1    | Exchange knife | 16x17x2 | HW  | 3,0 | 2   | 074604 □ | 074604 □ |
| 2    | Exchange knife | 40x17x2 | HW  | 1,0 | 2   | 074610 □ | 074611 □ |
| 2    | Exchange knife | 40x17x2 | HW  | 1,5 | 2   | 074612 □ | 074613 □ |
| 2    | Exchange knife | 40x17x2 | HW  | 2,0 | 2   | 074614 ● | 074615 ● |
| 2    | Exchange knife | 40x17x2 | HW  | 2,5 | 2   | 074616 □ | 074617 □ |
| 2    | Exchange knife | 40x17x2 | HW  | 3,0 | 2   | 074618 □ | 074619 □ |
| 3    | Exchange knife | 20x16x2 | HW  | 1,0 | 2   | 074620 □ | 074620 □ |
| 3    | Exchange knife | 20x16x2 | HW  | 1,5 | 2   | 074621 □ | 074621 □ |
| 3    | Exchange knife | 20x16x2 | HW  | 2,0 | 2   | 074622 □ | 074622 □ |
| 3    | Exchange knife | 20x16x2 | HW  | 2,5 | 2   | 074623 □ | 074623 □ |
| 3    | Exchange knife | 20x16x2 | HW  | 3,0 | 2   | 074624 □ | 074624 □ |



#### Profile knives for system Brandt, Homag

TM 135 0

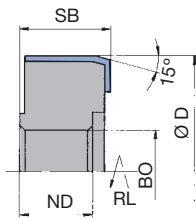
| Type | BEZ            | ABM         | QAL | R   | VE  | ID       | ID       |
|------|----------------|-------------|-----|-----|-----|----------|----------|
|      |                | mm          |     | mm  | PCS | LH       | RH       |
| 2    | Exchange knife | 12x13x2     | HW  | 1,5 | 2   | 075339 □ | 075339 □ |
| 1    | Exchange knife | 19,6x15,2x2 | HW  | 2,5 | 2   | 075338 □ | 075337 □ |
| 1    | Exchange knife | 19,6x15,2x2 | HW  | 2,0 | 2   | 075336 ● | 075335 ● |
| 1    | Exchange knife | 19,6x15,2x2 | HW  | 1,5 | 2   | 075334 ● | 075333 ● |
| 2    | Exchange knife | 12x13x2     | HW  | 2,0 | 2   | 075330 ● | 075330 ● |
| 1    | Exchange knife | 16x13,4x2   | HW  | 3,0 | 2   | 075329 □ | 075328 □ |
| 1    | Exchange knife | 16x13,4x2   | HW  | 2,0 | 2   | 075327 □ | 075326 □ |
| 1    | Exchange knife | 16x13,4x2   | HW  | 1,5 | 2   | 075325 □ | 075324 □ |
| 2    | Exchange knife | 12x13x2     | HW  | 3,0 | 2   | 075304 ● | 075304 ● |
| 1    | Exchange knife | 19,6x15,2x2 | HW  | 3,0 | 2   | 075303 ● | 075302 ● |



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools

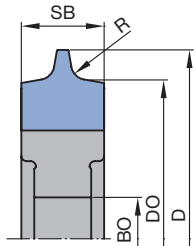


Type 4: WW 500 2 03

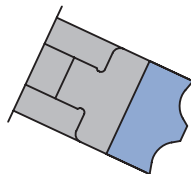
#### Profile knives for system Holz-Her

TM 435 0

| BEZ             | ABM<br>mm       | QAL | VE<br>PCS | DRI | ID              |
|-----------------|-----------------|-----|-----------|-----|-----------------|
| Turnblade knife | 30x12x1,5,PT1,3 | HW  | 2         | RH  | <b>005088 ●</b> |
| Turnblade knife | 30x12x1,5,PT1,3 | HW  | 2         | LH  | <b>005089 ●</b> |



Type 1

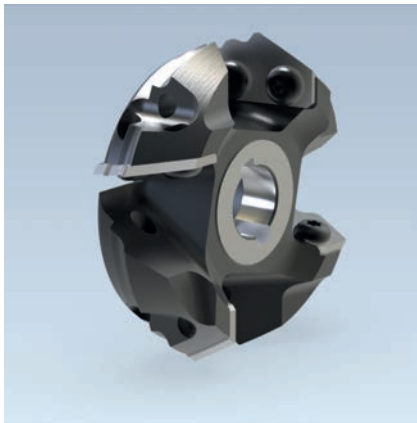


Type 2

#### Profile knives for system Ott

TM 135 0

| Type | BEZ            | ABM<br>mm | QAL | R<br>mm | VE<br>PCS | ID<br>LH        | ID<br>RH        |
|------|----------------|-----------|-----|---------|-----------|-----------------|-----------------|
| 1    | Exchange knife | 16x17,5x2 | HW  | 1,0     | 2         | <b>074540 □</b> | <b>074540 □</b> |
| 2    | Exchange knife | 16x17,5x2 | HW  | 1,5     | 2         | <b>009539 ●</b> | <b>009539 ●</b> |
| 1    | Exchange knife | 16x17,5x2 | HW  | 2,0     | 2         | <b>005132 ●</b> | <b>005132 ●</b> |
| 1    | Exchange knife | 16x18,5x2 | HW  | 2,5     | 2         | <b>074543 □</b> | <b>074543 □</b> |
| 2    | Exchange knife | 16x17,5x2 | HW  | 3,0     | 2         | <b>005133 ●</b> | <b>005133 ●</b> |
| 1    | Exchange knife | 16x19,5x2 | HW  | 3,5     | 2         | <b>074545 □</b> | <b>074545 □</b> |
| 2    | Exchange knife | 25x15x2   | HW  | 1,0     | 3         | <b>619194</b>   | <b>619194</b>   |
| 2    | Exchange knife | 25x15x2   | HW  | 2,0     | 3         | <b>619196 ●</b> | <b>619196 ●</b> |



### Multi-profile cutterhead / bevel cutterhead

#### Application:

For a choice of radii or bevels on edgebandings.

#### Machine:

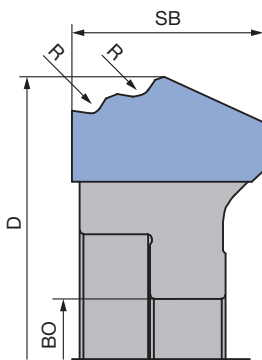
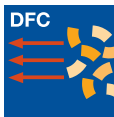
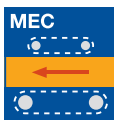
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

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



#### Various profiles - DFC, Homag

WE 500 2

| Machine | D<br>mm | SB<br>mm | BO<br>mm | Z | R<br>mm | FAW<br>° | ID<br>LH | ID<br>RH |
|---------|---------|----------|----------|---|---------|----------|----------|----------|
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1/2     |          | 075092 ● | 075093 ● |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3/2   |          | 075100 ● | 075101 ● |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1/3     |          | 075094 ● | 075095 ● |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 2/3     |          | 075112 □ | 075113 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1/1,5   |          | 075090 ● | 075091 ● |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,5/2   |          | 075106 □ | 075107 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,5/3   |          | 075108 □ | 075109 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1       | 15       | 075114 □ | 075115 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3/3   |          | 075102 □ | 075103 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 2       | 30       | 075130 □ | 075131 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 2       | 15       | 075120 □ | 075121 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1/1,3   |          | 075088 □ | 075089 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 2       | 45       | 075140 □ | 075141 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1       | 45       | 075134 □ | 075135 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3     | 45       | 075136 □ | 075137 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,5     | 45       | 075138 □ | 075139 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,5     | 30       | 075128 □ | 075129 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 2/2     |          | 075110 □ | 075111 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3/1,3 |          | 075096 □ | 075097 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,5/1,5 |          | 075104 □ | 075105 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1       | 30       | 075124 □ | 075125 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3/1,5 |          | 075098 □ | 075099 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1,3     | 30       | 075126 □ | 075127 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 3       | 30       | 075132 □ | 075133 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 3       | 45       | 075142 □ | 075143 □ |
| Homag   | 74,67   | 25,28    | 16 DKN   | 4 | 1/1     |          | 075086 □ | 075087 □ |

Further radii combinations available at short notice.

#### Spare knives:

| Part-<br>no. | BEZ            | ABM<br>mm    | QAL | R<br>mm | FAW<br>° | VE<br>PCS | ID<br>LH | ID<br>RH |
|--------------|----------------|--------------|-----|---------|----------|-----------|----------|----------|
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1/2     |          | 2         | 075706 ● | 075707 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,3/2   |          | 2         | 075714 ● | 075715 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1/3     |          | 2         | 075708 ● | 075709 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 2/3     |          | 2         | 075726 □ | 075727 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1/1,5   |          | 2         | 075704 ● | 075705 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,5/2   |          | 2         | 075720 □ | 075721 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,5/3   |          | 2         | 075722 □ | 075723 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1       | 15       | 2         | 075728 □ | 075729 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,3/3   |          | 2         | 075716 ● | 075717 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 2       | 30       | 2         | 075744 □ | 075745 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 2       | 15       | 2         | 075734 □ | 075735 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1/1,3   |          | 2         | 075702 ● | 075703 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 2       | 45       | 2         | 075754 ● | 075755 ● |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1       | 45       | 2         | 075748 ● | 075749 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,3     | 45       | 2         | 075750 □ | 075751 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,5     | 45       | 2         | 075752 □ | 075753 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,5     | 30       | 2         | 075742 □ | 075743 □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 2/2     |          | 2         | 075724 ● | 075725 ● |

● available ex stock

□ available at short notice

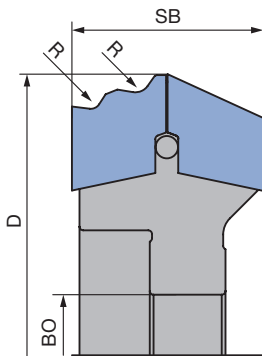
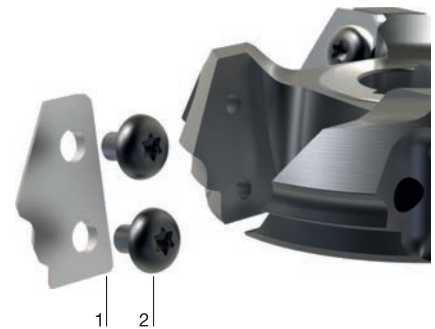
Instruction manual visit [www.leitz.org](http://www.leitz.org)

| Part-<br>no. | BEZ            | ABM<br>mm    | QAL | R<br>mm | FAW<br>° | VE<br>PCS | ID<br>LH        | ID<br>RH        |
|--------------|----------------|--------------|-----|---------|----------|-----------|-----------------|-----------------|
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,3/1,3 |          | 2         | <b>075710</b> □ | <b>075711</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,5/1,5 |          | 2         | <b>075718</b> □ | <b>075719</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1       | 30       | 2         | <b>075738</b> □ | <b>075739</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1,3/1,5 |          | 2         | <b>075712</b> □ | <b>075713</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1.3     | 30       | 2         | <b>075740</b> □ | <b>075741</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 3       | 30       | 2         | <b>075746</b> □ | <b>075747</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 3       | 45       | 2         | <b>075756</b> □ | <b>075757</b> □ |
| 1            | Exchange knife | 25.67x16.5x2 | HW  | 1/1     |          | 2         | <b>075700</b> □ | <b>075701</b> □ |

Further radii combinations available at short notice.

#### Spare parts:

| Part-no. | BEZ                      | ABM<br>mm | ID              |
|----------|--------------------------|-----------|-----------------|
| 2        | Oval head screw Torx® 15 | M4x6      | <b>006225</b> ● |
|          | Torx® key                | Torx® 15  | <b>005466</b> ● |



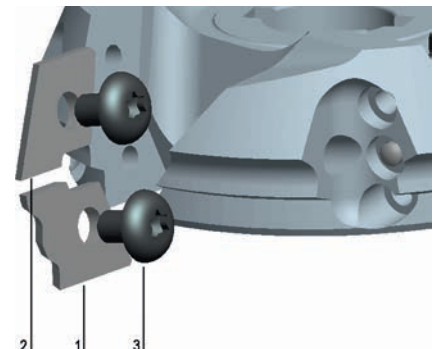
#### Spare knives - two-part knife design (until 03/2023)

TM 135 0

| Type | BEZ            | ABM<br>mm   | QAL | R<br>mm | FAW<br>° | VE<br>PCS | ID<br>LH        | ID<br>RH        |
|------|----------------|-------------|-----|---------|----------|-----------|-----------------|-----------------|
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1/1,5   |          | 2         | <b>075365</b> ● | <b>075366</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1/2     |          | 2         | <b>075347</b> ● | <b>075348</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1/3     |          | 2         | <b>075351</b> ● | <b>075352</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1,3/2   |          | 2         | <b>075349</b> ● | <b>075350</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1,3/3   |          | 2         | <b>075373</b> ● | <b>075374</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1,5/2   |          | 2         | <b>075367</b> ● | <b>075368</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1,5/3   |          | 2         | <b>075369</b> □ | <b>075370</b> □ |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 2/3     |          | 2         | <b>075353</b> ● | <b>075354</b> ● |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 1       | 15       | 2         | <b>075371</b> □ | <b>075372</b> □ |
| 1    | Exchange knife | 17,9x14,2x2 | HW  | 2       | 30       | 2         | <b>075201</b> □ | <b>075202</b> □ |
| 2    | Exchange knife | 18,1x13,5x2 | HW  |         |          | 2         | <b>075355</b> ● | <b>075356</b> ● |

#### Spare parts:

| Part-no. | BEZ                      | ABM<br>mm | ID              |
|----------|--------------------------|-----------|-----------------|
| 3        | Oval head screw Torx® 15 | M4x6      | <b>006225</b> ● |
|          | Torx® key                | Torx® 15  | <b>005466</b> ● |





### Profile scrapers

#### Application:

For scraping edgebandings with radii or bevels.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

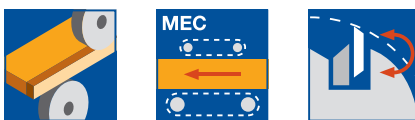
Plastic edgebandings.

#### Technical information:

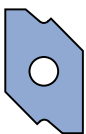
Bevel and radius scraper for scraper holder.

#### Profile scrapers

TM 130 0, TM 435 0



Type 1



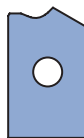
Type 3



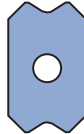
Type 5



Type 7



Type 2



Type 4



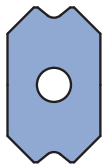
Type 6



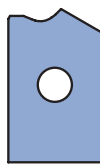
Type 8

| Machine        | SB<br>mm | H<br>mm | DIK<br>mm | R<br>mm | FAW<br>° | Type | QAL | VE<br>PCS | ID       | ID<br>left |
|----------------|----------|---------|-----------|---------|----------|------|-----|-----------|----------|------------|
| Biesse         | 12,7     | 12,7    | 3,18      | 1,0     |          | 1    | HW  | 2         | 074548 ● |            |
| Biesse         | 12,7     | 12,7    | 3,18      | 1,5     |          | 1    | HW  | 2         | 074549 ● |            |
| Biesse         | 12,7     | 12,7    | 3,18      | 2,0     |          | 1    | HW  | 2         | 074550 ● |            |
| Biesse         | 12,7     | 12,7    | 3,18      | 3,0     |          | 1    | HW  | 2         | 074551 □ |            |
| Fravol         | 12       | 20      | 2         | 1-3     |          | 2    | TDC | 2         | 074640 ● | 074639 ●   |
| Holz-Her       | 12       | 20      | 2         |         | 45       | 4    | HW  | 2         | 074037 ● |            |
| Holz-Her       | 12       | 20      | 2         | 1,0     |          | 4    | HW  | 2         | 074039 ● |            |
| Holz-Her       | 12       | 20      | 2         | 1,5     |          | 4    | HW  | 2         | 074074 ● |            |
| Holz-Her       | 12       | 20      | 2         | 2,0     |          | 4    | HW  | 2         | 074040 ● |            |
| Holz-Her       | 12       | 20      | 2         | 2,5     |          | 4    | HW  | 2         | 074075 □ |            |
| Holz-Her       | 12       | 20      | 2         | 3,0     |          | 4    | HW  | 2         | 074041 ● |            |
| Holz-Her ZK701 | 12       | 19      | 2         |         | 10       | 3    | HW  | 2         | 074576 □ | 074575 □   |
| Holz-Her ZK701 | 12       | 19      | 2         | 1,0     |          | 3    | HW  | 2         | 074562 □ | 074561 □   |
| Holz-Her ZK701 | 12       | 19      | 2         | 1,3     |          | 3    | HW  | 2         | 074564 □ | 074563 □   |
| Holz-Her ZK701 | 12       | 19      | 2         | 2,0     |          | 3    | HW  | 2         | 074568 □ | 074567 □   |
| Holz-Her ZK701 | 12       | 19      | 2         | 3,0     |          | 3    | HW  | 2         | 074572 □ | 074571 □   |
| Homag          | 12       | 20      | 2         |         | 45       | 4    | HW  | 2         | 074037 ● |            |
| Homag          | 12       | 20      | 2         | 1,0     |          | 4    | HW  | 2         | 074039 ● |            |
| Homag          | 12       | 20      | 2         | 1,5     |          | 4    | HW  | 2         | 074074 ● |            |
| Homag          | 12       | 20      | 2         | 2,0     |          | 4    | HW  | 2         | 074040 ● |            |
| Homag          | 12       | 20      | 2         | 2,5     |          | 4    | HW  | 2         | 074075 □ |            |
| Homag          | 12       | 20      | 2         | 3,0     |          | 4    | HW  | 2         | 074041 ● |            |
| Homag          | 12       | 20      | 2         |         | 45       | 5    | HW  | 2         | 073724 □ |            |
| Homag          | 12       | 20      | 2         | 1,0     |          | 5    | HW  | 2         | 073725 ● |            |
| Homag          | 12       | 20      | 2         | 1,5     |          | 5    | HW  | 2         | 073726 ● |            |
| Homag          | 12       | 20      | 2         | 2,0     |          | 5    | HW  | 2         | 073727 ● |            |
| Homag          | 12       | 20      | 2         | 2,5     |          | 5    | HW  | 2         | 073728 □ |            |
| Homag          | 12       | 20      | 2         | 3,0     |          | 5    | HW  | 2         | 073729 ● |            |
| Homag          | 20       | 11,5    | 2         | 1,0     |          | 6    | HW  | 2         | 073713 ● |            |
| Homag          | 20       | 11,5    | 2         | 1,5     |          | 6    | HW  | 2         | 073714 □ |            |
| Homag          | 20       | 11,5    | 2         | 2,0     |          | 6    | HW  | 2         | 073715 ● |            |
| Homag          | 20       | 11,5    | 2         | 3,0     |          | 6    | HW  | 2         | 073716 □ |            |
| IMA            | 12       | 20      | 2         |         | 45       | 4    | HW  | 2         | 074037 ● |            |
| IMA            | 12       | 20      | 2         | 1,0     |          | 7    | HW  | 2         | 074044 ● |            |
| IMA            | 12       | 20      | 2         | 1,5     |          | 7    | HW  | 2         | 074076 ● |            |
| IMA            | 12       | 20      | 2         | 2,0     |          | 7    | HW  | 2         | 074021 ● |            |
| IMA            | 12       | 20      | 2         | 2,5     |          | 7    | HW  | 2         | 074077 □ |            |
| IMA            | 12       | 20      | 2         | 3,0     |          | 7    | HW  | 2         | 074022 ● |            |
| Ott            | 12       | 13,3    | 3,3       | 1,0     |          | 8    | HW  | 2         | 074653 ● |            |
| Ott            | 12       | 13,3    | 3,3       | 2,0     |          | 8    | HW  | 2         | 074654 ● |            |
| SCM            | 12       | 20      | 2         | 2,0     |          | 4    | HW  | 2         | 074040 ● |            |
| Stefani        | 12,7     | 12,7    | 3,18      | 1,0     |          | 1    | HW  | 2         | 074548 ● |            |
| Stefani        | 12,7     | 12,7    | 3,18      | 1,5     |          | 1    | HW  | 2         | 074549 ● |            |
| Stefani        | 12,7     | 12,7    | 3,18      | 2,0     |          | 1    | HW  | 2         | 074550 ● |            |
| Stefani        | 12,7     | 12,7    | 3,18      | 3,0     |          | 1    | HW  | 2         | 074551 □ |            |

Additional scrapers available on request at short notice.



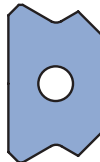
Type 1



Type 2



Type 3



Type 4

#### Technical information:

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

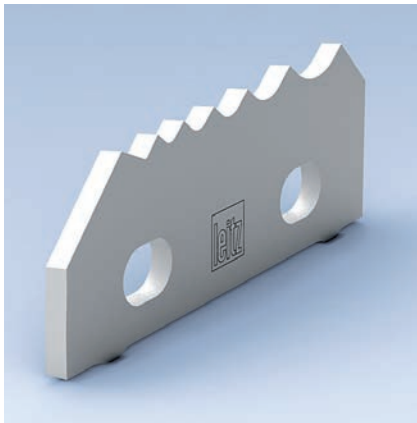
#### Profile scrapers with anti-stress whitening bevel

TM 435 0

| Machine  | SB<br>mm | H<br>mm | DIK<br>mm | R<br>mm | FAW<br>° | Type | QAL | VE<br>PCS | ID     | ID<br>left |
|----------|----------|---------|-----------|---------|----------|------|-----|-----------|--------|------------|
| Brandt   | 12       | 20      | 2         |         | 45       | 1    | HW  | 2         | 074103 | □          |
| Brandt   | 12       | 20      | 2         | 1,0     |          | 1    | HW  | 2         | 074095 | ●          |
| Brandt   | 12       | 20      | 2         | 1,3     |          | 1    | HW  | 2         | 074096 | ●          |
| Brandt   | 12       | 20      | 2         | 1,5     |          | 1    | HW  | 2         | 074097 | ●          |
| Brandt   | 12       | 20      | 2         | 2,0     |          | 1    | HW  | 2         | 074098 | ●          |
| Brandt   | 12       | 20      | 2         | 3,0     |          | 1    | HW  | 2         | 074100 | □          |
| EBM      | 12       | 20      | 2         |         | 45       | 1    | HW  | 2         | 074103 | □          |
| EBM      | 12       | 20      | 2         | 1,0     |          | 1    | HW  | 2         | 074095 | ●          |
| EBM      | 12       | 20      | 2         | 1,3     |          | 1    | HW  | 2         | 074096 | ●          |
| EBM      | 12       | 20      | 2         | 1,5     |          | 1    | HW  | 2         | 074097 | ●          |
| EBM      | 12       | 20      | 2         | 2,0     |          | 1    | HW  | 2         | 074098 | ●          |
| EBM      | 12       | 20      | 2         | 3,0     |          | 1    | HW  | 2         | 074100 | □          |
| Fravol   | 15,44    | 20      | 2         | 1-3     |          | 2    | TDC | 2         | 074642 | ● 074641 ● |
| Hebrock  | 12       | 20      | 2         | 1,0     |          | 1    | HW  | 2         | 074095 | ●          |
| Hebrock  | 12       | 20      | 2         | 1,3     |          | 1    | HW  | 2         | 074096 | ●          |
| Hebrock  | 12       | 20      | 2         | 1,5     |          | 1    | HW  | 2         | 074097 | ●          |
| Hebrock  | 12       | 20      | 2         | 2,0     |          | 1    | HW  | 2         | 074098 | ●          |
| Hebrock  | 12       | 20      | 2         | 3,0     |          | 1    | HW  | 2         | 074100 | □          |
| Holz-Her | 12       | 20      | 2         |         | 45       | 1    | HW  | 2         | 074103 | □          |
| Holz-Her | 12       | 20      | 2         | 1,0     |          | 1    | HW  | 2         | 074095 | ●          |
| Holz-Her | 12       | 20      | 2         | 1,3     |          | 1    | HW  | 2         | 074096 | ●          |
| Holz-Her | 12       | 20      | 2         | 1,5     |          | 1    | HW  | 2         | 074097 | ●          |
| Holz-Her | 12       | 20      | 2         | 2,0     |          | 1    | HW  | 2         | 074098 | ●          |
| Holz-Her | 12       | 20      | 2         | 3,0     |          | 1    | HW  | 2         | 074100 | □          |
| Homag    | 12       | 20      | 2         |         | 45       | 1    | HW  | 2         | 074103 | □          |
| Homag    | 12       | 20      | 2         | 1,0     |          | 1    | HW  | 2         | 074095 | ●          |
| Homag    | 12       | 20      | 2         | 1,3     |          | 1    | HW  | 2         | 074096 | ●          |
| Homag    | 12       | 20      | 2         | 1,5     |          | 1    | HW  | 2         | 074097 | ●          |
| Homag    | 12       | 20      | 2         | 2,0     |          | 1    | HW  | 2         | 074098 | ●          |
| Homag    | 12       | 20      | 2         | 3,0     |          | 1    | HW  | 2         | 074100 | □          |
| Homag    | 20       | 11,5    | 2         | 1,0     |          | 3    | HW  | 2         | 073719 | □          |
| Homag    | 20       | 11,5    | 2         | 1,5     |          | 3    | HW  | 2         | 073720 | □          |
| Homag    | 20       | 11,5    | 2         | 2,0     |          | 3    | HW  | 2         | 073721 | ●          |
| Homag    | 20       | 11,5    | 2         | 3,0     |          | 3    | HW  | 2         | 073723 | ●          |
| IMA      | 12       | 20      | 2         |         | 45       | 1    | HW  | 2         | 074103 | □          |
| IMA      | 12       | 20      | 2         | 1,0     |          | 4    | HW  | 2         | 074090 | ●          |
| IMA      | 12       | 20      | 2         | 1,3     |          | 4    | HW  | 2         | 074101 | □          |
| IMA      | 12       | 20      | 2         | 1,5     |          | 4    | HW  | 2         | 074091 | ●          |
| IMA      | 12       | 20      | 2         | 2,0     |          | 4    | HW  | 2         | 074092 | ●          |
| IMA      | 12       | 20      | 2         | 3,0     |          | 4    | HW  | 2         | 074094 | □          |

#### Spare parts:

| BEZ                      | ABM<br>mm | ID       |
|--------------------------|-----------|----------|
| Torx® key                | Torx® 15  | 005466 ● |
| Oval head screw Torx® 15 | M4x6      | 006225 ● |



### Multi-profile scrapers

#### Application:

For scraping edgebandings with radii or bevels.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic edgebandings.

#### Technical information:

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

#### Multi-profile scrapers

TM 135 0

| Machine | SB<br>mm | H<br>mm | DIK<br>mm | R<br>mm     | FAW<br>° | Type | QAL | VE<br>PCS | ID       | ID<br>left |
|---------|----------|---------|-----------|-------------|----------|------|-----|-----------|----------|------------|
| Biesse  | 34       | 12,7    | 3         | 1/2/3       | Fase     | 1    | HW  | 2         | 074082 ● |            |
| Brandt  | 13,5     | 13,38   | 2         | 1/3         |          | 2    | HW  | 2         | 075362 ● | 075361 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 1/2         |          | 2    | HW  | 2         | 075358 ● | 075357 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 1/1,5       |          | 2    | HW  | 2         | 075376 ● | 075375 □   |
| Brandt  | 13,5     | 13,38   | 2         | 1,3/3       |          | 2    | HW  | 2         | 075380 ● | 075379 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 1,3/2       |          | 2    | HW  | 2         | 075360 ● | 075359 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 1,5/2       |          | 2    | HW  | 2         | 075378 ● | 075377 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 2/3         |          | 2    | HW  | 2         | 075364 ● | 075363 ●   |
| Brandt  | 13,5     | 13,38   | 2         | 2           | 30       | 2    | HW  | 2         | 075398 □ | 075397 □   |
| Homag   | 13,5     | 13,38   | 2         | 1/3         |          | 2    | HW  | 2         | 075362 ● | 075361 ●   |
| Homag   | 13,5     | 13,38   | 2         | 1/2         |          | 2    | HW  | 2         | 075358 ● | 075357 ●   |
| Homag   | 13,5     | 13,38   | 2         | 1/1,5       |          | 2    | HW  | 2         | 075376 ● | 075375 □   |
| Homag   | 13,5     | 13,38   | 2         | 1,3/3       |          | 2    | HW  | 2         | 075380 ● | 075379 ●   |
| Homag   | 13,5     | 13,38   | 2         | 1,3/2       |          | 2    | HW  | 2         | 075360 ● | 075359 ●   |
| Homag   | 13,5     | 13,38   | 2         | 1,5/2       |          | 2    | HW  | 2         | 075378 ● | 075377 ●   |
| Homag   | 13,5     | 13,38   | 2         | 2/3         |          | 2    | HW  | 2         | 075364 ● | 075363 ●   |
| Homag   | 13,5     | 13,38   | 2         | 2           | 30       | 2    | HW  | 2         | 075398 □ | 075397 □   |
| Homag   | 45,8     | 17,95   | 2         | 1/1,5/2/3/5 | 20       | 3    | HW  | 2         | 074050 ● | 074049 ●   |
| IMA     | 24       | 20      | 2         | 1/1,5/2/3   |          | 4    | HW  | 2         | 074106 ● |            |
| IMA     | 24       | 20      | 2         | 1/2/3       |          | 4    | HW  | 2         | 074107 ● |            |
| Stefani | 34       | 12,7    | 3         | 1/2/3       | Fase     | 1    | HW  | 2         | 074080 □ |            |

#### Spare parts:

| BEZ                      | ABM<br>mm | ID       |
|--------------------------|-----------|----------|
| Torx® key                | Torx® 15  | 117507 ● |
| Oval head screw Torx® 15 | M4x6      | 006225 ● |

#### Technical information:

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

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

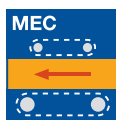
TM 135 0

| Machine | SB<br>mm | H<br>mm | DIK<br>mm | R<br>mm       | FAW<br>° | Type | QAL | VE<br>PCS | ID       | ID<br>left |
|---------|----------|---------|-----------|---------------|----------|------|-----|-----------|----------|------------|
| Homag   | 45,8     | 17,074  | 2         | 1/1,5/2/2,5/3 | 20       | 3    | HW  | 2         | 073105 ● | 073104 ●   |
| Homag   | 45,8     | 17,23   | 2         | 1/1,3/1,5/2/3 | 20       | 3    | HW  | 2         | 073107 ● | 073106 ●   |

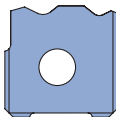
Further radii combinations with anti-stress whitening bevel available at short time.

#### Spare parts:

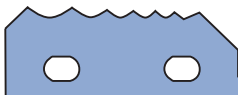
| BEZ                      | ABM<br>mm | ID       |
|--------------------------|-----------|----------|
| Torx® key                | Torx® 15  | 117507 ● |
| Oval head screw Torx® 15 | M4x6      | 006225 ● |



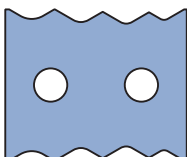
Type 1



Type 2



Type 3

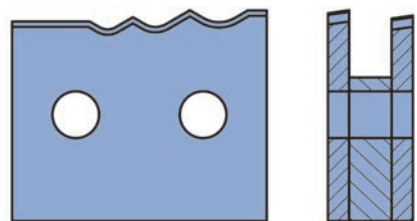
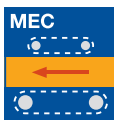


Type 4

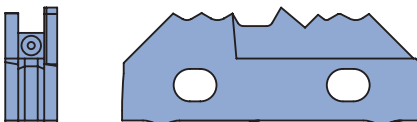
## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



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



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

### Multi-profile scrapers

#### Application:

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

#### Machine:

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

#### Workpiece material:

Plastic edgebander as PP, ABS, PMMA etc.

#### Technical information:

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

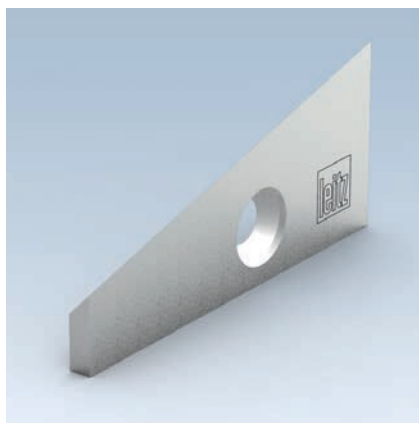
**Attention:** Only applicable on standard scraper aggregates with special profile scraper holders.

#### Duo multi-profile scraper

TM 135 0, TM 435 0

| Machine | SB<br>mm | H<br>mm | DIK<br>mm | R<br>mm                  | FAW<br>° | Type | QAL | ID       | ID<br>left |
|---------|----------|---------|-----------|--------------------------|----------|------|-----|----------|------------|
| Homag   | 45,8     | 19,94   | 8         | 1,3/2,0 (Duo)<br>0,6/1,5 | 5        | 2    | HW  | 073731 □ | 073730 □   |
| IMA     | 24       | 19,8    | 8         | 1/2/3                    | 45       | 1    | HW  | 074089 □ | 074088 □   |
| IMA     | 23,7     | 19,8    | 8         | 1,3/1,5/2                | 45       | 1    | HW  | 074085 □ | 074084 □   |

Further radii combinations available at short notice.



### Flat scrapers

#### Application:

For scraping edgebandings and glue.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic edgebandings.

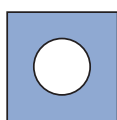
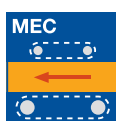
#### Technical information:

Different profile flat scrapers.

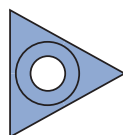
#### Flat scraper knives

TC 105 0, TM 135 0, TM 405 0, TM 440 0, TM 480 0

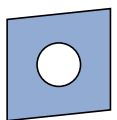
| Machine  | SB<br>mm | H<br>mm | DIK<br>mm | FAW<br>° | Type | QAL  | VE<br>PCS | ID       | ID<br>left |
|----------|----------|---------|-----------|----------|------|------|-----------|----------|------------|
| Biesse   | 16       | 16      | 4,7       |          | 1    | HW   | 2         | 074556   |            |
| Biesse   | 22,9     | 22,9    | 2,5       |          | 2    | HW   | 2         | 074555 ● |            |
| Brandt   | 15       | 14,3    | 2,5       | 6        | 3    | MC   | 2         | 074579 ● | 074578 ●   |
| Brandt   | 15       | 14,3    | 2,5       | 6        | 3    | HW   | 2         | 074501 ● | 074500 ●   |
| EBM      | 36       | 30      | 3         |          | 4    | HW   | 2         | 074635 ● | 074634 ●   |
| Fravol   | 20       | 12      | 1,5       |          | 5    | HW   | 2         | 074638 ● |            |
| Hebrock  | 36       | 30      | 3         |          | 4    | HW   | 2         | 074635 ● | 074634 ●   |
| Holz-Her | 14       | 14      | 2         |          | 1    | HW   | 2         | 009546 ● |            |
| Homag    | 14,3     | 14,3    | 2,5       |          | 1    | HW   | 10        | 005426 ● |            |
| Homag    | 15       | 14,3    | 2,5       | 6        | 3    | MC   | 2         | 074579 ● | 074578 ●   |
| Homag    | 15       | 14,3    | 2,5       | 6        | 3    | HW   | 2         | 074501 ● | 074500 ●   |
| Homag    | 32       | 55      | 4,5       | 15       | 6    | HW   | 2         | 074048 ● | 074047 ●   |
| IMA      | 14,3     | 14,3    | 2,5       |          | 1    | HW   | 2         | 074305 ● |            |
| IMA      | 55       | 25      | 3         | 15       | 7    | HW   | 2         | 074024 ● | 074023 ●   |
| IMA BAZ  | 11       | 14,3    | 2,5       |          | 5    | HW   | 2         | 074306   |            |
| Ott      | 15       | 14,3    | 2,5       | 6        | 3    | MC   | 2         | 074579 ● | 074578 ●   |
| Ott      | 15       | 14,3    | 2,5       | 6        | 3    | HW   | 2         | 074501 ● | 074500 ●   |
| SCM      | 14       | 14      | 2         |          | 1    | HW-F | 10        | 005099 ● |            |



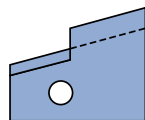
Type 1



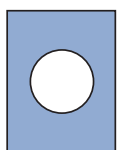
Type 2



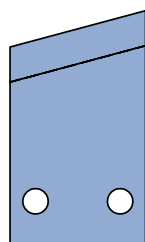
Type 3



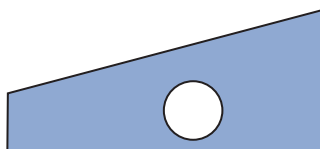
Type 4



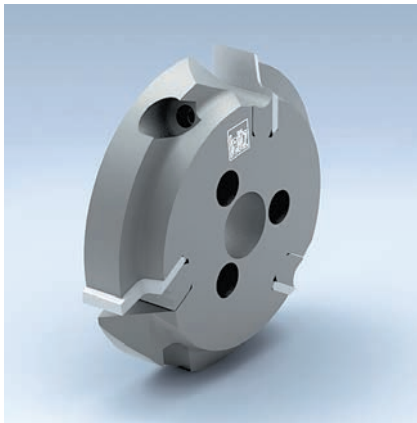
Type 5



Type 6



Type 7



### Profile cutterhead / bevel cutterhead for stationary machines

#### Application:

To round/bevel edgebandings.

#### Machine:

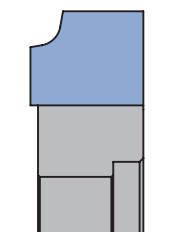
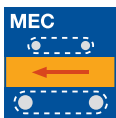
Homag BAZ.

#### Workpiece material:

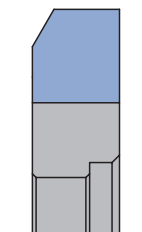
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

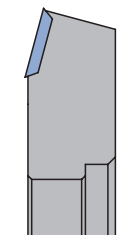
Cutterheads with HW knives for edge trimming cutter aggregate. Tool centering at recess diameter 19 mm. The same cutterhead tool body suitable for R 1.0 to 3.0 mm.  $D_0$  = constant reference diameter.



Type 1



Type 2



Type 3

#### Various radii / bevels - Homag

WE 500 2

| D  | D <sub>0</sub> | BO | NLA      | Z | QAL | R   | FAW | Type | n <sub>max</sub>  | ID       | ID       |
|----|----------------|----|----------|---|-----|-----|-----|------|-------------------|----------|----------|
| mm | mm             | mm | mm       |   |     | mm  | °   |      | min <sup>-1</sup> | LH       | RH       |
| 59 | 50             | 15 | 3/4,2/25 | 3 | HW  | 1,0 |     | 1    | 18000             | 073001 □ | 073000 □ |
| 59 | 50             | 15 | 3/4,2/25 | 3 | HW  | 1,5 |     | 1    | 18000             | 073003 □ | 073002 □ |
| 59 | 50             | 15 | 3/4,2/25 | 3 | HW  | 2,0 |     | 1    | 18000             | 073005 ● | 073004 ● |
| 59 | 50             | 15 | 3/4,2/25 | 3 | HW  | 3,0 |     | 1    | 18000             | 073009 □ | 073008 □ |
| 60 | 50             | 15 | 3/4,2/25 | 3 | HW  |     | 45  | 2    | 18000             | 073041   | 073040   |
| 62 | 50             | 15 | 3/4,2/25 | 3 | HW  |     | 15  | 3    | 18000             | 073101   | 073100   |

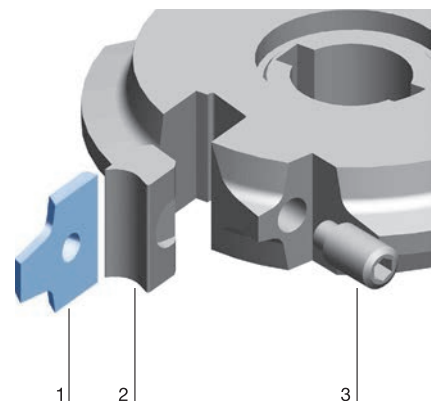
Type 3 for special thin edgebandings.

#### Spare knives:

| Part-no. | SB | H  | DIK | QAL  | R   | FAW | Type | VE  | ID       | ID       |
|----------|----|----|-----|------|-----|-----|------|-----|----------|----------|
|          | mm | mm | mm  |      | mm  | °   |      | PCS | LH       | RH       |
| 1        | 13 | 15 | 2   | HW   | 1,0 |     | 1    | 3   | 073501 ● | 073500 ● |
| 1        | 13 | 15 | 2   | HW   | 1,5 |     | 1    | 3   | 073503 ● | 073502 ● |
| 1        | 13 | 15 | 2   | HW   | 2,0 |     | 1    | 2   | 073505 ● | 073504 ● |
| 1        | 13 | 15 | 2   | HW   | 3,0 |     | 1    | 2   | 073509 ● | 073508 ● |
| 1        | 12 | 16 | 2   | HW   |     | 45  | 2    | 2   | 073541 ● | 073540 ● |
| 1        | 14 | 14 | 2   | HW-F |     |     | 3    | 10  | 005099 ● | 005099 ● |

#### Spare parts:

| Part-no. | BEZ                         | ABM         | ID       |
|----------|-----------------------------|-------------|----------|
|          |                             | mm          |          |
| 2        | Clamping wedge RH           | 11,5x14,4x7 | 073400 ● |
| 2        | Clamping wedge LH           | 11,5x14,4x7 | 073401 ● |
| 3        | Allen screw                 | M6x12       | 006035   |
| 3        | Countersink screw, Torx® 20 | M6x0.5x4.9  | 006243 ● |
|          | Torx® key                   | Torx® 20    | 006091 ● |
|          | Setting gauge for knives    | 43x12x6     | 005350 ● |



## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



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

**Application:**

To round/bevel edgebandings.

**Machine:**

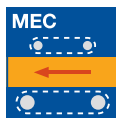
Homag BAZ.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

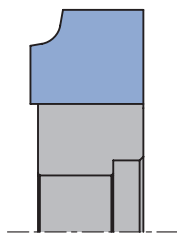
DP tipped tool with interface for edge trimming cutter aggregate. Tool centering at recess diameter 19 mm.  $D_0$  = constant reference diameter.



**Radii cutter DP - Homag**

WF 501 2 DP

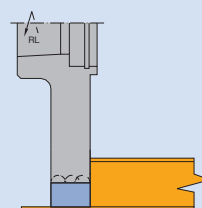
| D  | $D_0$ | BO | NLA      | Z | QAL | R   | $n_{\max}$        | ID              | ID              |
|----|-------|----|----------|---|-----|-----|-------------------|-----------------|-----------------|
| mm | mm    | mm | mm       |   |     | mm  | min <sup>-1</sup> | LH              | RH              |
| 57 | 50    | 15 | 3/4,2/25 | 3 | DP  | 2,0 | 18000             | <b>073103</b> □ | <b>073102</b> □ |
| 57 | 50    | 15 | 3/4,2/25 | 3 | DP  | 3,0 | 18000             | <b>091522</b> □ | <b>091523</b> □ |



Type 1

#### Rebating

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



#### Scoring

2

3

#### Hogging

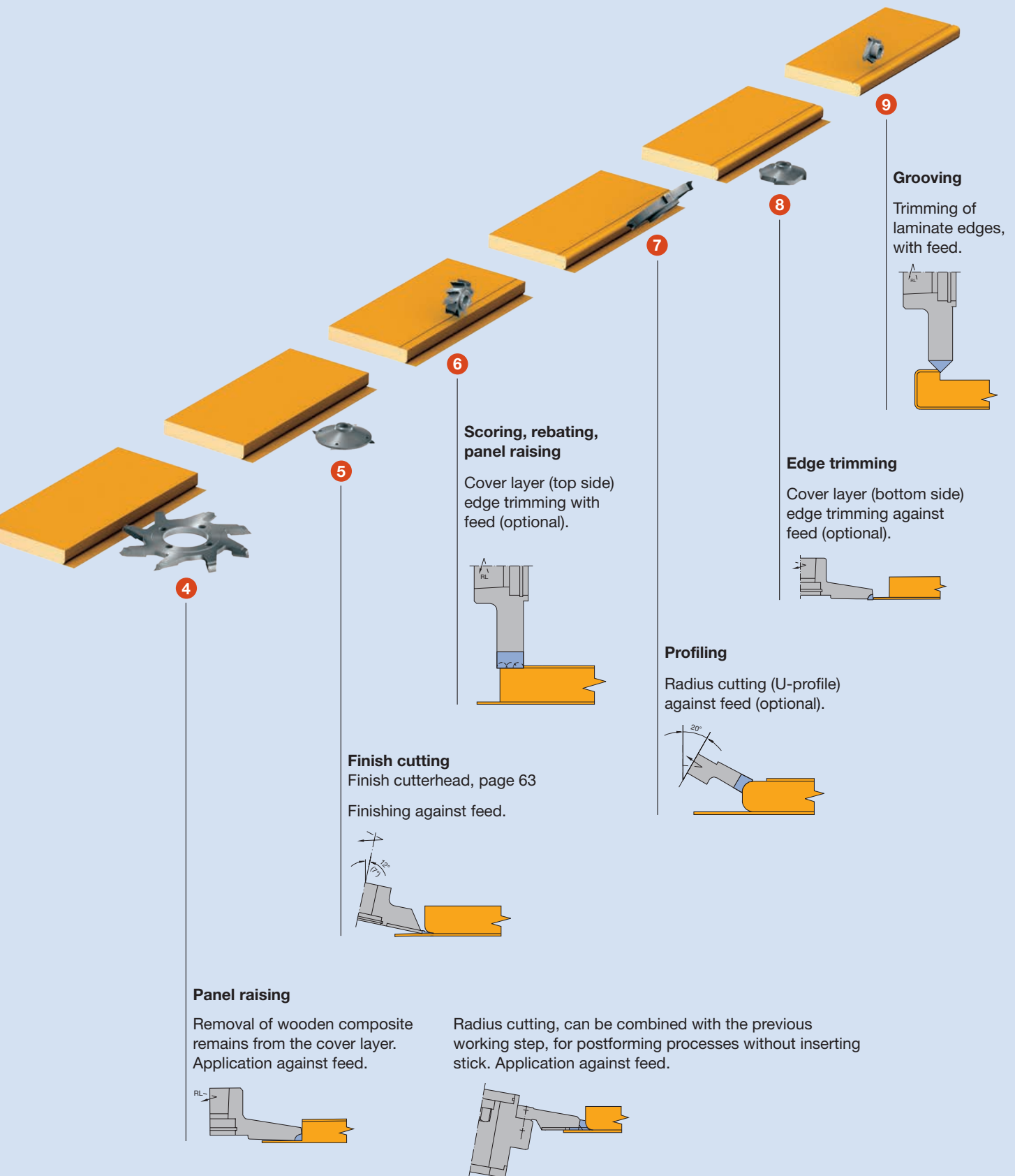
Compact hogger DT Premium, page 17  
Cutting and segment hogger, page 19

1

1

2

1



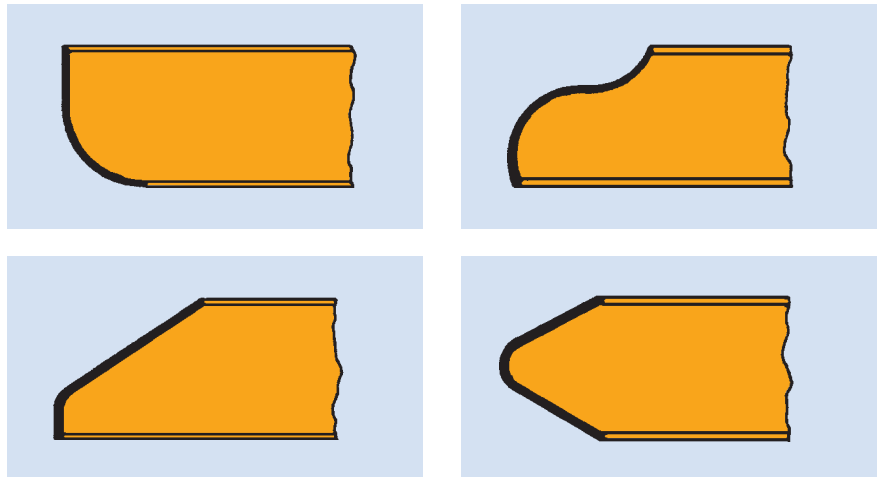
## 2. Panel processing

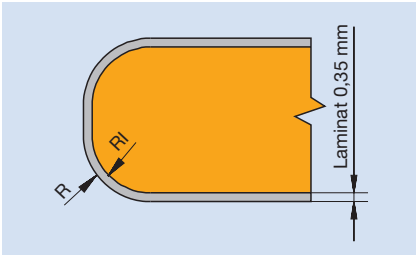
### 2.2 Postforming processing

#### 2.2.2 Postforming tools

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

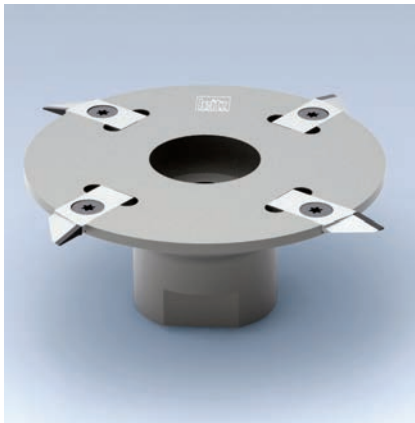
#### Profile examples



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

## 2. Panel processing

### 2.2 Postforming processing 2.2.2 Postforming tools



#### Finishing cutterhead

##### Application:

To finish cut the radius of postforming profiles.

##### Machine:

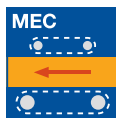
Postforming machines.

##### Workpiece material:

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

##### Technical information:

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

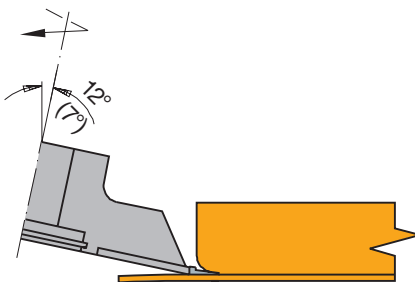


#### Spare knives for finishing cutterheads

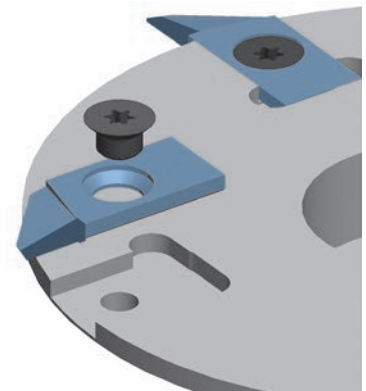
TM 160 0

| BEZ   | ABM<br>mm            | QAL | ID<br>LH | ID<br>RH |
|-------|----------------------|-----|----------|----------|
| Knife | 12x31x2,5x0,5, SB2,5 | DP  | 008208 • | 008204 • |

Spare knives for 7° and 12° inclined spindles.



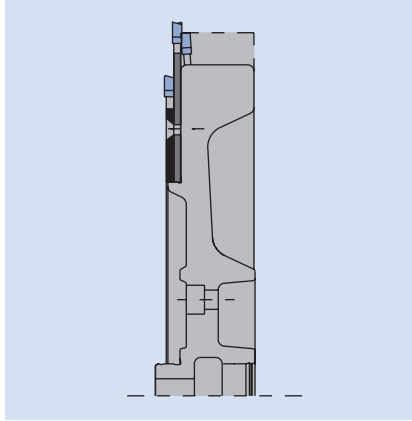
Finish cutting radii up to R 14 mm at 7° and 12° spindle angle



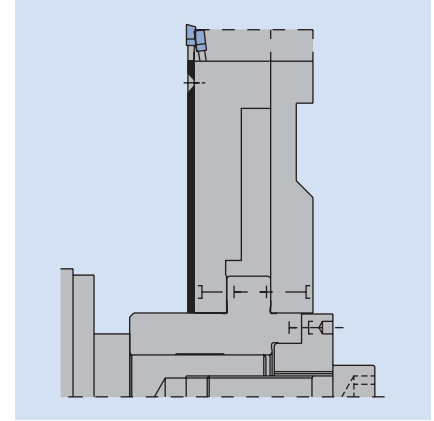
##### Segment hogger

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

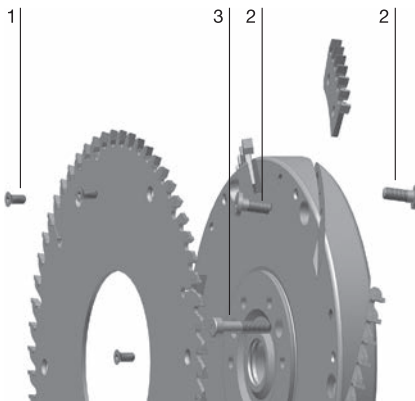
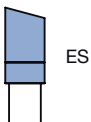
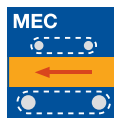
##### Designs



Toolset for finish-production unit with sizing and finish cut



Toolset for sizing unit mounted on flanged sleeve



### Segment hogger for sizing unit

#### Application:

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

#### Machine:

Sizing station in production lines.

#### Workpiece material:

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

#### Technical information:

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

#### Hogger for sizing unit

SZ 300 2, SZ 301 2

| Machine     | D   | SB   | BO     | Z/ZF <sub>Sawblade</sub> | QAL | ID       | ID       |
|-------------|-----|------|--------|--------------------------|-----|----------|----------|
|             | mm  | mm   | mm     |                          |     | LH       | RH       |
| Siempelkamp | 305 | 60,1 | 30     | 60/ES                    | HW  | 064700 □ | 064701 □ |
| Siempelkamp | 355 | 60,5 | 40 DKN | 72/ES                    | HW  | 064702   | 064703   |

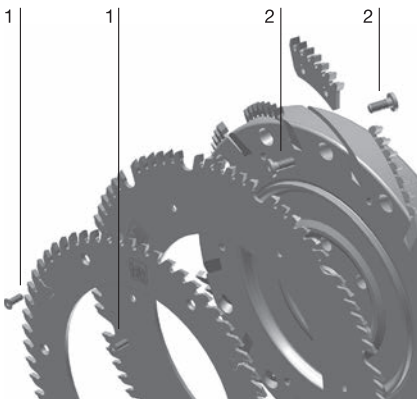
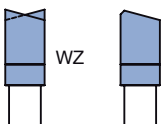
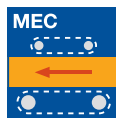
#### Spare parts:

| Part-<br>no. | BEZ                            | ABM<br>mm   | Z    | ZF | QAL | BEM                           | ID       |
|--------------|--------------------------------|-------------|------|----|-----|-------------------------------|----------|
|              | Basic hogger                   | 300x28,0x30 | 6x7  | FZ | HW  |                               | 064440 ● |
|              | Basic hogger                   | 300x28,0x30 | 6x7  | FZ | HW  |                               | 064441 ● |
|              | Basic hogger                   | 350x36,5x80 | 6x10 | FZ | HW  |                               | 064442   |
|              | Basic hogger                   | 350x36,5x80 | 6x10 | FZ | HW  |                               | 064443   |
|              | Extension cutter               | 300x28,0x30 | 6x7  | FZ | HW  |                               | 064444 ● |
|              | Extension cutter               | 300x28,0x30 | 6x7  | FZ | HW  |                               | 064445 ● |
|              | Extension cutter               | 350x20,2x80 | 6x10 | FZ | HW  |                               | 064446   |
|              | Extension cutter               | 350x20,2x80 | 6x10 | FZ | HW  |                               | 064447   |
|              | Hogging segment                | D 300/340   | 7    | FZ | HW  |                               | 064970 ● |
|              | Hogging segment                | D 300/340   | 7    | FZ | HW  |                               | 064971 ● |
|              | Hogging segment                | D 350       | 10   | FZ | HW  |                               | 064962 ● |
|              | Hogging segment                | D 350       | 10   | FZ | HW  |                               | 064963 ● |
| 1            | Countersink<br>screw, Torx® 20 | M6x12       |      |    |     | Torx® 20                      | 006084 ● |
| 2            | Screw with ISK                 | M8x17       |      |    |     | for D = 250, 350,<br>305, 355 | 006237 ● |
| 3            | Cylindrical screw<br>with ISK  | M8x60       |      |    |     | for D = 305                   | 005878 ● |
| 3            | Cylindrical screw<br>with ISK  | M8x35       |      |    |     | for D = 305, 350              | 005874 ● |
| 3            | Cylindrical screw<br>with ISK  | M8x25       |      |    |     | for D = 355                   | 005947 ● |

#### Hogging sawblade

WK 801 2

| D   | SB  | BO  | Z  | ZF | QAL | ID       | ID       |
|-----|-----|-----|----|----|-----|----------|----------|
| mm  | mm  | mm  |    |    |     | LH       | RH       |
| 305 | 4,4 | 120 | 60 | ES | HW  | 061844 ● | 061845 ● |
| 355 | 4,4 | 80  | 72 | ES | HW  | 061846 ● | 061847 ● |



### Segment hogger for splitting unit

#### Application:

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

#### Machine:

Sizing station in production lines.

#### Workpiece material:

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

#### Technical information:

Cut edge quality of the trim and finish cuts is defined by the sawblades. Set assembled with finish cut, trim sawblade and twelve tungsten carbide tipped segments. Staggered cut by twelve hogging segment. The hogger is mounted directly on the motor spindle without flanged sleeve.

#### Hogger for splitting unit

SZ 300 2

| Machine          | D<br>mm | SB<br>mm | BO<br>mm | Z/ZF <sub>Sawblade</sub> | QAL | ID<br>LH      | ID<br>RH      |
|------------------|---------|----------|----------|--------------------------|-----|---------------|---------------|
| Siempel-<br>kamp | 350     | 42,1     | 30       | 60 ES/FA<br>72 WZ        | HW  | <b>064704</b> | <b>064705</b> |

#### Spare parts:

| Part-<br>no. | BEZ                            | ABM<br>mm   | Z    | ZF | QAL | BEM              | ID              |
|--------------|--------------------------------|-------------|------|----|-----|------------------|-----------------|
|              | Basic hogger                   | 340x34,5x30 | 12x7 | FZ | HW  |                  | <b>064448</b>   |
|              | Basic hogger                   | 340x34,5x30 | 12x7 | FZ | HW  |                  | <b>064449</b>   |
|              | Hogging segment                | D 300/340   | 7    | FZ | HW  |                  | <b>064970 •</b> |
|              | Hogging segment                | D 300/340   | 7    | FZ | HW  |                  | <b>064971 •</b> |
| 1            | Countersink screw,<br>Torx® 20 | M6x16       |      |    |     | Torx® 20         | <b>006086 •</b> |
| 2            | Cylindrical screw with<br>ISK  | M8x35       |      |    |     | for D = 305, 350 | <b>005874 •</b> |

#### Hogging sawblade

WK 802 2, WK 850 2

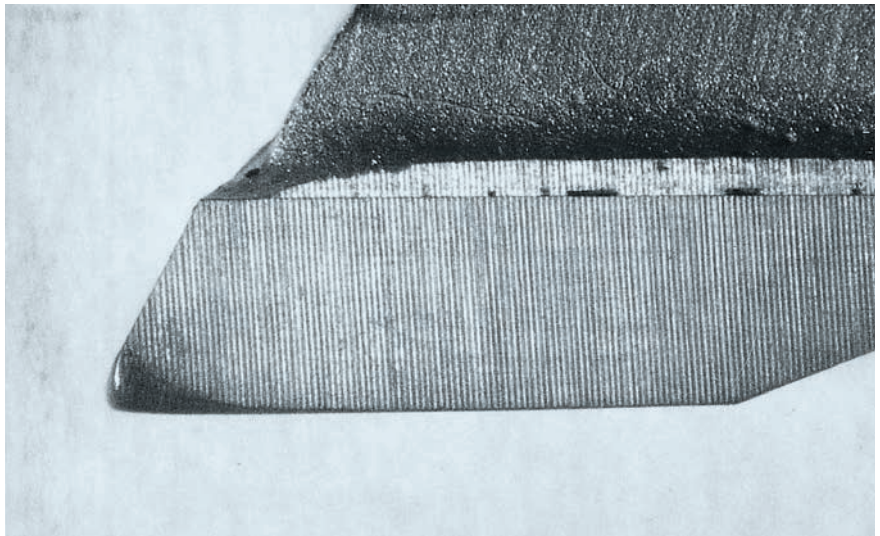
| D<br>mm | SB<br>mm | BO<br>mm | Z  | ZF    | QAL | ID<br>LH        | ID<br>RH        |
|---------|----------|----------|----|-------|-----|-----------------|-----------------|
| 300     | 4,4      | 200      | 60 | ES/FA | HW  | <b>061848 •</b> | <b>061849 •</b> |
| 350     | 4,4      | 200      | 72 | WZ    | HW  | <b>061850 •</b> | <b>061850 •</b> |

| Problem                                                    | Possible cause                                                                                            | Action                                                                                                          |
|------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------|
| <b>Break outs at the edge of the workpiece top edge</b>    | - Incorrect height adjustment of hogging motor and tilt in feed direction                                 | Correct setting<br>Check position of tools in feed direction, adjust standard value of 0.1 mm to the panel edge |
|                                                            | - Too much axial play in spindle bearing or damaged bearing                                               | Check motor bearings and tolerances                                                                             |
|                                                            | - Track vibrates due to low chain tension and damaged guides                                              | Check the chain tension, replace damaged parts                                                                  |
|                                                            | - Incorrect top pressure adjustment                                                                       | Check top pressure                                                                                              |
|                                                            | - Run out tolerance too high, possible tool imbalance                                                     | Measure tool, correct and check for imbalance                                                                   |
|                                                            | - Insufficient number of teeth, feed rate too high                                                        | Increase number of teeth or adjust feed speed                                                                   |
| <b>Break outs at the edge of the workpiece bottom edge</b> | - Workpiece projection too large or thin workpieces                                                       | Provide additional support in the tool area                                                                     |
|                                                            | - Incorrect adjustment in feed direction of scoring or hogging tool                                       | Produce trial sample and adjust motors                                                                          |
|                                                            | - Scoring sawblade not adjusted to the accuracy required in feed direction or hogging tool tilted too far | Check angles of scoring sawblade and hogging tool in feed direction                                             |
| <b>Tooth pattern at workpiece edge wavy surface</b>        | - Tool position setting angle is too high                                                                 | Correct the tool setting angle                                                                                  |
|                                                            | - Transport of workpiece not consistent during through feed                                               | Check chain and drive                                                                                           |
|                                                            | - Inconstant workpiece feed rate                                                                          | Increase number of teeth or adjust feed speed                                                                   |
|                                                            | - Run out tolerance too high, possible imbalanced tool                                                    | Measure tool, correct and check for imbalance                                                                   |
| <b>Surface of middle layer rough, uneven (with steps)</b>  | - Tool worn, blunt                                                                                        | Repair and service the tool                                                                                     |
|                                                            | - Insufficient number of teeth, feed speed too high                                                       | Increase number of teeth, adjust feed speed                                                                     |
|                                                            | - Adjustment of top and bottom tools (scoring/hogging tool) not level with feed direction                 | Produce trial sample and adjust motors                                                                          |
|                                                            | - Adjustment of hogging tool not at correct angle to the track                                            | Check angle with dial gauge on the horizontal moving spindle                                                    |
|                                                            | - Incorrect tooth shape of tool and angle geometry                                                        | Check and correct                                                                                               |
|                                                            | - Insufficient middle layer quality of the workpiece                                                      | Improve by removing resin and sharpening more frequently                                                        |
| <b>Break outs at edge of workpiece end grain, front</b>    | - Adjustment of jump head to the hogging tool not level with feed direction                               | Produce trial sample and adjust motors                                                                          |
| <b>Break outs at edge of workpiece end grain, back</b>     | - Adjustment of the controlled scoring motor not level with the hogging unit in feed direction            | Check movement of the jump scoring motor and correct adjustment to the hogging unit                             |
|                                                            | - Poor quality of middle layer of workpiece material (large chip flow, poor pressing)                     | Improve by removing resin and sharpening tools more often                                                       |
|                                                            | - Insufficient number of teeth, feed speed too high                                                       | Increase number of teeth or adjust feed speed                                                                   |
|                                                            | - Incorrect tooth shape and angle geometry                                                                | Check and adjust through resharpener                                                                            |

### Rounding of the cutting edge

When hogging solid wood and wood-derived materials with or without coating, the teeth of the hogging sawblade and hogger parts are subject to mechanical and chemical wear.

The surface quality determines the size of the cutting edge abrasion. An extremely worn sawblade tooth requires additional sharpening and reduces the number of possible resharpenings.



Typical cutting edge wear when machining solid wood.

### Cutting edge destruction through improper use

If the relationship between the number of teeth and feed speed is incorrect, the cutting forces will be too high when hogging solid wood, especially with a high moisture content. This leads to choking the gullet and consequently destruction of the saw tooth.

#### Action:

Reduce the number of teeth to increase the gullet area; adjust feed speed so the cutting quality is still adequate.



Cutting edge destruction through improper use.

### Cutting edge destruction through overstress

If the material to be removed is wider than the cutting width of the hogger, the outside teeth of the raised hogger segments are destroyed by overstress.

The hogging width must always be smaller than the cutting width of the hogging tool.



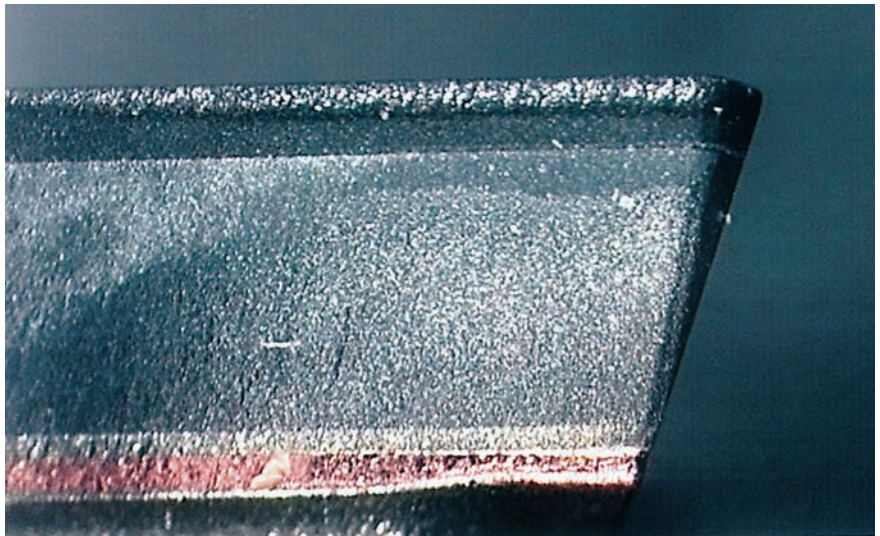
Destruction of saw tooth through overstress.

### Rounding of cutting edges

The illustration opposite shows a typical blunt cutting edge, resulting from mechanical abrasion when machining uniform materials.

Removing the resin from the sides of the teeth between resharpening intervals leads to a considerably longer performance time, as it prevents the loss of side relief.

The area of wear should be approx. 0.2 to max. 0.3 mm.

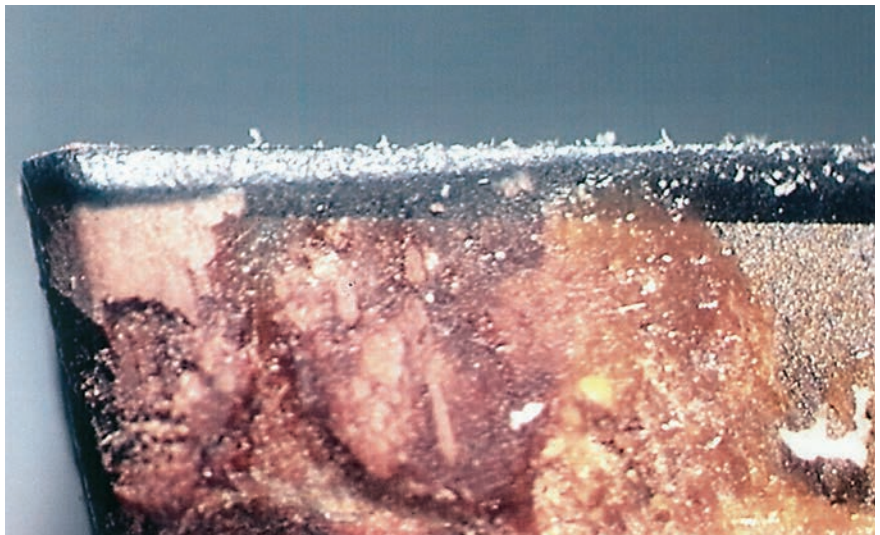


Wear to cutting edges after machining MDF.

### Cutting edge rounding and resin build up

Apart from cutting edge wear, a build-up also forms at the side of the teeth from adhesive dust and chip particles (resin build-up) when the workpiece material has a high resin content or the tool has been run for a long time.

This leads to higher cutting forces and power consumption, low surface and middle layer quality and a considerably reduced tool life.

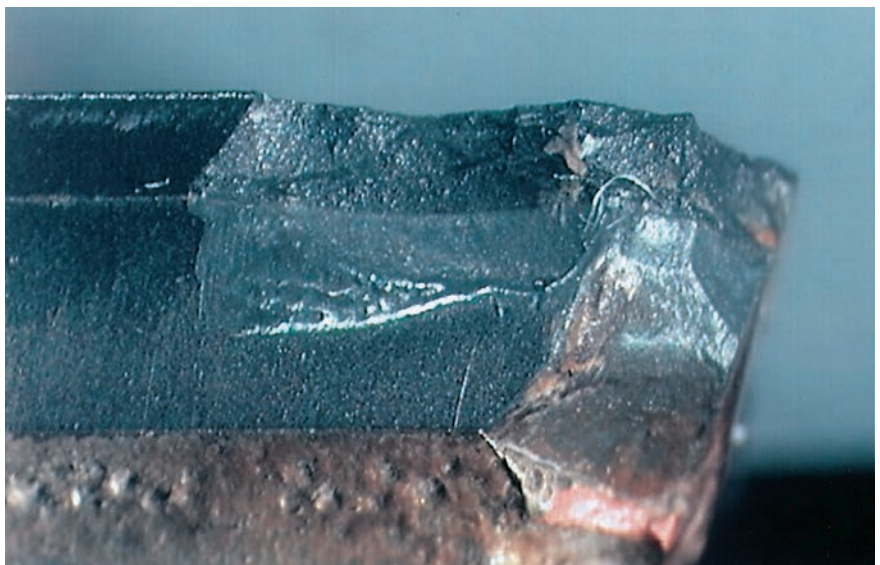


Wear to cutting edges and resin build-up after machining chipboard.

### Cutting edge destruction

The cutting edges can be destroyed when machining workpiece materials with a high sand content, a grain size up to 2 - 3 mm diameter (l) or containing metallic particles.

Using DP (DIA) tools when machining such workpiece materials is problematic and use is not recommended for efficient machining.



Cutting edge destruction from metallic particles.

## Enquiry/order form special tools – panel processing



**Customer details:** Customer number:   
(if known)

☐ Enquiry  
☐ Order

Delivery date: (not binding)  CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Workpiece material:

Type:

Moisture content (of solid wood) %

Direction of machining

☐ along grain ☐ across grain

Cutting quality:

☐ Pre-hogging

Coating:

☐ Yes

☐ No

Type (of wood derived material):

Hogging width: mm

Material thickness: mm

☐ Finish hogging

### Machine:

Manufacturer:

Type:

Model:

Power: kW (HP) motor spindle (see drawing):

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

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

Hogging motor:

☐ Against feed

☐ With feed

☐ Application scoring/hogging

☐ Application hogging/hogging

### Tool:

Tool type (see selection):

☐ Hogging set in cutter design

☐ Hogging set with segments

☐ Compact hogging set

☐ Other

Dimensions:

Diameter mm

Cutting width mm

Bore mm

Adaptor:

☐ Mechanical

☐ Quick change

☐ Hydraulic

No. of teeth:

Hogging sawblade

Hogger

Cutting material:

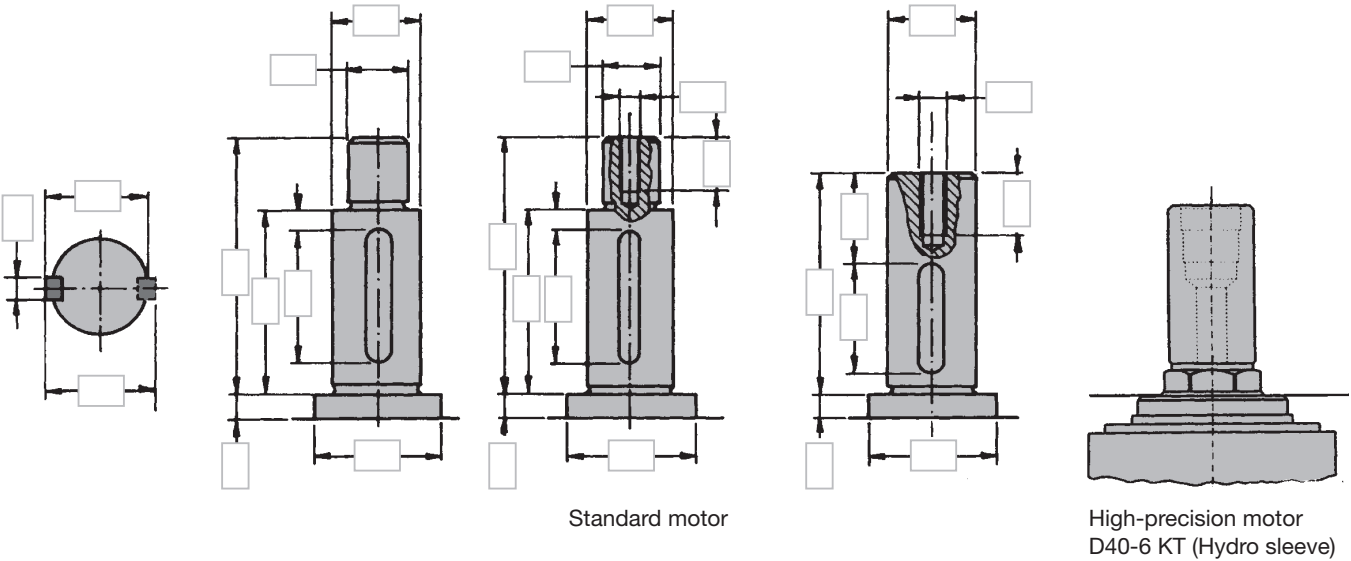
☐ HW (TC)

☐ DP (DIA)

Please state existing data on tool, machine and workpiece material.

**Hogging motor/spindle details:**

(Enter dimensions on drawing or state in space for sketches)



**Sketch for application plan, motor spindle etc.**



Scoring  
hogging



Tipped tool



Hogging



Light alloy  
body



Double  
hogging



Interchangeable  
knives



End  
trimming



Mechanical  
knife clamping,  
reversible



Edge  
trimming



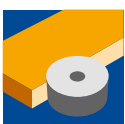
Resharpenable  
cutting face



Grooving,  
horizontal  
and vertical



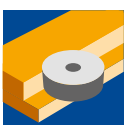
Resharpenable  
clearance face



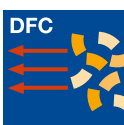
Jointing



Low noise



Rebating



Optimised  
chip flow



Profiling



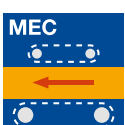
Tungsten  
carbide



Profiling  
joints



Polycrystalline  
diamond (PCD)



Mechanical  
feed

