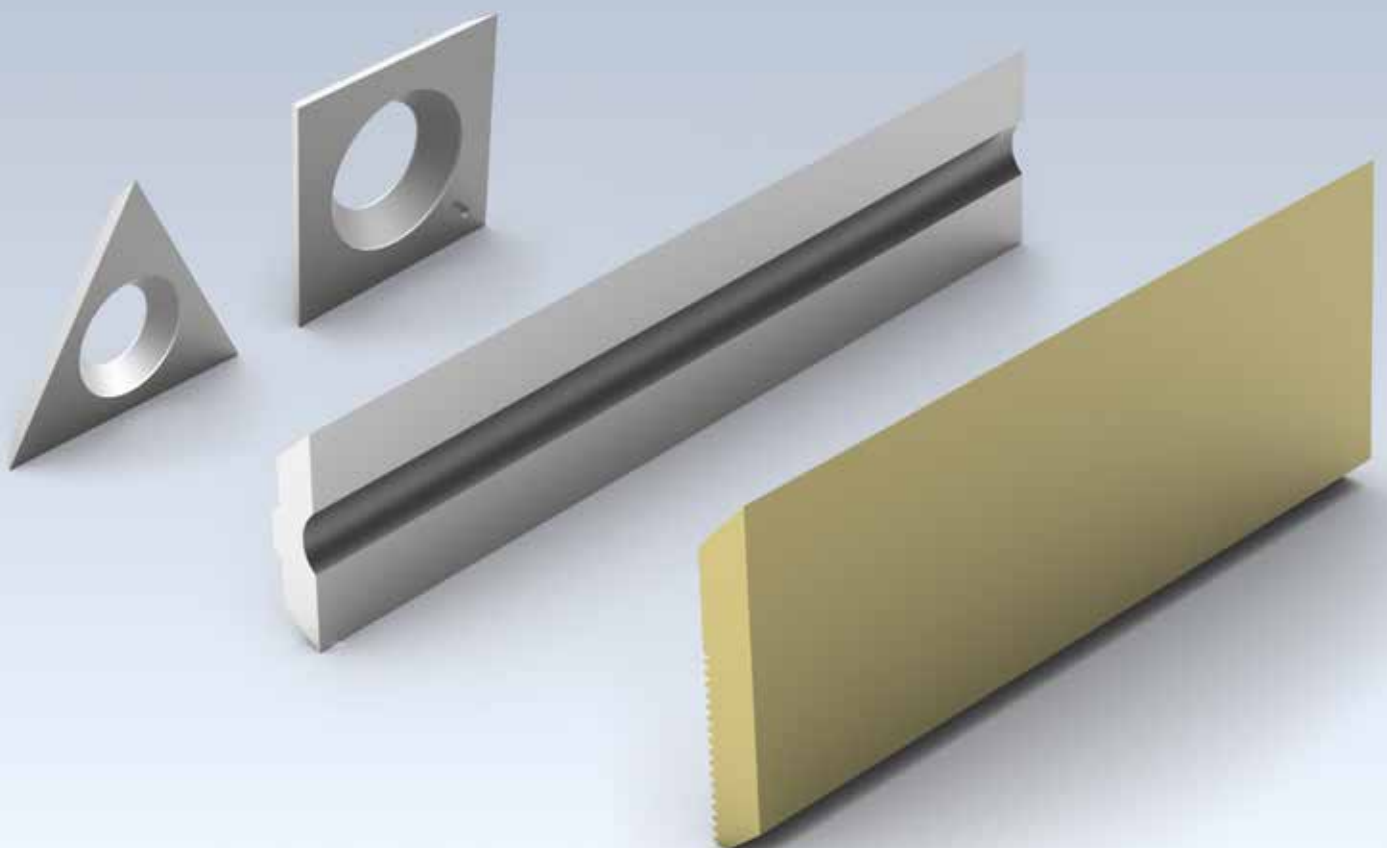


# Knives and spare parts

Leitz Lexicon Edition 7

Version 2

01/2025



## 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 |
|----|--------------------------------------|

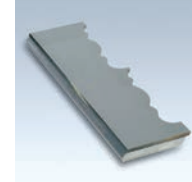
|       |                    |
|-------|--------------------|
| V     | = number of spurs  |
| $v_c$ | = cutting speed    |
| $v_f$ | = feed speed       |
| VE    | = packing unit     |
| VSB   | = adjustment range |

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

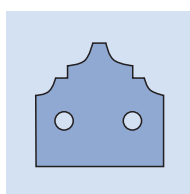
|    |                                    |
|----|------------------------------------|
| Z  | = number of teeth                  |
| ZA | = number of fingers                |
| ZF | = tooth shape (cutting edge shape) |
| ZL | = finger length                    |

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

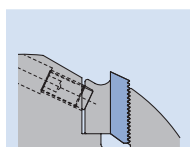
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



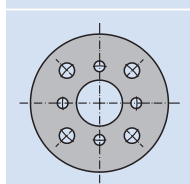
## 8. Knives and spare parts



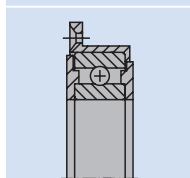
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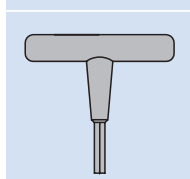
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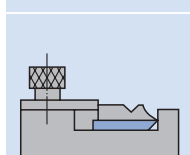
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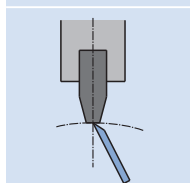
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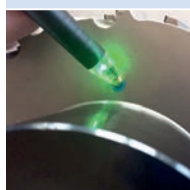
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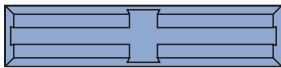
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|----------|----|

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



Turnblade knife for router cutter WL 100 1

##### Workpiece material:

Softwood and hardwood

##### Cutting material:

HW

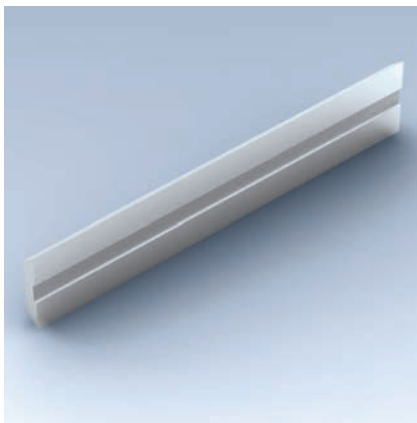
#### Knife height up to 5.5 mm

##### HW-05

TM 410 0

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ      | QAL   | VE<br>PCS | ID       |
|----------|---------|-----------|----------|-------|-----------|----------|
| 20       | 4,1     | 1,1       | WL 100-1 | HW-05 | 10        | 005186 ● |
| 20       | 5,5     | 1,1       | WL 100-1 | HW-05 | 10        | 005187 ● |
| 25       | 5,5     | 1,1       | WL 100-1 | HW-05 | 10        | 005188 ● |
| 30       | 5,5     | 1,1       | WL 100-1 | HW-05 | 10        | 005189 ● |
| 40       | 5,5     | 1,1       | WL 100-1 | HW-05 | 10        | 005190 ● |
| 50       | 5,5     | 1,1       | WL 100-1 | HW-05 | 10        | 005191 ● |

ID = 1 piece.



#### Knife height 8 mm

##### HW-30F / HW-05

TM 410 0

| SB<br>mm | H<br>mm | DIK<br>mm | VE<br>PCS | ID<br>HW-05 | ID<br>HW-30F |
|----------|---------|-----------|-----------|-------------|--------------|
| 7,7      | 8       | 1,5       | 10        | 005053 ●    | 005068 ●     |
| 9,7      | 8       | 1,5       | 10        | 005054 ●    | 005197 ●     |
| 11,7     | 8       | 1,5       | 10        | 005055 ●    | 005069 ●     |
| 14,7     | 8       | 1,5       | 10        | 005056 ●    | 005070 ●     |
| 19,7     | 8       | 1,5       | 10        | 005057 ●    | 005071 ●     |
| 25       | 8       | 1,5       | 10        | 005058 ●    | 005198 ●     |
| 30       | 8       | 1,5       | 10        | 005059 ●    | 005072 ●     |
| 35       | 8       | 1,5       | 10        | 005400 ●    | 005073 ●     |
| 40       | 8       | 1,5       | 10        | 005401 ●    | 005074 ●     |
| 45       | 8       | 1,5       |           | 007681 ●    | 007679 □     |
| 50       | 8       | 1,5       | 10        | 005402 ●    | 005075 ●     |
| 60       | 8       | 1,5       | 10        | 005403 ●    | 005076 ●     |
| 70       | 8       | 1,5       |           | 007682 ●    | 007680 □     |
| 80       | 8       | 1,5       | 10        |             | 005077 ●     |
| 80       | 8       | 1,5       |           | 005404 ●    |              |
| 100      | 8       | 1,5       |           | 005405 ●    | 005184 ●     |
| 120      | 8       | 1,5       |           | 005406 ●    | 005185 ●     |

ID = 1 piece.



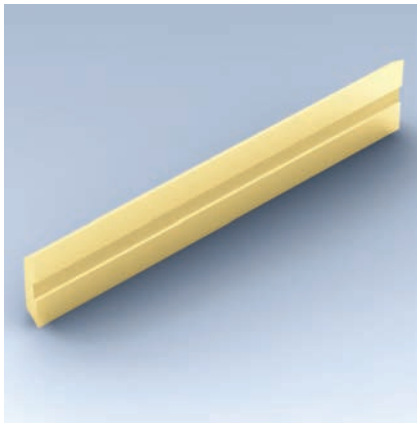
Turnblade knife HW

| Cutting material recommendation    | HW-30F | HW-05 |
|------------------------------------|--------|-------|
| Softwood                           | ◆      | ◇     |
| Hardwood                           | ◇      | ◆     |
| Glulam                             | ◇      | ◆     |
| Chipboard                          | ◇      | ◆     |
| MDF                                | ◇      | ◆     |
| Thermoplastics (PE, PP, PVC, etc.) | ◇      | ◆     |

◆ suitable ◇ partly suitable

##### Cutting material:

HW fine grain quality/ HW



Turnblade knife HW

| Cutting material recommendation    | HW-30F MC | HW-30F MC Micro |
|------------------------------------|-----------|-----------------|
| Softwood                           | ◆         | ◆               |
| Hardwood                           | ◇         | ◆               |
| Glulam                             | ◇         | ◇               |
| Chipboard                          |           |                 |
| MDF                                |           |                 |
| Thermoplastics (PE, PP, PVC, etc.) | ◇         | ◇               |
|                                    | HW-05 MC  | TDC             |
| Softwood                           | ◇         | ◇               |
| Hardwood                           | ◆         | ◇               |
| Glulam                             | ◆         | ◆               |
| Chipboard                          | ◆         | ◆               |
| MDF                                | ◆         | ◆               |
| Thermoplastics (PE, PP, PVC, etc.) | ◆         | ◆               |

◆ suitable ◇ partly suitable

#### Coating:

Marathon MC (Multi Coating) / Marathon TDC (Tungsten Diamond Coating)

#### Attention:

HW-30F MC cutting edges with micro-finish for high demands on finish quality and cutting performance

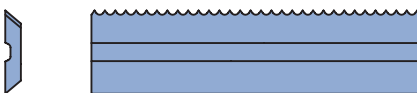
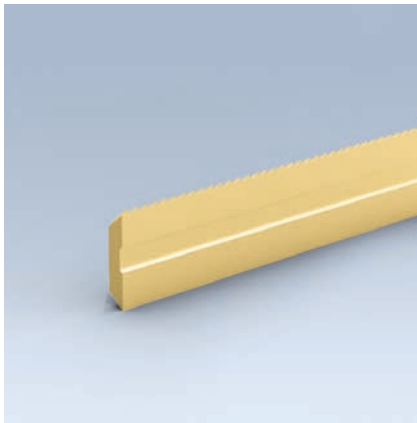
### Knife height 8 mm Marathon

#### HW-30F MC / HW-30F MC Micro / HW-05 MC / HW TDC

TM 410 0, TM 410 0 50, TM 410 0 70

| SB mm | H mm | DIK mm | VE PCS | ID HW-30F MC | ID HW-30F MC Micro | ID HW-05 MC | ID HW TDC |
|-------|------|--------|--------|--------------|--------------------|-------------|-----------|
| 7,7   | 8    | 1,5    | 10     | 601600 ●     | 601704 ●           | 601628 ●    | 601416    |
| 9,7   | 8    | 1,5    | 10     | 601601 ●     | 601705 ●           | 601629 ●    | 601417    |
| 11,7  | 8    | 1,5    | 10     | 601602 ●     | 601706 ●           | 601630 ●    | 601418    |
| 14,7  | 8    | 1,5    | 10     | 601603 ●     | 601707 ●           | 601631 ●    | 601419    |
| 19,7  | 8    | 1,5    | 10     | 601604 ●     | 601708 ●           | 601632 ●    | 601420    |
| 25    | 8    | 1,5    | 10     | 601605 ●     | 601709 ●           | 601633 ●    | 601421    |
| 30    | 8    | 1,5    | 10     | 601606 ●     | 601710 ●           | 601634 ●    | 601422    |
| 35    | 8    | 1,5    | 10     | 601607 ●     | 601711 ●           | 601635 ●    | 601423    |
| 40    | 8    | 1,5    | 10     | 601608 ●     | 601712 ●           | 601636 ●    | 601424    |
| 45    | 8    | 1,5    | 1      | 601609 □     | 601713 □           | 601637 ●    | 601425    |
| 50    | 8    | 1,5    | 1      |              | 601714 ●           |             |           |
| 50    | 8    | 1,5    | 10     | 601610 ●     |                    | 601638 ●    | 601426    |
| 60    | 8    | 1,5    | 1      |              | 601715 ●           |             |           |
| 60    | 8    | 1,5    | 10     | 601611 ●     |                    | 601639 ●    | 601427    |
| 70    | 8    | 1,5    | 1      | 601612 □     | 601716 □           | 601640 ●    | 601428    |
| 80    | 8    | 1,5    | 1      |              | 601717 ●           | 601641 ●    |           |
| 80    | 8    | 1,5    | 10     | 601613 ●     |                    |             | 601429    |
| 100   | 8    | 1,5    | 1      | 601614 ●     | 601718 ●           | 601642 ●    | 601430    |
| 120   | 8    | 1,5    | 1      | 601615 ●     | 601719 ●           | 601643 ●    | 601431    |

ID = 1 piece.



One-way knife HW



**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW fine grain quality (HW 30F)  
HW (HW-05)

**Coating:**

Marathon MC (Multi Coating)

**RipTec:**

Cutting edges with RipTec profile for high surface quality and cutting performance

### Changeable knife 8 mm Marathon RipTec for turnblade knife tools Integral

**HW-30F MC RipTec**

TM 140 0 08

| SB  | H  | DIK | KBZ          | QAL       | VE  | ID     |
|-----|----|-----|--------------|-----------|-----|--------|
| mm  | mm | mm  |              |           | PCS |        |
| 8   | 8  | 1,5 | EPR 8/8-MC   | HW-30F MC | 2   | 601744 |
| 10  | 8  | 1,5 | EPR 8/10-MC  | HW-30F MC | 2   | 601745 |
| 12  | 8  | 1,5 | EPR 8/12-MC  | HW-30F MC | 2   | 601746 |
| 14  | 8  | 1,5 | EPR 8/15-MC  | HW-30F MC | 2   | 601747 |
| 20  | 8  | 1,5 | EPR 8/20-MC  | HW-30F MC | 2   | 601748 |
| 24  | 8  | 1,5 | EPR 8/25-MC  | HW-30F MC | 2   | 601749 |
| 29  | 8  | 1,5 | EPR 8/30-MC  | HW-30F MC | 2   | 601750 |
| 34  | 8  | 1,5 | EPR 8/35-MC  | HW-30F MC | 2   | 601751 |
| 39  | 8  | 1,5 | EPR 8/40-MC  | HW-30F MC | 2   | 601752 |
| 44  | 8  | 1,5 | EPR 8/45-MC  | HW-30F MC | 2   | 601753 |
| 49  | 8  | 1,5 | EPR 8/50-MC  | HW-30F MC | 2   | 601754 |
| 59  | 8  | 1,5 | EPR 8/60-MC  | HW-30F MC | 2   | 601755 |
| 69  | 8  | 1,5 | EPR 8/70-MC  | HW-30F MC | 2   | 601756 |
| 78  | 8  | 1,5 | EPR 8/80-MC  | HW-30F MC | 2   | 601757 |
| 98  | 8  | 1,5 | EPR 8/100-MC | HW-30F MC | 2   | 601758 |
| 118 | 8  | 1,5 | EPR 8/120-MC | HW-30F MC | 2   | 601759 |

ID = 1 piece.

**HW-05 MC RipTec**

TM 140 0 08

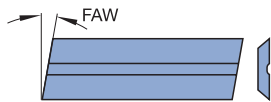
| SB  | H  | DIK | KBZ           | QAL      | VE  | ID     |
|-----|----|-----|---------------|----------|-----|--------|
| mm  | mm | mm  |               |          | PCS |        |
| 8   | 8  | 1,5 | EPR 8/8B-MC   | HW-05 MC | 2   | 601760 |
| 10  | 8  | 1,5 | EPR 8/10B-MC  | HW-05 MC | 2   | 601761 |
| 12  | 8  | 1,5 | EPR 8/12B-MC  | HW-05 MC | 2   | 601762 |
| 14  | 8  | 1,5 | EPR 8/15B-MC  | HW-05 MC | 2   | 601763 |
| 20  | 8  | 1,5 | EPR 8/20B-MC  | HW-05 MC | 2   | 601764 |
| 24  | 8  | 1,5 | EPR 8/25B-MC  | HW-05 MC | 2   | 601765 |
| 29  | 8  | 1,5 | EPR 8/30B-MC  | HW-05 MC | 2   | 601766 |
| 34  | 8  | 1,5 | EPR 8/35B-MC  | HW-05 MC | 2   | 601767 |
| 39  | 8  | 1,5 | EPR 8/40B-MC  | HW-05 MC | 2   | 601768 |
| 44  | 8  | 1,5 | EPR 8/45B-MC  | HW-05 MC | 2   | 601769 |
| 49  | 8  | 1,5 | EPR 8/50B-MC  | HW-05 MC | 2   | 601770 |
| 59  | 8  | 1,5 | EPR 8/60B-MC  | HW-05 MC | 2   | 601771 |
| 69  | 8  | 1,5 | EPR 8/70B-MC  | HW-05 MC | 2   | 601772 |
| 78  | 8  | 1,5 | EPR 8/80B-MC  | HW-05 MC | 2   | 601773 |
| 98  | 8  | 1,5 | EPR 8/100B-MC | HW-05 MC | 2   | 601774 |
| 118 | 8  | 1,5 | EPR 8/120B-MC | HW-05 MC | 2   | 601775 |

ID = 1 piece.

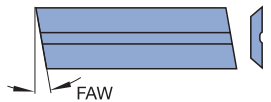
## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

HW fine grain quality

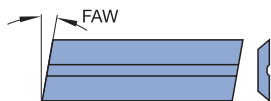
#### Knife height 8 mm (bevel/tenoning tools)

##### HW-30F

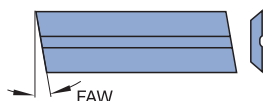
TM 410 0

| SB<br>mm | H<br>mm | DIK<br>mm | FAW<br>° | KBZ     | QAL    | ID       |
|----------|---------|-----------|----------|---------|--------|----------|
| 15       | 8       | 1,5       | 14°      | ZM 10/4 | HW-30F | 005050 ● |
| 15       | 8       | 1,5       | 14°      | ZM 11/4 | HW-30F | 005051 ● |
| 21       | 8       | 1,5       | 10°      | ZM 10/1 | HW-30F | 005004 ● |
| 21       | 8       | 1,5       | 10°      | ZM 11/1 | HW-30F | 005006 ● |

ID = 1 piece.



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

#### Knife height 8 mm Marathon (bevel/tenoning tools)

##### HW-30F MC / HW-05 MC

TM 410 0 50

| SB<br>mm | H<br>mm | DIK<br>mm | FAW<br>° | KBZ     | ID<br>HW-05<br>MC | ID<br>HW-30F<br>MC |
|----------|---------|-----------|----------|---------|-------------------|--------------------|
| 15       | 8       | 1,5       | 8°       | ZM 10/5 | 601645 ●          | 601617 ●           |
| 15       | 8       | 1,5       | 8°       | ZM 11/5 | 601644 ●          | 601616 ●           |
| 15       | 8       | 1,5       | 14°      | ZM 10/4 | 601647 ●          | 601619 ●           |
| 15       | 8       | 1,5       | 14°      | ZM 11/4 | 601646 ●          | 601618 ●           |
| 21       | 8       | 1,5       | 10°      | ZM 10/1 | 601649 ●          | 601621 ●           |
| 21       | 8       | 1,5       | 10°      | ZM 11/1 | 601648 ●          | 601620 ●           |

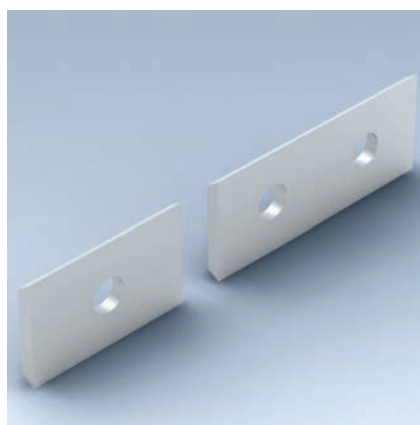
ID = 1 piece.

| Cutting material recommendation    | HW-30F MC | HW-05 MC |
|------------------------------------|-----------|----------|
| Softwood                           | ◆         | ◇        |
| Hardwood                           | ◇         | ◆        |
| Glulam                             | ◇         | ◆        |
| Chipboard                          |           | ◆        |
| MDF                                |           | ◆        |
| Thermoplastics (PE, PP, PVC, etc.) | ◇         | ◆        |

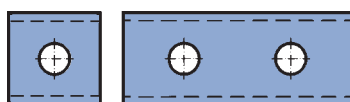
◆ suitable ◇ partly suitable

#### Coating:

Marathon MC (Multi Coating)



Knife type:  
Type 1 Type 2



Turnblade knife

| Cutting material recommendation    | HW-05F | HW-02UF | TDC |
|------------------------------------|--------|---------|-----|
| Softwood                           | ◆      | ◇       | ◇   |
| Hardwood                           | ◆      | ◆       | ◇   |
| Glulam                             | ◇      | ◆       | ◆   |
| Chipboard                          | ◇      | ◆       | ◆   |
| MDF                                | ◇      | ◆       | ◆   |
| Thermoplastics (PE, PP, PVC, etc.) | ◇      | ◆       | ◆   |

◆ suitable ◇ partly suitable

### Knife height 12 mm

#### HW-05F / HW-02UF / TDC

TM 405 0

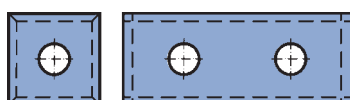
| Knife | SB<br>mm | H<br>mm | DIK<br>mm | VE<br>PCS | ID<br>HW-02UF | ID<br>HW-05F | ID<br>TDC |
|-------|----------|---------|-----------|-----------|---------------|--------------|-----------|
| 1     | 7,6      | 12      | 1,5       | 10        |               | 005080 ●     | 602414    |
| 1     | 9        | 12      | 1,5       | 10        |               | 005158 ●     | 602415    |
| 1 *   | 12       | 12      | 1,5       | 10        |               | 005081 ●     | 602416 ●  |
| 1     | 15       | 12      | 1,5       | 10        |               | 005082 ●     | 602417    |
| 1     | 20       | 12      | 1,5       | 10        | 602001 ●      | 005083 ●     | 602418    |
| 2     | 30       | 12      | 1,5       | 10        | 602002 ●      | 005084 ●     | 602419 ●  |
| 2     | 40       | 12      | 1,5       | 10        | 602003 ●      | 005085 ●     | 602420    |
| 2     | 50       | 12      | 1,5       | 10        | 602004 ●      | 005086 ●     | 602421 ●  |
| 2     | 60       | 12      | 1,5       | 10        |               | 005087 ●     | 602422    |

ID = 1 piece.

\* = with 4 cutting edges.

#### Cutting material:

HW / HW ultra fine grain quality



Turnblade knife with 4 cutting edges

| Cutting material recommendation    | HW-05F | HW-02UF |
|------------------------------------|--------|---------|
| Softwood                           | ◆      | ◇       |
| Hardwood                           | ◆      | ◆       |
| Glulam                             | ◇      | ◆       |
| Chipboard                          | ◇      | ◆       |
| MDF                                | ◇      | ◆       |
| Thermoplastics (PE, PP, PVC, etc.) | ◇      | ◆       |

◆ suitable ◇ partly suitable

### Knife height 12 mm with 4 cutting edges

#### HW-05F / HW-02UF

TM 405 0

| SB<br>mm | H<br>mm | DIK<br>mm | VE<br>PCS | ID<br>HW-02UF | ID<br>HW-05F |
|----------|---------|-----------|-----------|---------------|--------------|
| 30       | 12      | 1,5       | 10        | 602005 ●      | 005161 ●     |
| 50       | 12      | 1,5       | 10        | 602006 ●      | 006506 ●     |

ID = 1 piece.

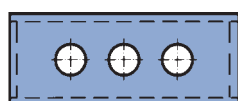
#### HW-05F with 3 holes

TM 405 0

| SB<br>mm | H<br>mm | DIK<br>mm | QAL    | VE<br>PCS | ID       |
|----------|---------|-----------|--------|-----------|----------|
| 50       | 12      | 1,7       | HW-05F | 10        | 007668 ● |

ID = 1 piece.

**Cutting material:**  
HW / HW ultra fine grain quality



Turnblade knife with 4 cutting edges  
and 3 holes



Turnblade knife

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW

#### Knife height 12 mm (slotting tools)

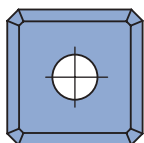
**HW**

TM 405 0

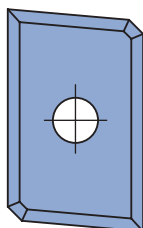
| SB<br>mm | H<br>mm | DIK<br>mm | KBZ    | QAL | ID       |
|----------|---------|-----------|--------|-----|----------|
| 7,6      | 12      | 1,5       | SM 1/1 | HW  | 005120 ● |
| 9,6      | 12      | 1,5       | SM 1/2 | HW  | 005121 ● |
| 11,6     | 12      | 1,5       | SM 1/3 | HW  | 005122 ● |

Knife type:  
Type 1

Type 2



Turnblade knife



**Workpiece material:**  
Softwood and hardwood

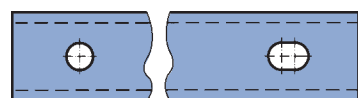
**Cutting material:**  
HW

#### Knife height 12 mm with bevel

**HW**

TM 405 0

| Knife | SB<br>mm | H<br>mm | DIK<br>mm | FAW<br>° | QAL | ID       |
|-------|----------|---------|-----------|----------|-----|----------|
| 1     | 12       | 12      | 1,5       | 1x45°    | HW  | 602009 ● |
| 2     | 19,7     | 12      | 1,5       | 5°       | HW  | 602010 ● |



Turnblade knife

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW

#### Knife height 13 mm

**HW**

TM 405 0

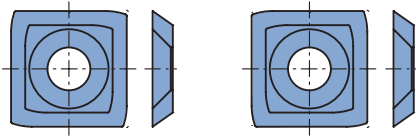
| SB<br>mm | H<br>mm | DIK<br>mm | QAL | VE<br>PCS | ID       |
|----------|---------|-----------|-----|-----------|----------|
| 80       | 13      | 2,2       | HW  | 10        | 005096 ● |
| 100      | 13      | 2,2       | HW  | 10        | 005097 ● |
| 120      | 13      | 2,2       | HW  | 10        | 005098 ● |

ID = 1 piece.

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



#### Turnblade knife with radius for calibration moulder System Rotoles

**HW**

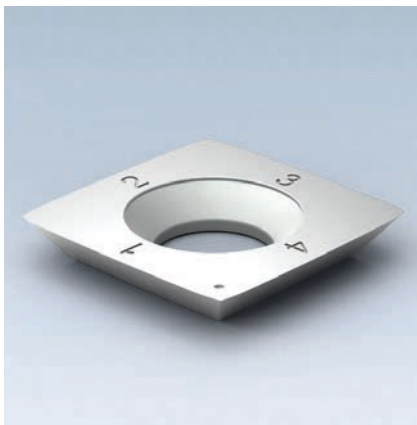
TM 435 0

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW / HW fine grain quality

| SB   | H    | DIK | QAL    | VE  | ID       | ID       |
|------|------|-----|--------|-----|----------|----------|
| mm   | mm   | mm  |        | PCS | left     | right    |
| 14,3 | 14,3 | 2,5 | HW     | 10  | 602525 ● | 602526 ● |
| 14   | 14   | 2   | HW-10F | 10  | 602527 ● | 602528 ● |

ID = 1 piece.



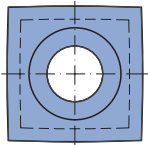
#### Turnblade knives for cutterhead system HeliCut

**HW / TDC**

TM 135 0, TM 405 0, TM 435 0

| BEM                           | SB   | H    | DIK | QAL   | VE  | ID       |
|-------------------------------|------|------|-----|-------|-----|----------|
|                               | mm   | mm   | mm  |       | PCS |          |
| HeliCut 15                    | 15   | 15   | 2,5 | HW    | 10  | 009549 ● |
| HeliCut 15                    | 15   | 15   | 2,5 | HW-MF | 10  | 009543 ● |
| HeliCut 15                    | 15   | 15   | 2,5 | TDC   |     | 602900 ● |
| HeliCut 11 (peripheral tip)   | 11   | 11   | 1,5 | HW    | 10  | 602515 ● |
| HeliCut 11 (peripheral tip)   | 11   | 11   | 1,5 | TDC   |     | 602904 ● |
| HeliCut 11 (plunging tip D30) | 20,6 | 12,7 | 2   | HW    | 10  | 602531 ● |
| HeliCut 11 (plunging tip D40) | 22   | 12,7 | 2   | HW    |     | 602516 ● |

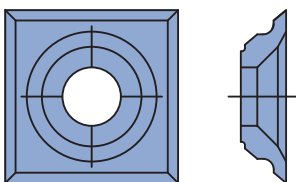
ID = 1 piece.



HW turnblade knife

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW / TDC



Turnblade knife with 4 cutting edges

**Workpiece material:**  
Softwood and hardwood

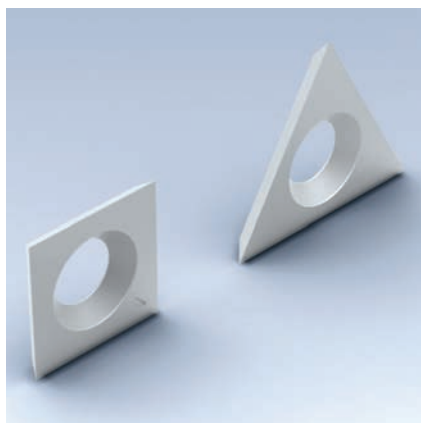
**Cutting material:**  
HW

#### Knife height 21 mm with 4 cutting edges

**HW**

TM 410 0

| SB | H  | DIK | QAL | ID       |
|----|----|-----|-----|----------|
| mm | mm | mm  |     |          |
| 21 | 21 | 5,5 | HW  | 009527 ● |



#### Spurs

##### HW / DP

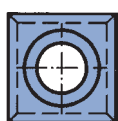
TM 405 0, TM 480 0

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ      | QAL  | VE<br>PCS | ID       |
|----------|---------|-----------|----------|------|-----------|----------|
| 14       | 14      | 2         | VS 1     | HW-F | 10        | 005099 ● |
| 14       | 14      | 1,2       | VS 4     | HW   | 10        | 005130 ● |
| 14       | 14      | 1,2       | Holz-Her | HW   | 10        | 602500 ● |
| 15       | 15      | 2         |          | HW   |           | 005100 ● |
| 19       |         | 2         | VS 2     | HW-F | 10        | 005115 ● |
| 19       |         | 2         | VS 2R*   | HW-F | 10        | 006615 ● |
| 19       |         | 2         | VS 2L*   | HW-F | 10        | 006616 ● |
| 19       |         | 2         | VS 2     | DP   | 2         | 006607 ● |
| 19       |         | 2         | VS 3R    | HW-F |           | 005116 ● |
| 19       |         | 2         | VS 3L    | HW-F |           | 005159 ● |

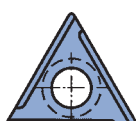
\* = Spurs with reduced slotting depth. Knives can be used alternatively in VS2 knife seating.

DP\* = diamond coated.

ID = 1 piece.



VS 1



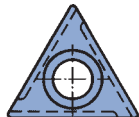
VS 3L



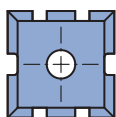
VS 2



VS 4



VS 3R



ID 005100

##### Workpiece material:

Solid wood, wood derived materials

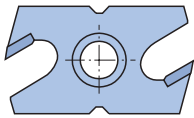
##### Cutting material:

HW fine grain quality / DP\*

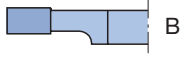
## 8. Knives and spare parts

### 8.1 Knives and blank knives

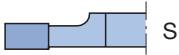
#### 8.1.3 Grooving knives / profile grooving knives



Grooving knife



Grooving knife image



Grooving knife mirror image

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW fine grain quality

#### Grooving knives

**Mechanical feed**

TM 460 0

| SB<br>mm | KBZ     | QAL  | ID       |
|----------|---------|------|----------|
| 3        | NA 3B   | HW-F | 008315 ● |
| 3        | NA 3S   | HW-F | 008316 ● |
| 3        | NAK 3B* | HW-F | 616002 ● |
| 3        | NAK 3S* | HW-F | 616003 ● |
| 4,5      | NA 4,5  | HW-F | 008333 ● |
| 4        | NA 4    | HW-F | 008317 ● |
| 5        | NA 5    | HW-F | 008318 ● |
| 7        | NA 7    | HW-F | 008319 ● |
| 8        | NAN 8   | HW-F | 008349 ● |
| 9        | NA 9    | HW-F | 008320 ● |

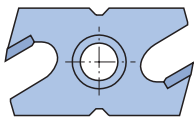
\* Grooving knife with reduced grooving depth

**Manual feed**

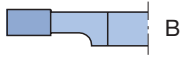
TM 460 1

| SB<br>mm | KBZ     | QAL  | ID       |
|----------|---------|------|----------|
| 3        | NB 3B   | HW-F | 008321 ● |
| 3        | NB 3S   | HW-F | 008322 ● |
| 3        | NBK 3B* | HW-F | 616000 ● |
| 3        | NBK 3S* | HW-F | 616001 ● |
| 4        | NB 4    | HW-F | 008323 ● |
| 5        | NB 5    | HW-F | 008324 ● |
| 7        | NB 7    | HW-F | 008325 ● |
| 8        | NBN 8   | HW-F | 008348 ● |
| 9        | NB 9    | HW-F | 008326 ● |

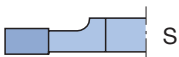
\* Grooving knife with reduced grooving depth.



Grooving knife



Grooving knife image



Grooving knife mirror image

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

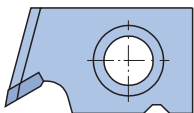
HW fine grain quality

#### Profile grooving knives

**For sealing strip**

TM 160 0

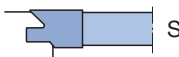
| SB<br>mm | KBZ   | QAL  | ID       |
|----------|-------|------|----------|
| 8        | NC 1B | HW-F | 008327 ● |
| 8        | NC 1S | HW-F | 008328 ● |



Profile grooving knife



Profile grooving knife image



Profile grooving knife mirror image

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW fine grain quality



Lamello turnblade knives

**Cutting material:**

HW

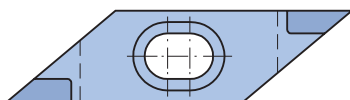
#### Lamello turnblade knives

**HW**

TM 463 0

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ        | QAL | VE<br>PCS | ID              |
|----------|---------|-----------|------------|-----|-----------|-----------------|
| 18       | 18      | 1,95      | WP 18/1,95 | HW  | 10        | <b>005114 ●</b> |
| 18       | 18      | 2,5       | WP 18/2,5  | HW  | 10        | <b>005195 ●</b> |

ID = 1 piece.



Rhomboid turnblade knives

**Cutting material:**

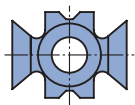
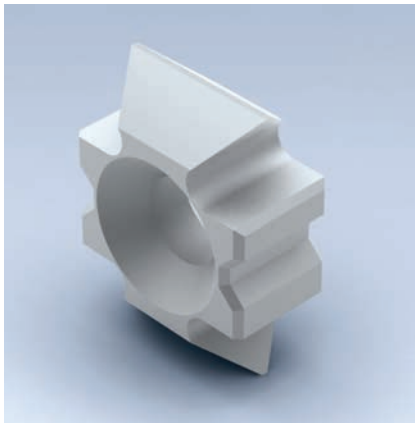
HW fine grain quality

#### Rhomboid turnblade knives

**HW-F**

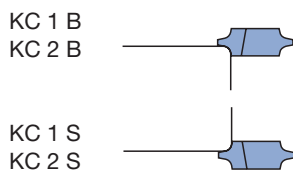
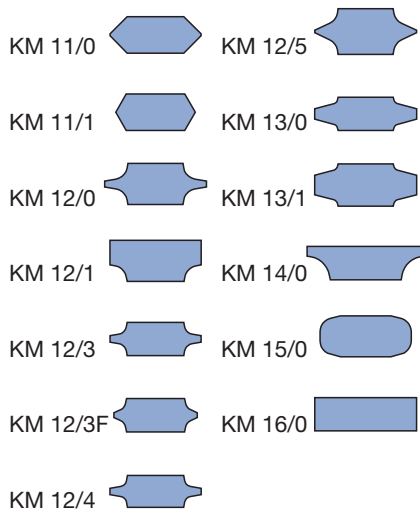
TM 461 0

| L<br>mm | H<br>mm | SB<br>mm | KBZ     | QAL  | ID              |
|---------|---------|----------|---------|------|-----------------|
| 45,416  | 12      | 5,6      | RMA 5,6 | HW-F | <b>008329 ●</b> |
| 45,416  | 12      | 6,6      | RMA 6,6 | HW-F | <b>008330 ●</b> |



**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW fine grain quality



**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW fine grain quality

### Mechanical feed

#### HW-F

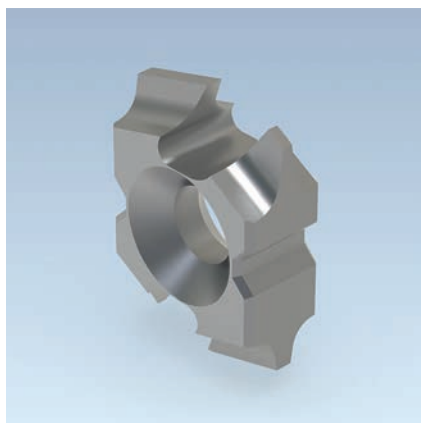
TM 462 0

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ          | QAL  | ID       |
|----------|---------|-----------|--------------|------|----------|
| 20       | 15      | 8         | KM 11/0 45°  | HW-F | 008268 ● |
| 20       | 15      | 7         | KM 12/4 R1,5 | HW-F | 008272 ● |
| 20       | 15      | 7,3       | KM 12/3 R2   | HW-F | 008307 ● |
| 22,3     | 15      | 9         | KM 12/0 R3   | HW-F | 008270 ● |
| 22       | 15      | 9         | KM 15/0 R3   | HW-F | 008275 ● |
| 20       | 15      | 9         | KM 12/1 R3   | HW-F | 008271 ● |
| 17,5     | 15      | 8         | KM 11/1 60°  | HW-F | 008269 ● |
| 18,3     | 15      | 7,3       | KM 12/3F R2F | HW-F | 008308 ● |
| 22,3     | 15      | 10        | KM 12/5 R3F  | HW-F | 008273 ● |
| 22,3     | 15      | 7,3       | KM 13/0 N5   | HW-F | 008274 ● |
| 22,3     | 15      | 9         | KM 13/1 N7   | HW-F | 008287 ● |
| 22,3     | 15      | 7,3       | KM 16/0      | HW-F | 008286 ● |
| 22,3     | 15      | 7,3       | KM 14/0 R5   | HW-F | 008347 ● |

#### HW-F, with bevelled cutting area

TM 462 0

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ        | QAL  | ID       |
|----------|---------|-----------|------------|------|----------|
| 20       | 15      | 8,3       | KC 1B (R2) | HW-F | 008334 ● |
| 20       | 15      | 10        | KC 2B (R3) | HW-F | 008335 ● |
| 20       | 15      | 8,3       | KC 1S (R2) | HW-F | 008336 ● |
| 20       | 15      | 10        | KC 2S (R3) | HW-F | 008337 ● |

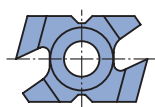


#### Manual feed

##### HW-F

TM 462 1

| SB<br>mm | H<br>mm | DIK<br>mm | KBZ          | QAL  | ID       |
|----------|---------|-----------|--------------|------|----------|
| 23       | 15      | 7,3       | KM 22/3 R2   | HW-F | 008309 ● |
| 23       | 15      | 8         | KM 21/0 45°  | HW-F | 008292 ● |
| 23       | 15      | 9         | KM 22/1 R3   | HW-F | 008290 ● |
| 25,7     | 15      | 7,3       | KM 24/0 R5   | HW-F | 008305 ● |
| 23       | 15      | 7         | KM 22/4 R1,5 | HW-F | 008295 ● |
| 23       | 15      | 9         | KM 25/0 R3   | HW-F | 008291 ● |
| 25,7     | 15      | 9,3       | KM 23/1 N7   | HW-F | 008298 ● |
| 25,7     | 15      | 7,3       | KM 24/1 R5   | HW-F | 008306 ● |
| 23       | 15      | 9         | KM 22/0 R3   | HW-F | 008293 ● |
| 20,5     | 15      | 8         | KM 21/1 60°  | HW-F | 008294 ● |
| 21       | 15      | 7,3       | KM 22/3F R2F | HW-F | 008310 ● |
| 23       | 15      | 9         | KM 22/5 R3F  | HW-F | 008296 ● |
| 25,7     | 15      | 7,3       | KM 23/0 N5   | HW-F | 008297 ● |
| 25,7     | 15      | 7,3       | KM 26/0      | HW-F | 008299 ● |



##### Workpiece material:

Softwood and hardwood

##### Cutting material:

HW fine grain quality



| Cutting material recommendation    | HS Classic / Premium | MC33 | HW |
|------------------------------------|----------------------|------|----|
| Solid wood dry                     | ◆                    | ◆    | ◇  |
| Solid wood wet                     | ◇                    | ◆    |    |
| Hardwood dry                       | ◇                    | ◆    | ◆  |
| Hardwood wet                       | ◇                    | ◆    |    |
| Glulam                             |                      | ◇    | ◇  |
| Thermoplastics (PE, PP, PVC, etc.) | ◆                    | ◆    | ◇  |
| WPC (Wood-Plastic-Composite)       | ◇                    | ◆    | ◇  |

◆ suitable ◇ partly suitable



Cross section of planer knife (HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

#### Cutting material:

HS Classic / HS Premium / MC33 / HW

#### Wedge angle:

40° (HS Classic / HS Premium / MC33)

45° (HW)

### Knife height 30 mm

#### For planerhead wedge-type system WM 200 2 05

TM 100 0, TM 100 0 03, TM 100 0 05

| SB  | H  | DIK | VE  | ID         | ID         | ID       | ID       |
|-----|----|-----|-----|------------|------------|----------|----------|
| mm  | mm | mm  | PCS | HS Classic | HS Premium | HW       | MC33     |
| 60  | 30 | 3   | 2   | 605000     | 027101 ●   | 027277 ● | 606700 ● |
| 80  | 30 | 3   | 2   | 605001     | 027102 ●   | 027278 ● | 606701 ● |
| 100 | 30 | 3   | 2   | 605002 ●   | 027103 ●   | 027279 ● | 606702 ● |
| 110 | 30 | 3   | 2   | 605003     | 027104 ●   | 027280 ● | 606703 ● |
| 120 | 30 | 3   | 2   | 605004     | 027105 ●   | 027281 ● | 606704 ● |
| 130 | 30 | 3   | 2   | 605005 ●   | 027106 ●   | 027282 ● | 606705 ● |
| 150 | 30 | 3   | 2   | 605006 ●   | 027107 ●   | 027283 ● | 606706 ● |
| 160 | 30 | 3   | 2   | 605045 ●   | 027163 ●   |          | 606745 ● |
| 170 | 30 | 3   | 2   | 605007 ●   | 027108 ●   | 027284 ● | 606707 ● |
| 180 | 30 | 3   | 2   | 605008 ●   | 027109 ●   | 027285 ● | 606708 ● |
| 190 | 30 | 3   | 2   | 605009     | 027144 ●   | 027322 ● | 606709 ● |
| 210 | 30 | 3   | 2   | 605010     | 027110 ●   | 027286 ● | 606710 ● |
| 230 | 30 | 3   | 2   | 605011 ●   | 027111 ●   | 027287 ● | 606711 ● |
| 240 | 30 | 3   | 2   | 605012 ●   | 027134 ●   | 027323 ● | 606712 ● |
| 250 | 30 | 3   | 2   | 605013     | 027161 ●   |          | 606713 ● |
| 260 | 30 | 3   | 2   | 605014 ●   | 027112 ●   | 027288 ● | 606714 ● |
| 270 | 30 | 3   | 2   | 605015     | 027162 ●   |          | 606715 ● |
| 310 | 30 | 3   | 2   | 605016 ●   | 027113 ●   | 027289 ● | 606716 ● |
| 320 | 30 | 3   | 2   | 605046     | 027164 ●   |          | 606746 ● |
| 360 | 30 | 3   | 2   | 605029     | 027114 ●   | 027292 ● | 606729 ● |
| 400 | 30 | 3   | 2   | 605030     | 027115 ●   |          | 606730 ● |
| 410 | 30 | 3   | 2   | 605031 ●   | 027116 ●   | 027293 ● | 606731 ● |
| 460 | 30 | 3   | 2   | 605032     | 027130 ●   | 027295 ● | 606732 □ |
| 500 | 30 | 3   | 2   | 605033     | 027117 ●   |          | 606733 □ |
| 510 | 30 | 3   | 2   | 605034 ●   | 027118 ●   | 027296 ● | 606734 □ |
| 600 | 30 | 3   | 2   | 605035     | 027119 ●   |          | 606735 □ |
| 610 | 30 | 3   | 2   | 605036 ●   | 027120 ●   | 027297 ● | 606736 □ |
| 630 | 30 | 3   | 2   | 605037     | 027125 ●   | 027298 ● | 606737 □ |
| 640 | 30 | 3   | 2   | 605038 ●   | 027121 ●   | 027299 ● | 606738 □ |
| 710 | 30 | 3   | 2   | 605039     | 027122 ●   | 027300 ● | 606739 □ |
| 810 | 30 | 3   | 2   | 605040 ●   | 027123 ●   | 027302 ● | 606740 □ |

ID = 1 piece.

### Knife height 35 mm

#### For long planerheads wedge-type system

TM 100 0, TM 100 0 03, TM 100 0 05

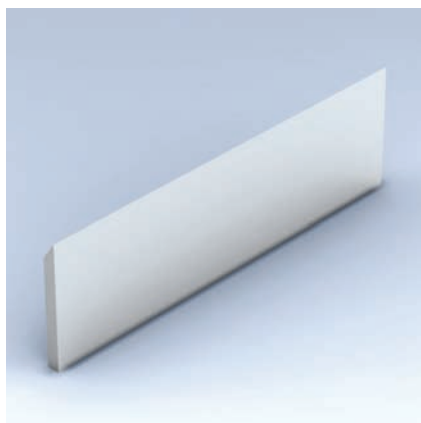
| SB  | H  | DIK | VE  | ID         | ID         | ID       | ID       |
|-----|----|-----|-----|------------|------------|----------|----------|
| mm  | mm | mm  | PCS | HS Classic | HS Premium | HW       | MC33     |
| 60  | 35 | 3   | 2   | 605119     | 027387 ●   |          | 606819 ● |
| 100 | 35 | 3   | 2   | 605120     | 027388 ●   |          | 606820 ● |
| 160 | 35 | 3   | 2   | 605121     | 027389 ●   |          | 606821 ● |
| 230 | 35 | 3   | 2   | 605122     | 027390 ●   |          | 606822 ● |
| 310 | 35 | 3   | 2   | 605100     | 027351 ●   | 027303 ● | 606800 ● |
| 320 | 35 | 3   | 2   | 605101     | 027352 ●   | 027304 □ | 606801 ● |
| 330 | 35 | 3   | 2   | 605102     | 027353 ●   | 027305 □ | 606802 ● |
| 360 | 35 | 3   | 2   | 605103     | 027354 ●   | 027306 □ | 606803 ● |
| 400 | 35 | 3   | 2   | 605104     | 027355 ●   | 027307 □ | 606804 ● |
| 410 | 35 | 3   | 2   | 605105 ●   | 027356 ●   | 027308 ● | 606805 ● |
| 450 | 35 | 3   | 2   | 605106     | 027357 ●   | 027309 □ | 606806 □ |
| 460 | 35 | 3   | 2   | 605107     | 027358 ●   | 027310 □ | 606807 □ |
| 500 | 35 | 3   | 2   | 605108 ●   | 027359 ●   | 027311 □ | 606808 □ |
| 510 | 35 | 3   | 2   | 605109 ●   | 027360 ●   | 027312 ● | 606809 □ |
| 600 | 35 | 3   | 2   | 605110     | 027361 ●   | 027313 □ | 606810 □ |
| 610 | 35 | 3   | 2   | 605111 ●   | 027362 ●   | 027314 □ | 606811 □ |
| 630 | 35 | 3   | 2   | 605112     | 027363 ●   | 027315 ● | 606812 □ |
| 635 | 35 | 3   | 2   | 605113     | 027364 ●   | 027316 ● | 606813 □ |
| 640 | 35 | 3   | 2   | 605114 ●   | 027365 ●   | 027317 ● | 606814 □ |
| 660 | 35 | 3   | 2   |            | 027371 ●   |          |          |
| 700 | 35 | 3   | 2   | 605115     | 027366 ●   | 027318 □ | 606815 □ |
| 710 | 35 | 3   | 2   | 605116     | 027367 ●   | 027319 □ | 606816 □ |
| 740 | 35 | 3   | 2   | 605117     | 027368 ●   | 027320 □ | 606817 □ |
| 810 | 35 | 3   | 2   | 605118 ●   | 027369 ●   | 027321 ● | 606818 □ |

ID = 1 piece.

● available ex stock

□ available at short notice

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



### Knives for cassette system

#### Planer knives 30 mm with threaded bore

TM 105 0

| SB<br>mm | H<br>mm | DIK<br>mm | VE<br>PCS | ID<br>HS | ID<br>HW |
|----------|---------|-----------|-----------|----------|----------|
| 130      | 30      | 3         | 2         | 006825 ● | 006915 ● |
| 150      | 30      | 3         | 2         | 006928 ● | 006931 ● |
| 180      | 30      | 3         | 2         | 006826 ● | 006916 ● |
| 190      | 30      | 3         | 2         | 006929 ● |          |
| 230      | 30      | 3         | 2         | 006827 ● | 006917 ● |
| 240      | 30      | 3         | 2         | 006926 ● |          |

ID = 1 piece.

| Cutting material<br>recommendation    | HS | HW |
|---------------------------------------|----|----|
| Solid wood dry                        | ◆  |    |
| Solid wood wet                        | ◇  |    |
| Hardwood dry                          |    | ◆  |
| Hardwood wet                          |    | ◆  |
| Glulam                                |    | ◆  |
| Chipboard                             |    | ◇  |
| MDF                                   |    | ◇  |
| Thermoplastics<br>(PE, PP, PVC, etc.) |    | ◇  |
| WPC                                   |    |    |
| (Wood-Plastic-Composite)              |    | ◇  |

◆ suitable ◇ partly suitable



Cross section of planer knife  
(HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

#### Cutting material:

HS / HW



#### Planer knives with 60° back serration

For planerhead with 60° back serrated knife fixture

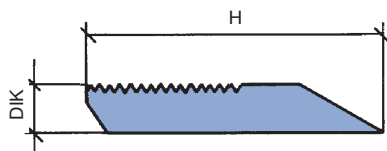
AT 103 0 29

| SB<br>mm | H<br>mm | DIK<br>mm | SET<br>PCS | QAL  | ID              |
|----------|---------|-----------|------------|------|-----------------|
| 150      | 30      | 5         | 2          | MC33 | <b>697359</b> □ |
| 230      | 30      | 5         | 2          | MC33 | <b>697360</b> □ |
| 310      | 30      | 5         | 2          | MC33 | <b>697361</b> □ |
| 320      | 30      | 5         | 2          | MC33 | <b>697362</b> □ |
| 330      | 30      | 5         | 2          | MC33 | <b>697363</b> □ |
| 40       | 40      | 5         | 2          | MC33 | <b>697300</b> ● |
| 60       | 40      | 5         | 2          | MC33 | <b>697301</b> ● |
| 80       | 40      | 5         | 2          | MC33 | <b>697302</b> ● |
| 100      | 40      | 5         | 2          | MC33 | <b>697303</b> ● |
| 130      | 40      | 5         | 2          | MC33 | <b>697304</b> ● |
| 150      | 40      | 5         | 2          | MC33 | <b>697305</b> ● |
| 170      | 40      | 5         | 2          | MC33 | <b>697306</b> ● |
| 180      | 40      | 5         | 2          | MC33 | <b>697307</b> ● |
| 190      | 40      | 5         | 2          | MC33 | <b>697308</b> ● |
| 210      | 40      | 5         | 2          | MC33 | <b>697309</b> ● |
| 230      | 40      | 5         | 2          | MC33 | <b>697310</b> ● |
| 240      | 40      | 5         | 2          | MC33 | <b>697311</b> ● |
| 270      | 40      | 5         | 2          | MC33 | <b>697312</b> ● |
| 310      | 40      | 5         | 2          | MC33 | <b>697313</b> ● |

Set of the same weight.

| Cutting material recommendation       | MC 33 |
|---------------------------------------|-------|
| Solid wood dry                        | ◆     |
| Solid wood wet                        | ◆     |
| Hardwood dry                          | ◆     |
| Hardwood wet                          | ◆     |
| Glulam                                | ◇     |
| Chipboard                             |       |
| MDF                                   |       |
| Thermoplastics<br>(PE, PP, PVC, etc.) | ◆     |
| WPC<br>(Wood-Plastic-Composite)       | ◆     |

◆ suitable ◇ partly suitable

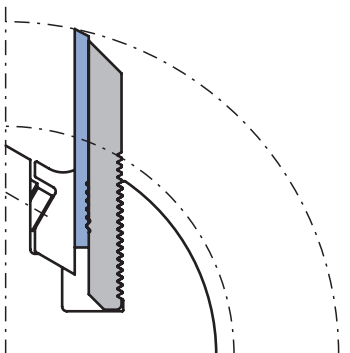
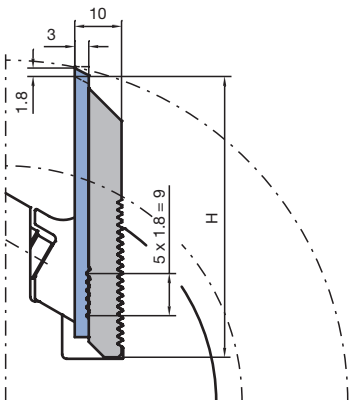


Cutting material:  
MC33



| Cutting material recommendation    | HW-30F jointable | HW-10F not jointable |
|------------------------------------|------------------|----------------------|
| Solid wood dry                     | ◆                |                      |
| Solid wood wet                     |                  |                      |
| Hardwood dry                       | ◆                | ◆                    |
| Hardwood wet                       |                  | ◇                    |
| Glulam                             | ◇                | ◆                    |
| Chipboard                          |                  | ◆                    |
| MDF                                | ◆                | ◆                    |
| Thermoplastics (PE, PP, PVC, etc.) | ◆                | ◆                    |
| WPC (Wood-Plastic-Composite)       | ◆                | ◆                    |

◆ suitable ◇ partly suitable



## Planer knives Powerknife System PKS®

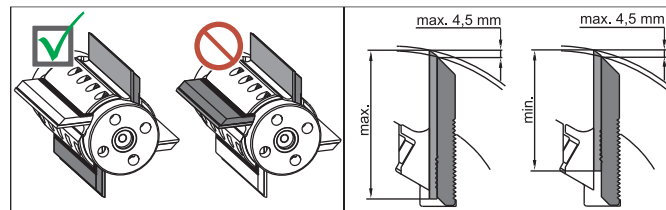
For planerhead with 60° back serrated knife fixture

AT 103 0 26, AT 107 0 26

| SB mm | H mm | DIK mm | SET PCS | QAL    | ID Blank knife set | ID Blank knife set with backing plate |
|-------|------|--------|---------|--------|--------------------|---------------------------------------|
| 40    | 40   | 10     | 2       | HW-30F | 696614 □           | 697814 □                              |
| 60    | 40   | 10     | 2       | HW-30F | 696615 □           | 697815 □                              |
| 80    | 40   | 10     | 2       | HW-30F | 696616 □           | 697816 □                              |
| 100   | 40   | 10     | 2       | HW-30F | 696617 □           | 697817 □                              |
| 130   | 40   | 10     | 2       | HW-30F | 696618 □           | 697818 □                              |
| 150   | 40   | 10     | 2       | HW-30F | 696619 ●           | 697819 ●                              |
| 170   | 40   | 10     | 2       | HW-30F | 696620 ●           | 697820 ●                              |
| 180   | 40   | 10     | 2       | HW-30F | 696621 □           | 697821 □                              |
| 190   | 40   | 10     | 2       | HW-30F | 696622 □           | 697822 □                              |
| 210   | 40   | 10     | 2       | HW-30F | 696623 ●           | 697823 ●                              |
| 230   | 40   | 10     | 2       | HW-30F | 696624 □           | 697824 □                              |
| 240   | 40   | 10     | 2       | HW-30F | 696625 ●           | 697825 ●                              |
| 270   | 40   | 10     | 2       | HW-30F | 696626 □           | 697826 □                              |
| 310   | 40   | 10     | 2       | HW-30F | 696627 ●           | 697827 ●                              |
| 40    | 40   | 10     | 2       | HW-10F | 696600 □           | 697800 □                              |
| 60    | 40   | 10     | 2       | HW-10F | 696601 □           | 697801 □                              |
| 80    | 40   | 10     | 2       | HW-10F | 696602 □           | 697802 □                              |
| 100   | 40   | 10     | 2       | HW-10F | 696603 □           | 697803 □                              |
| 130   | 40   | 10     | 2       | HW-10F | 696604 □           | 697804 □                              |
| 150   | 40   | 10     | 2       | HW-10F | 696605 ●           | 697805 ●                              |
| 170   | 40   | 10     | 2       | HW-10F | 696606 ●           | 697806 ●                              |
| 180   | 40   | 10     | 2       | HW-10F | 696607 □           | 697807 □                              |
| 190   | 40   | 10     | 2       | HW-10F | 696608 □           | 697808 □                              |
| 210   | 40   | 10     | 2       | HW-10F | 696609 ●           | 697809 ●                              |
| 230   | 40   | 10     | 2       | HW-10F | 696610 □           | 697810 □                              |
| 240   | 40   | 10     | 2       | HW-10F | 696611 ●           | 697811 ●                              |
| 270   | 40   | 10     | 2       | HW-10F | 696612 □           | 697812 □                              |
| 310   | 40   | 10     | 2       | HW-10F | 696613 ●           | 697813 ●                              |

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

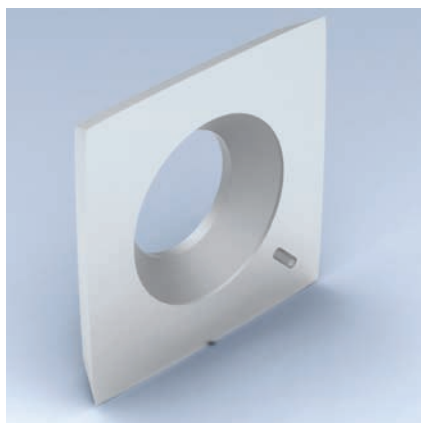
Set of the same weight.



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

### Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



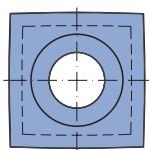
#### Turnblade planing knives HeliPlan

For cutterhead system HeliPlan

TM 405 0

| BEZ             | ABM<br>mm | QAL | VE<br>PCS | ID       |
|-----------------|-----------|-----|-----------|----------|
| Turnblade knife | 15x15x2,5 | HW  | 10        | 009535 ● |
| Turnblade knife | 15x15x2,5 | TDC |           | 602901 ● |

ID = 1 piece.



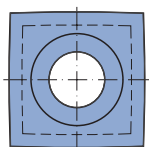
HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW / TDC



HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

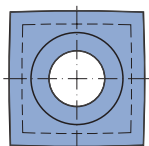
#### Turnblade planing knives CASTOR

For cutterhead system CASTOR-Finish

TM 405 0

| BEZ             | ABM<br>mm | QAL | VE<br>PCS | ID       |
|-----------------|-----------|-----|-----------|----------|
| Turnblade knife | 15x15x2,5 | HW  | 10        | 009540 ● |

ID = 1 piece.



HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

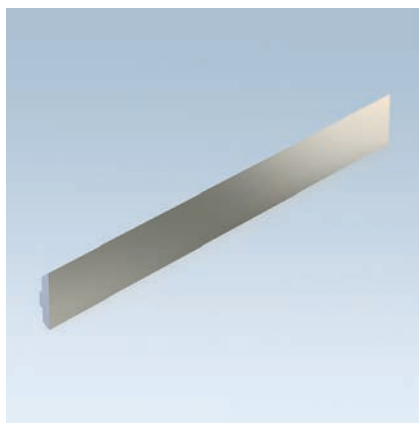
#### Turnblade planing knives

For cutterhead system

TM 405 0

| BEZ             | ABM<br>mm     | QAL | VE<br>PCS | ID       |
|-----------------|---------------|-----|-----------|----------|
| Turnblade knife | 13,8x13,8x2,5 | HW  | 10        | 602534 ● |

ID = 1 piece



#### Turnblade planing knives CentroPlan

For cutterhead system CentroPlan

AT 103 0 36

| SB  | H  | DIK | SET | QAL | ID              |
|-----|----|-----|-----|-----|-----------------|
| mm  | mm | mm  | PCS |     |                 |
| 100 | 13 | 2,6 | 2   | HW  | <b>617604</b> □ |
| 120 | 13 | 2,6 | 2   | HW  | <b>617605</b> □ |
| 130 | 13 | 2,6 | 2   | HW  | <b>617606</b> ● |
| 150 | 13 | 2,6 | 2   | HW  | <b>617607</b> ● |
| 166 | 13 | 2,6 | 2   | HW  | <b>617671</b> ● |
| 170 | 13 | 2,6 | 2   | HW  | <b>617611</b> □ |
| 180 | 13 | 2,6 | 2   | HW  | <b>617612</b> ● |
| 190 | 13 | 2,6 | 2   | HW  | <b>617614</b> □ |
| 210 | 13 | 2,6 | 2   | HW  | <b>617615</b> ● |
| 230 | 13 | 2,6 | 2   | HW  | <b>617616</b> □ |
| 236 | 13 | 2,6 | 2   | HW  | <b>617669</b> ● |
| 240 | 13 | 2,6 | 2   | HW  | <b>617618</b> □ |
| 256 | 13 | 2,6 | 2   | HW  | <b>617672</b> □ |
| 270 | 13 | 2,6 | 2   | HW  | <b>617665</b> ● |
| 310 | 13 | 2,6 | 2   | HW  | <b>617662</b> ● |
| 330 | 13 | 2,6 | 2   | HW  | <b>617624</b> ● |

| Cutting material recommendation | HW |
|---------------------------------|----|
| Solid wood dry                  | ◆  |
| Solid wood wet                  | ◆  |
| Hardwood dry                    | ◆  |
| Hardwood wet                    | ◆  |
| Glulam                          | ◆  |
| Chipboard                       | ◇  |
| MDF                             | ◇  |

◆ suitable ◇ partly suitable



Turnblade knife CentroPlan

**Cutting material:**

HW



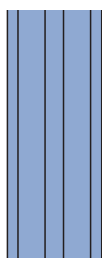
### Turnblade planing knives CentroStar, CentroFix, QuickFix

For cutterhead system CentroStar, CentroFix, QuickFix - HS

AT 103 0 02, AT 103 0 20

| Cutting material recommendation | HS | MC | HW |
|---------------------------------|----|----|----|
| Solid wood dry                  | ◆  | ◆  |    |
| Solid wood wet                  | ◇  | ◆  |    |
| Hardwood dry                    |    | ◇  | ◆  |
| Hardwood wet                    |    | ◆  | ◆  |
| Glulam                          |    | ◆  | ◆  |
| Clipboard                       |    |    | ◇  |
| MDF                             |    |    | ◇  |

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

**Cutting material:**

HS

**Cutting material:**

MC

| SB    | H  | DIK | SET | QAL | ID       |
|-------|----|-----|-----|-----|----------|
| mm    | mm | mm  | PCS |     |          |
| 100   | 12 | 2,7 | 4   | HS  | 610203 ● |
| 120   | 12 | 2,7 | 4   | HS  | 610204 ● |
| 124,6 | 12 | 2,7 | 4   | HS  | 610244 ● |
| 130   | 12 | 2,7 | 4   | HS  | 610205 ● |
| 136   | 12 | 2,7 | 4   | HS  | 610206 ● |
| 150   | 12 | 2,7 | 4   | HS  | 610208 ● |
| 166   | 12 | 2,7 | 4   | HS  | 610286 ● |
| 170   | 12 | 2,7 | 4   | HS  | 610210 ● |
| 180   | 12 | 2,7 | 4   | HS  | 610211 ● |
| 186   | 12 | 2,7 | 3   | HS  | 610247 ● |
| 190   | 12 | 2,7 | 4   | HS  | 610212 ● |
| 210   | 12 | 2,7 | 4   | HS  | 610213 ● |
| 230   | 12 | 2,7 | 4   | HS  | 610214 ● |
| 236   | 12 | 2,7 | 4   | HS  | 610287 ● |
| 240   | 12 | 2,7 | 4   | HS  | 610215 ● |
| 256   | 12 | 2,7 | 4   | HS  | 610288 ● |
| 260   | 12 | 2,7 | 4   | HS  | 610017 ● |
| 310   | 12 | 2,7 | 4   | HS  | 610018 ● |
| 400   | 12 | 2,7 | 4   | HS  | 610022 ● |
| 410   | 12 | 2,7 | 4   | HS  | 610023 ● |
| 410   | 12 | 2,7 | 3   | HS  | 610043 ● |
| 420   | 12 | 2,7 | 4   | HS  | 610024 ● |
| 430   | 12 | 2,7 | 4   | HS  | 610025 ● |
| 500   | 12 | 2,7 | 4   | HS  | 610028 ● |
| 510   | 12 | 2,7 | 4   | HS  | 610029 ● |
| 520   | 12 | 2,7 | 4   | HS  | 610030 ● |
| 530   | 12 | 2,7 | 4   | HS  | 610031 ● |
| 540   | 12 | 2,7 | 4   | HS  | 610032 ● |
| 610   | 12 | 2,7 | 4   | HS  | 610034 ● |
| 630   | 12 | 2,7 | 4   | HS  | 610036 ● |
| 640   | 12 | 2,7 | 4   | HS  | 610038 ● |
| 710   | 12 | 2,7 | 4   | HS  | 610040 ● |
| 810   | 12 | 2,7 | 4   | HS  | 610042 ● |

For cutterhead system CentroStar, CentroFix, QuickFix - MC

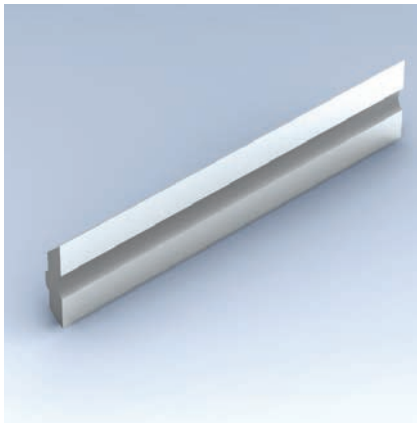
AT 103 0 20

| SB  | H  | DIK | SET | QAL | ID       |
|-----|----|-----|-----|-----|----------|
| mm  | mm | mm  | PCS |     |          |
| 100 | 12 | 2,7 | 4   | MC  | 610278 ● |
| 120 | 12 | 2,7 | 4   | MC  | 610279 ● |
| 130 | 12 | 2,7 | 4   | MC  | 610280 ● |
| 150 | 12 | 2,7 | 4   | MC  | 610281 ● |
| 180 | 12 | 2,7 | 4   | MC  | 610282 ● |
| 230 | 12 | 2,7 | 4   | MC  | 610283 ● |
| 240 | 12 | 2,7 | 4   | MC  | 610284 ● |
| 310 | 12 | 2,7 | 4   | MC  | 610285 ● |

**Cutting material:**  
HW-F

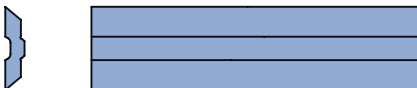
**For cutterhead system CentroStar, CentroFix, QuickFix - HW-F**  
AT 103 0 20, TM 410 0 02

| SB  | H  | DIK | SET | QAL  | ID              |
|-----|----|-----|-----|------|-----------------|
| mm  | mm | mm  | PCS |      |                 |
| 100 | 12 | 2,7 | 2   | HW-F | <b>610606 ●</b> |
| 120 | 12 | 2,7 | 2   | HW-F | <b>610610 ●</b> |
| 130 | 12 | 2,7 | 2   | HW-F | <b>610612 ●</b> |
| 136 | 12 | 2,7 | 2   | HW-F | <b>610614 ●</b> |
| 150 | 12 | 2,7 | 2   | HW-F | <b>610616 ●</b> |
| 166 | 12 | 2,7 | 2   | HW-F | <b>610680 ●</b> |
| 170 | 12 | 2,7 | 2   | HW-F | <b>610620 ●</b> |
| 180 | 12 | 2,7 | 2   | HW-F | <b>610621 ●</b> |
| 190 | 12 | 2,7 | 2   | HW-F | <b>610625 ●</b> |
| 210 | 12 | 2,7 | 2   | HW-F | <b>610627 ●</b> |
| 230 | 12 | 2,7 | 2   | HW-F | <b>610629 ●</b> |
| 236 | 12 | 2,7 | 2   | HW-F | <b>610679 ●</b> |
| 240 | 12 | 2,7 | 2   | HW-F | <b>610631 ●</b> |
| 256 | 12 | 2,7 | 2   | HW-F | <b>610681 ●</b> |
| 400 | 12 | 2,7 | 1   | HW-F | <b>612016 ●</b> |
| 410 | 12 | 2,7 | 1   | HW-F | <b>612017 ●</b> |
| 420 | 12 | 2,7 | 1   | HW-F | <b>612018 ●</b> |
| 430 | 12 | 2,7 | 1   | HW-F | <b>612019 ●</b> |
| 500 | 12 | 2,7 | 1   | HW-F | <b>612022 ●</b> |
| 510 | 12 | 2,7 | 1   | HW-F | <b>612023 ●</b> |
| 520 | 12 | 2,7 | 1   | HW-F | <b>612024 ●</b> |
| 530 | 12 | 2,7 | 1   | HW-F | <b>612025 ●</b> |
| 540 | 12 | 2,7 | 1   | HW-F | <b>612026 ●</b> |



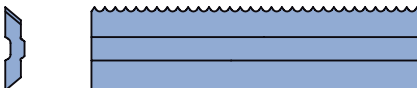
| Cutting material recommendation | HS | HW |
|---------------------------------|----|----|
| Solid wood dry                  | ◆  |    |
| Solid wood wet                  | ◇  |    |
| Hardwood dry                    |    | ◆  |
| Hardwood wet                    |    | ◆  |
| Glulam                          |    | ◆  |
| Clipboard                       |    | ◇  |
| MDF                             |    | ◇  |

◆ suitable ◇ partly suitable

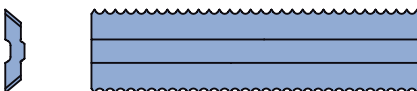


Turnblade knife VariPlan HS / HW  
resharpenable, for finish cutting of soft-  
wood and hardwood

**Cutting material:**  
HS / HW



Turnblade knife VariPlan HW Integral  
resharpenable, for pre and finish cutting  
softwood and hardwood



Turnblade knife VariPlan HW RipTec  
resharpenable, for pre-cutting softwood  
and hardwood

**Cutting material:**  
HW

## Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus

AT 103 0 03, AT 103 0 27

| SB<br>mm | H<br>mm | DIK<br>mm | SET<br>PCS | ID<br>HS | ID<br>HW<br>Microfinish |
|----------|---------|-----------|------------|----------|-------------------------|
| 50       | 16      | 3,7       | 2          | 610500 □ | 617100 □                |
| 60       | 16      | 3,7       | 2          | 610501 □ | 617101 □                |
| 80       | 16      | 3,7       | 2          | 610502 □ | 617102 □                |
| 100      | 16      | 3,7       | 2          | 610504 ● | 617104 □                |
| 120      | 16      | 3,7       | 2          | 610505 ● | 617105 □                |
| 130      | 16      | 3,7       | 2          | 610506 ● | 617106 ●                |
| 150      | 16      | 3,7       | 2          | 610509 ● | 617109 ●                |
| 166      | 16      | 3,7       | 2          | 610571 □ | 617171 ●                |
| 170      | 16      | 3,7       | 2          | 610511 ● | 617111 ●                |
| 180      | 16      | 3,7       | 2          | 610512 ● | 617112 ●                |
| 190      | 16      | 3,7       | 2          | 610514 ● | 617114 ●                |
| 210      | 16      | 3,7       | 2          | 610515 ● | 617115 ●                |
| 230      | 16      | 3,7       | 2          | 610516 ● | 617116 ●                |
| 236      | 16      | 3,7       | 2          | 610569 □ | 617169 ●                |
| 240      | 16      | 3,7       | 2          | 610518 ● | 617118 ●                |
| 256      | 16      | 3,7       | 2          | 610572 □ | 617172 ●                |
| 270      | 16      | 3,7       | 2          |          | 617165 ●                |
| 310      | 16      | 3,7       | 2          | 610522 ● | 617122 ●                |
| 330      | 16      | 3,7       | 2          |          | 617124 □                |
| 360      | 16      | 3,7       | 2          |          | 617125 □                |
| 400      | 16      | 3,7       | 2          | 610526 □ | 617126 □                |
| 410      | 16      | 3,7       | 2          | 610527 ● | 617127 □                |
| 410      | 16      | 3,7       | 3          | 610528 □ |                         |
| 420      | 16      | 3,7       | 2          | 610529 □ | 617129 □                |
| 430      | 16      | 3,7       | 2          | 610530 □ | 617130 □                |
| 500      | 16      | 3,7       | 2          | 610533 ● | 617133 □                |
| 510      | 16      | 3,7       | 4          | 610562 □ | 617162 □                |
| 520      | 16      | 3,7       | 4          | 610563 □ | 617163 □                |
| 530      | 16      | 3,7       | 2          | 610536 □ | 617136 □                |
| 540      | 16      | 3,7       | 2          | 610537 □ | 617137 □                |
| 600      | 16      | 3,7       | 2          | 610538 ● | 617138 ●                |
| 610      | 16      | 3,7       | 2          | 610539 □ | 617139 □                |
| 630      | 16      | 3,7       | 2          | 610541 ● | 617141 □                |
| 640      | 16      | 3,7       | 4          | 610564 □ | 617164 □                |

For cutterhead system VariPlan Plus

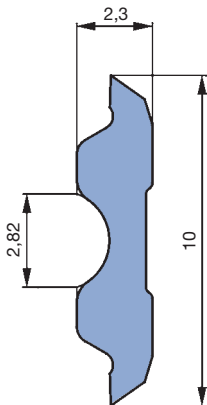
AT 103 0 23, AT 103 0 24

| SB<br>mm | H<br>mm | DIK<br>mm | SET<br>PCS | ID<br>HW<br>Integral | ID<br>HW<br>RipTec |
|----------|---------|-----------|------------|----------------------|--------------------|
| 100      | 16      | 3,7       | 2          | 611904               | 611204 □           |
| 120      | 16      | 3,7       | 2          | 611905               | 611205 □           |
| 130      | 16      | 3,7       | 2          | 611906 ●             | 611206 ●           |
| 150      | 16      | 3,7       | 2          | 611909               | 611209 ●           |
| 166      | 16      | 3,7       | 2          |                      | 611271 ●           |
| 170      | 16      | 3,7       | 2          | 611911 ●             | 611211 ●           |
| 180      | 16      | 3,7       | 2          | 611912 ●             | 611212 ●           |
| 190      | 16      | 3,7       | 2          | 611914               | 611214 ●           |
| 210      | 16      | 3,7       | 2          | 611915               | 611215 ●           |
| 230      | 16      | 3,7       | 2          | 611916               | 611216 ●           |
| 236      | 16      | 3,7       | 2          |                      | 611269 ●           |
| 240      | 16      | 3,7       | 2          | 611918 ●             | 611218 ●           |
| 270      | 16      | 3,7       | 2          | 611965               | 611265 ●           |
| 310      | 16      | 3,7       | 2          | 611922               | 611222 ●           |



| Cutting material recommendation | HS | HW |
|---------------------------------|----|----|
| Solid wood dry                  | ◆  |    |
| Solid wood wet                  | ◇  |    |
| Hardwood dry                    |    | ◆  |
| Hardwood wet                    |    | ◆  |
| Glulam                          |    | ◆  |
| Clipboard                       |    | ◇  |
| MDF                             |    | ◇  |

◆ suitable ◇ partly suitable



Turnblade knife MicroTec  
Turnblade knife TriTec

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HS

Suitable for:

#### Long planerheads

on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)

#### Cutterheads

with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

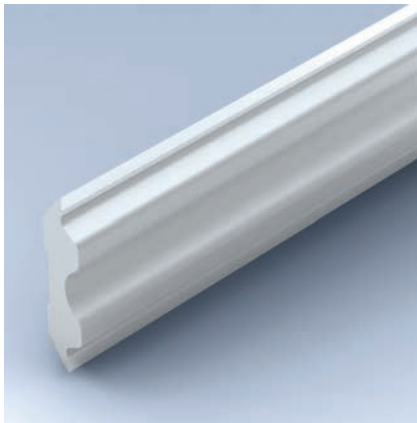
### Turnblade planing knives TriTec

For cutterhead system Torsa, HS

AT 103 0 12

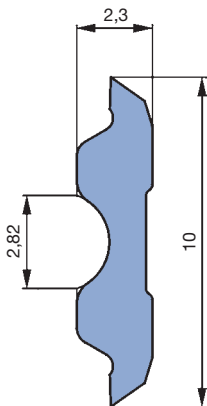
| SB  | H  | DIK | QAL | SET | ID       |
|-----|----|-----|-----|-----|----------|
| mm  | mm | mm  |     | PCS |          |
| 60  | 10 | 2,3 | HS  | 4   | 610900 □ |
| 80  | 10 | 2,3 | HS  | 4   | 610901 □ |
| 100 | 10 | 2,3 | HS  | 4   | 610902 ● |
| 110 | 10 | 2,3 | HS  | 4   | 610903 ● |
| 120 | 10 | 2,3 | HS  | 4   | 610904 ● |
| 130 | 10 | 2,3 | HS  | 4   | 610905 ● |
| 140 | 10 | 2,3 | HS  | 4   | 610906 ● |
| 150 | 10 | 2,3 | HS  | 4   | 610907 ● |
| 170 | 10 | 2,3 | HS  | 4   | 610908 ● |
| 180 | 10 | 2,3 | HS  | 4   | 610909 ● |
| 190 | 10 | 2,3 | HS  | 4   | 610910 ● |
| 200 | 10 | 2,3 | HS  | 4   | 610911 ● |
| 210 | 10 | 2,3 | HS  | 4   | 610912 ● |
| 220 | 10 | 2,3 | HS  | 4   | 610913 ● |
| 230 | 10 | 2,3 | HS  | 4   | 610914 ● |
| 240 | 10 | 2,3 | HS  | 4   | 610915 ● |
| 250 | 10 | 2,3 | HS  | 4   | 610916 ● |
| 260 | 10 | 2,3 | HS  | 4   | 610917 ● |
| 265 | 10 | 2,3 | HS  | 4   | 610918 ● |
| 270 | 10 | 2,3 | HS  | 4   | 610919 ● |
| 300 | 10 | 2,3 | HS  | 4   | 610920 ● |
| 310 | 10 | 2,3 | HS  | 4   | 610921 ● |
| 350 | 10 | 2,3 | HS  | 4   | 610922 ● |
| 360 | 10 | 2,3 | HS  | 4   | 610923 □ |
| 400 | 10 | 2,3 | HS  | 4   | 610924 ● |
| 410 | 10 | 2,3 | HS  | 4   | 610925 ● |
| 420 | 10 | 2,3 | HS  | 4   | 610926 □ |
| 430 | 10 | 2,3 | HS  | 4   | 610927 ● |
| 450 | 10 | 2,3 | HS  | 4   | 610928 □ |
| 460 | 10 | 2,3 | HS  | 4   | 610929 □ |
| 500 | 10 | 2,3 | HS  | 4   | 610930 ● |
| 510 | 10 | 2,3 | HS  | 4   | 610931 ● |
| 520 | 10 | 2,3 | HS  | 4   | 610932 ● |
| 530 | 10 | 2,3 | HS  | 4   | 610933 ● |
| 600 | 10 | 2,3 | HS  | 4   | 610934 □ |
| 610 | 10 | 2,3 | HS  | 4   | 610935 ● |
| 630 | 10 | 2,3 | HS  | 4   | 610936 ● |
| 640 | 10 | 2,3 | HS  | 4   | 610937 ● |
| 660 | 10 | 2,3 | HS  | 4   | 610938 ● |
| 710 | 10 | 2,3 | HS  | 4   | 610939 ● |
| 740 | 10 | 2,3 | HS  | 4   | 610940 □ |
| 810 | 10 | 2,3 | HS  | 4   | 610941 ● |

Further dimensions on request.



| Cutting material recommendation | HS | HW |
|---------------------------------|----|----|
| Solid wood dry                  | ◆  |    |
| Solid wood wet                  | ◇  |    |
| Hardwood dry                    |    | ◆  |
| Hardwood wet                    |    | ◆  |
| Glulam                          |    | ◆  |
| Clipboard                       |    | ◇  |
| MDF                             |    | ◇  |

◆ suitable ◇ partly suitable



Turnblade knife MicroTec  
Turnblade knife TriTec

#### Cutting material:

HW

#### Note:

Knives longer than 540 mm are cut into pieces.

Suitable for:

#### Long planerheads

on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)

#### Cutterheads

with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

### Turnblade planing knives MicroTec

For cutterhead system Torsa, HW

AT 103 0 12

| SB  | H  | DIK | QAL | SET | ID       |
|-----|----|-----|-----|-----|----------|
| mm  | mm | mm  |     | PCS |          |
| 60  | 10 | 2,3 | HW  | 2   | 610950 □ |
| 80  | 10 | 2,3 | HW  | 2   | 610951 □ |
| 100 | 10 | 2,3 | HW  | 2   | 610952 □ |
| 110 | 10 | 2,3 | HW  | 2   | 610953 □ |
| 120 | 10 | 2,3 | HW  | 2   | 610954 □ |
| 130 | 10 | 2,3 | HW  | 2   | 610955 □ |
| 140 | 10 | 2,3 | HW  | 2   | 610956 □ |
| 150 | 10 | 2,3 | HW  | 2   | 610957 □ |
| 170 | 10 | 2,3 | HW  | 2   | 610958 □ |
| 180 | 10 | 2,3 | HW  | 2   | 610959 □ |
| 190 | 10 | 2,3 | HW  | 2   | 610960 □ |
| 200 | 10 | 2,3 | HW  | 2   | 610961 □ |
| 210 | 10 | 2,3 | HW  | 2   | 610962 □ |
| 220 | 10 | 2,3 | HW  | 2   | 610963 □ |
| 230 | 10 | 2,3 | HW  | 2   | 610964 □ |
| 240 | 10 | 2,3 | HW  | 2   | 610965 □ |
| 250 | 10 | 2,3 | HW  | 2   | 610966 □ |
| 260 | 10 | 2,3 | HW  | 2   | 610967 □ |
| 265 | 10 | 2,3 | HW  | 2   | 610968 □ |
| 270 | 10 | 2,3 | HW  | 2   | 610969 □ |
| 300 | 10 | 2,3 | HW  | 2   | 610970 □ |
| 310 | 10 | 2,3 | HW  | 2   | 610971 □ |
| 350 | 10 | 2,3 | HW  | 2   | 610972 □ |
| 360 | 10 | 2,3 | HW  | 2   | 610973 □ |
| 400 | 10 | 2,3 | HW  | 2   | 610974 □ |
| 410 | 10 | 2,3 | HW  | 2   | 610975 □ |
| 420 | 10 | 2,3 | HW  | 2   | 610976 □ |
| 430 | 10 | 2,3 | HW  | 2   | 610977 □ |
| 450 | 10 | 2,3 | HW  | 2   | 610978 □ |
| 460 | 10 | 2,3 | HW  | 2   | 610979 □ |
| 500 | 10 | 2,3 | HW  | 2   | 610980 □ |
| 510 | 10 | 2,3 | HW  | 2   | 610981 □ |
| 520 | 10 | 2,3 | HW  | 2   | 610982 □ |
| 530 | 10 | 2,3 | HW  | 2   | 610983 □ |

Further dimensions on request.



#### Turnblade planing knives Centrolock

For cutterhead system Centrolock / Easylock

AT 103 0 13

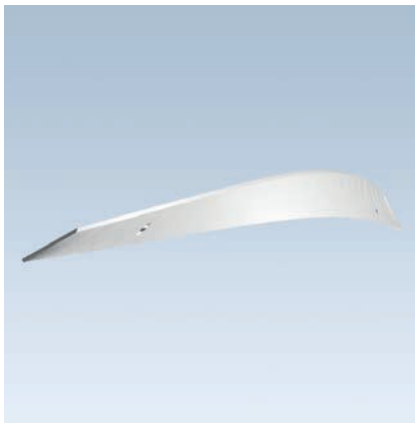
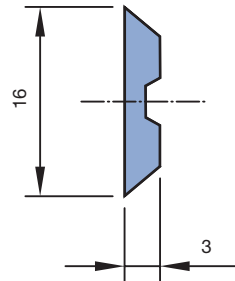
| SB<br>mm | H<br>mm | DIK<br>mm | SET<br>PCS | ID<br>HS | ID<br>HW | ID<br>MC |
|----------|---------|-----------|------------|----------|----------|----------|
| 60       | 16      | 3         | 2          | 611801 ● | 611861 ● | 611831 ● |
| 80       | 16      | 3         | 2          | 611802 ● | 611862 ● | 611832 ● |
| 100      | 16      | 3         | 2          | 611803 ● | 611863 ● | 611833 ● |
| 130      | 16      | 3         | 2          | 611804 ● | 611864 ● | 611834 ● |
| 150      | 16      | 3         | 2          | 611805 ● | 611865 ● | 611835 ● |
| 170      | 16      | 3         | 2          | 611806 ● | 611866 ● | 611836 ● |
| 180      | 16      | 3         | 2          | 611807 ● | 611867 ● | 611837 ● |
| 190      | 16      | 3         | 2          | 611808 ● | 611868 ● | 611838 ● |
| 230      | 16      | 3         | 2          | 611809 ● | 611869 ● | 611839 ● |
| 240      | 16      | 3         | 2          | 611810 ● | 611870 ● | 611840 ● |
| 260      | 16      | 3         | 2          | 611811 ● | 611871 ● | 611841 ● |
| 270      | 16      | 3         | 2          | 611812 ● | 611872 ● | 611842 ● |
| 285      | 16      | 3         | 2          | 611817 ● | 611877 ● | 611847   |
| 310      | 16      | 3         | 2          | 611813 ● | 611873 ● | 611843 ● |
| 460      | 16      | 3         | 2          | 611814 ● |          |          |

| Cutting material recommendation | HS | MC | HW |
|---------------------------------|----|----|----|
| Solid wood dry                  | ◆  | ◆  |    |
| Solid wood wet                  | ◇  | ◆  |    |
| Hardwood dry                    |    | ◇  | ◆  |
| Hardwood wet                    |    | ◆  | ◆  |
| Glulam                          |    | ◆  | ◆  |
| Clipboard                       |    |    | ◇  |
| MDF                             |    |    | ◇  |

◆ suitable ◇ partly suitable

**Cutting material:**

HS / MC / HW



#### Spiral planer knife

One-way knife for spiral long planerhead

TM 101 0

| BEZ                      | SB<br>mm | QAL | ID       |
|--------------------------|----------|-----|----------|
| HS-Spiral knife, one-way | 410      | HS  | 006841 ● |
| HS-Spiral knife, one-way | 420      | HS  | 006910   |
| HS-Spiral knife, one-way | 510      | HS  | 006842 ● |
| HS-Spiral knife, one-way | 520      | HS  | 006911 ● |
| HS-Spiral knife, one-way | 610      | HS  | 006843 ● |
| HS-Spiral knife, one-way | 630      | HS  | 006912 ● |
| HS-Spiral knife, one-way | 640      | HS  | 006844 ● |

Resharpenable knife for spiral long planerhead

TM 106 0

| BEZ                            | SB<br>mm | QAL | ID       |
|--------------------------------|----------|-----|----------|
| HS-Spiral knife, resharpenable | 410      | HS  | 006828 ● |
| HS-Spiral knife, resharpenable | 420      | HS  | 006907   |
| HS-Spiral knife, resharpenable | 510      | HS  | 006829 ● |
| HS-Spiral knife, resharpenable | 520      | HS  | 006908   |
| HS-Spiral knife, resharpenable | 610      | HS  | 006830 ● |
| HS-Spiral knife, resharpenable | 630      | HS  | 006909 ● |
| HS-Spiral knife, resharpenable | 640      | HS  | 006831 ● |

**Cutting material:**

HS



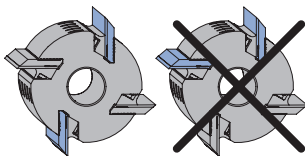
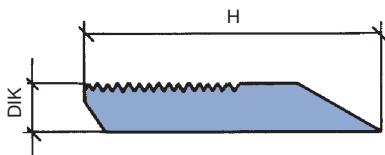
| Cutting material recommendation    | HS | MC 33 |
|------------------------------------|----|-------|
| Solid wood dry                     | ◆  | ◆     |
| Solid wood wet                     | ◇  | ◆     |
| Hardwood dry                       | ◇  | ◆     |
| Hardwood wet                       | ◇  | ◆     |
| Glulam                             |    | ◇     |
| Thermoplastics (PE, PP, PVC, etc.) | ◆  | ◆     |
| WPC (Wood-Plastic-Composite)       | ◇  | ◆     |

◆ suitable ◇ partly suitable

| H  | PT |
|----|----|
| mm | mm |
| 50 | 15 |
| 60 | 20 |
| 70 | 30 |

Table to determine maximum profile depth.

The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.



#### Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

#### Cutting material:

HS / MC33

### Blank knives with 60° back serration

#### HS and MC33 blank knives, for profile and hydro profile cutterheads

AT 103 0 28, AT 103 0 29

| SB  | H  | DIK | PT <sub>max</sub> | SET | ID       | ID       |
|-----|----|-----|-------------------|-----|----------|----------|
| mm  | mm | mm  | mm                | PCS | HS       | MC33     |
| 40  | 50 | 8   | 15                | 2   | 697500 □ | 697314 ● |
| 60  | 50 | 8   | 15                | 2   | 697501 □ | 697315 ● |
| 80  | 50 | 8   | 15                | 2   | 697502 □ | 697316 ● |
| 100 | 50 | 8   | 15                | 2   | 697503 □ | 697317 ● |
| 130 | 50 | 8   | 15                | 2   | 697504 □ | 697318 ● |
| 150 | 50 | 8   | 15                | 2   | 697505 □ | 697319 ● |
| 170 | 50 | 8   | 15                | 2   | 697506 □ | 697320 ● |
| 180 | 50 | 8   | 15                | 2   | 697507 □ | 697321 □ |
| 190 | 50 | 8   | 15                | 2   | 697508 □ | 697322 □ |
| 210 | 50 | 8   | 15                | 2   | 697509 □ | 697323 □ |
| 230 | 50 | 8   | 15                | 2   | 697510 □ | 697324 ● |
| 240 | 50 | 8   | 15                | 2   | 697511 □ | 697325 ● |
| 260 | 50 | 8   | 15                | 2   | 697512 □ | 697326 □ |
| 270 | 50 | 8   | 15                | 2   | 697513 □ | 697327 □ |
| 310 | 50 | 8   | 15                | 2   | 697514 □ | 697328 ● |
| 40  | 60 | 8   | 20                | 2   | 697515 □ | 697329 ● |
| 60  | 60 | 8   | 20                | 2   | 697516 □ | 697330 ● |
| 80  | 60 | 8   | 20                | 2   | 697517 □ | 697331 ● |
| 100 | 60 | 8   | 20                | 2   | 697518 □ | 697332 ● |
| 130 | 60 | 8   | 20                | 2   | 697519 □ | 697333 ● |
| 150 | 60 | 8   | 20                | 2   | 697520 □ | 697334 ● |
| 170 | 60 | 8   | 20                | 2   | 697521 □ | 697335 ● |
| 180 | 60 | 8   | 20                | 2   | 697522 □ | 697336 □ |
| 190 | 60 | 8   | 20                | 2   | 697523 □ | 697337 □ |
| 210 | 60 | 8   | 20                | 2   | 697524 □ | 697338 □ |
| 230 | 60 | 8   | 20                | 2   | 697525 □ | 697339 ● |
| 240 | 60 | 8   | 20                | 2   | 697526 □ | 697340 ● |
| 260 | 60 | 8   | 20                | 2   | 697527 □ | 697341 □ |
| 270 | 60 | 8   | 20                | 2   | 697528 □ | 697342 □ |
| 310 | 60 | 8   | 20                | 2   | 697529 □ | 697343 ● |
| 40  | 70 | 8   | 30                | 2   | 697530 □ | 697344 ● |
| 60  | 70 | 8   | 30                | 2   | 697531 □ | 697345 ● |
| 80  | 70 | 8   | 30                | 2   | 697532 □ | 697346 ● |
| 100 | 70 | 8   | 30                | 2   | 697533 □ | 697347 ● |
| 130 | 70 | 8   | 30                | 2   | 697534 □ | 697348 ● |
| 150 | 70 | 8   | 30                | 2   | 697535 □ | 697349 ● |
| 170 | 70 | 8   | 30                | 2   | 697536 □ | 697350 ● |
| 180 | 70 | 8   | 30                | 2   | 697537 □ | 697351 ● |
| 190 | 70 | 8   | 30                | 2   | 697538 □ | 697352 □ |
| 210 | 70 | 8   | 30                | 2   | 697539 □ | 697353 □ |
| 230 | 70 | 8   | 30                | 2   | 697540 □ | 697354 □ |
| 240 | 70 | 8   | 30                | 2   | 697541 □ | 697355 ● |
| 260 | 70 | 8   | 30                | 2   | 697542 □ | 697356 □ |
| 270 | 70 | 8   | 30                | 2   | 697543 □ | 697357 □ |
| 310 | 70 | 8   | 30                | 2   | 697544 □ | 697358 □ |

MC33 blank knife set of the same weight.

#### HS and MC33 blank knives for cutting to individual cutting width

TC 110 0, TC 110 0 03

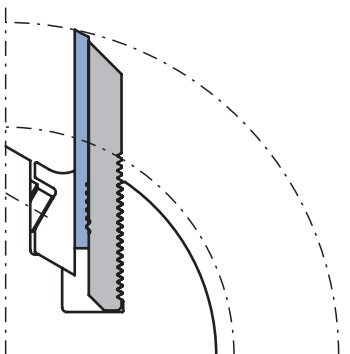
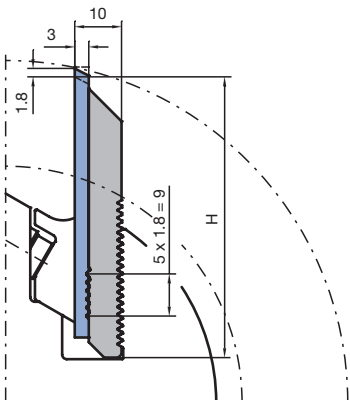
| SB  | H    | DIK | PT <sub>max</sub> | ID       | ID       |
|-----|------|-----|-------------------|----------|----------|
| mm  | mm   | mm  | mm                | HS       | MC33     |
| 650 | 38,1 | 8   | 5                 | 635003 □ | 635206 □ |
| 650 | 45   | 8   | 10                | 635004 □ | 635207 □ |
| 650 | 50   | 8   | 15                | 635000 ● | 635203 □ |
| 650 | 60   | 8   | 20                | 635001 ● | 635204 □ |
| 650 | 70   | 8   | 30                | 635002 ● | 635205 □ |

ID = 1 piece.



| Cutting material recommendation    | HW-30F jointable | HW-10F not jointable |
|------------------------------------|------------------|----------------------|
| Solid wood dry                     | ◆                |                      |
| Solid wood wet                     |                  |                      |
| Hardwood dry                       | ◆                | ◆                    |
| Hardwood wet                       |                  | ◇                    |
| Glulam                             | ◇                | ◆                    |
| Chipboard                          |                  | ◆                    |
| MDF                                | ◆                | ◆                    |
| Thermoplastics (PE, PP, PVC, etc.) | ◆                | ◆                    |
| WPC (Wood-Plastic-Composite)       | ◆                | ◆                    |

◆ suitable ◇ partly suitable



### Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 15 mm

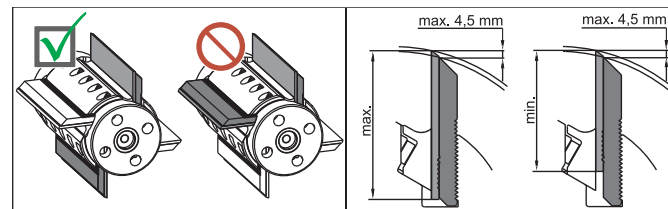
AT 103 0 26, AT 107 0 26

| SB mm | H mm | DIK mm | PT <sub>max</sub> mm | SET PCS | QAL    | ID Blank knife set | ID Blank knife set with backing plate |
|-------|------|--------|----------------------|---------|--------|--------------------|---------------------------------------|
| 40    | 50   | 10     | 15                   | 2       | HW-30F | 696642 ●           | 697842 ●                              |
| 60    | 50   | 10     | 15                   | 2       | HW-30F | 696643 ●           | 697843 ●                              |
| 80    | 50   | 10     | 15                   | 2       | HW-30F | 696644 ●           | 697844 ●                              |
| 100   | 50   | 10     | 15                   | 2       | HW-30F | 696645 ●           | 697845 ●                              |
| 130   | 50   | 10     | 15                   | 2       | HW-30F | 696646 ●           | 697846 ●                              |
| 150   | 50   | 10     | 15                   | 2       | HW-30F | 696647 ●           | 697847 ●                              |
| 170   | 50   | 10     | 15                   | 2       | HW-30F | 696648 □           | 697848 □                              |
| 180   | 50   | 10     | 15                   | 2       | HW-30F | 696649 □           | 697849 □                              |
| 190   | 50   | 10     | 15                   | 2       | HW-30F | 696650 □           | 697850 □                              |
| 210   | 50   | 10     | 15                   | 2       | HW-30F | 696651 □           | 697851 □                              |
| 230   | 50   | 10     | 15                   | 2       | HW-30F | 696652 □           | 697852 □                              |
| 240   | 50   | 10     | 15                   | 2       | HW-30F | 696653 ●           | 697853 ●                              |
| 270   | 50   | 10     | 15                   | 2       | HW-30F | 696654 □           | 697854 □                              |
| 310   | 50   | 10     | 15                   | 2       | HW-30F | 696655 ●           | 697855 ●                              |
| 40    | 50   | 10     | 15                   | 2       | HW-10F | 696628 ●           | 697828 ●                              |
| 60    | 50   | 10     | 15                   | 2       | HW-10F | 696629 ●           | 697829 ●                              |
| 80    | 50   | 10     | 15                   | 2       | HW-10F | 696630 ●           | 697830 ●                              |
| 100   | 50   | 10     | 15                   | 2       | HW-10F | 696631 ●           | 697831 ●                              |
| 130   | 50   | 10     | 15                   | 2       | HW-10F | 696632 ●           | 697832 ●                              |
| 150   | 50   | 10     | 15                   | 2       | HW-10F | 696633 ●           | 697833 ●                              |
| 170   | 50   | 10     | 15                   | 2       | HW-10F | 696634 □           | 697834 □                              |
| 180   | 50   | 10     | 15                   | 2       | HW-10F | 696635 □           | 697835 □                              |
| 190   | 50   | 10     | 15                   | 2       | HW-10F | 696636 □           | 697836 □                              |
| 210   | 50   | 10     | 15                   | 2       | HW-10F | 696637 □           | 697837 □                              |
| 230   | 50   | 10     | 15                   | 2       | HW-10F | 696638 □           | 697838 □                              |
| 240   | 50   | 10     | 15                   | 2       | HW-10F | 696639 ●           | 697839 ●                              |
| 270   | 50   | 10     | 15                   | 2       | HW-10F | 696640 □           | 697840 □                              |
| 310   | 50   | 10     | 15                   | 2       | HW-10F | 696641 ●           | 697841 ●                              |

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

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



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

**Attention:**

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

**For profile and hydro profile cutterheads, PT 20 mm**

AT 103 0 26, AT 107 0 26

| SB<br>mm | H<br>mm | DIK<br>mm | PT <sub>max</sub><br>mm | SET<br>PCS | QAL    | ID<br>Blank<br>knife set | ID<br>Blank<br>knife<br>set with<br>backing<br>plate |
|----------|---------|-----------|-------------------------|------------|--------|--------------------------|------------------------------------------------------|
| 40       | 60      | 10        | 20                      | 2          | HW-30F | 696670 ●                 | 697870 ●                                             |
| 60       | 60      | 10        | 20                      | 2          | HW-30F | 696671 ●                 | 697871 ●                                             |
| 80       | 60      | 10        | 20                      | 2          | HW-30F | 696672 ●                 | 697872 ●                                             |
| 100      | 60      | 10        | 20                      | 2          | HW-30F | 696673 ●                 | 697873 ●                                             |
| 130      | 60      | 10        | 20                      | 2          | HW-30F | 696674 ●                 | 697874 ●                                             |
| 150      | 60      | 10        | 20                      | 2          | HW-30F | 696675 ●                 | 697875 ●                                             |
| 170      | 60      | 10        | 20                      | 2          | HW-30F | 696676 □                 | 697876 □                                             |
| 180      | 60      | 10        | 20                      | 2          | HW-30F | 696677 □                 | 697877 □                                             |
| 190      | 60      | 10        | 20                      | 2          | HW-30F | 696678 □                 | 697878 □                                             |
| 210      | 60      | 10        | 20                      | 2          | HW-30F | 696679 □                 | 697879 □                                             |
| 230      | 60      | 10        | 20                      | 2          | HW-30F | 696680 □                 | 697880 □                                             |
| 240      | 60      | 10        | 20                      | 2          | HW-30F | 696681 ●                 | 697881 ●                                             |
| 40       | 60      | 10        | 20                      | 2          | HW-10F | 696656 ●                 | 697856 ●                                             |
| 60       | 60      | 10        | 20                      | 2          | HW-10F | 696657 ●                 | 697857 ●                                             |
| 80       | 60      | 10        | 20                      | 2          | HW-10F | 696658 ●                 | 697858 ●                                             |
| 100      | 60      | 10        | 20                      | 2          | HW-10F | 696659 ●                 | 697859 ●                                             |
| 130      | 60      | 10        | 20                      | 2          | HW-10F | 696660 ●                 | 697860 ●                                             |
| 150      | 60      | 10        | 20                      | 2          | HW-10F | 696661 ●                 | 697861 ●                                             |
| 170      | 60      | 10        | 20                      | 2          | HW-10F | 696662 □                 | 697862 □                                             |
| 180      | 60      | 10        | 20                      | 2          | HW-10F | 696663 □                 | 697863 □                                             |
| 190      | 60      | 10        | 20                      | 2          | HW-10F | 696664 □                 | 697864 □                                             |
| 210      | 60      | 10        | 20                      | 2          | HW-10F | 696665 □                 | 697865 □                                             |
| 230      | 60      | 10        | 20                      | 2          | HW-10F | 696666 □                 | 697866 □                                             |
| 240      | 60      | 10        | 20                      | 2          | HW-10F | 696667 ●                 | 697867 ●                                             |

**For profile and hydro profile cutterheads, PT 30 mm**

AT 103 0 26, AT 107 0 26

| SB<br>mm | H<br>mm | DIK<br>mm | PT <sub>max</sub><br>mm | SET<br>PCS | QAL    | ID<br>Blank<br>knife set | ID<br>Blank<br>knife<br>set with<br>backing<br>plate |
|----------|---------|-----------|-------------------------|------------|--------|--------------------------|------------------------------------------------------|
| 40       | 70      | 10        | 30                      | 2          | HW-30F | 696691 ●                 | 697891 ●                                             |
| 60       | 70      | 10        | 30                      | 2          | HW-30F | 696692 ●                 | 697892 ●                                             |
| 80       | 70      | 10        | 30                      | 2          | HW-30F | 696693 ●                 | 697893 ●                                             |
| 100      | 70      | 10        | 30                      | 2          | HW-30F | 696694 ●                 | 697894 ●                                             |
| 130      | 70      | 10        | 30                      | 2          | HW-30F | 696695 ●                 | 697895 ●                                             |
| 150      | 70      | 10        | 30                      | 2          | HW-30F | 696696 ●                 | 697896 ●                                             |
| 40       | 70      | 10        | 30                      | 2          | HW-10F | 696684 ●                 | 697884 ●                                             |
| 60       | 70      | 10        | 30                      | 2          | HW-10F | 696685 ●                 | 697885 ●                                             |
| 80       | 70      | 10        | 30                      | 2          | HW-10F | 696686 ●                 | 697886 ●                                             |
| 100      | 70      | 10        | 30                      | 2          | HW-10F | 696687 ●                 | 697887 ●                                             |
| 130      | 70      | 10        | 30                      | 2          | HW-10F | 696688 ●                 | 697888 ●                                             |
| 150      | 70      | 10        | 30                      | 2          | HW-10F | 696689 ●                 | 697889 ●                                             |



**Workpiece material:**  
Softwood

**Cutting material:**  
SP

For multi-purpose profile cutterheads:  
WM 502 2  
WM 510 1 01  
WM 510 1 02  
Profiles to scale 1:1 can be found on the  
Leitz Homepage [www.leitz.org](http://www.leitz.org)

### Profile knives for multi-purpose cutterheads

#### Knives

TM 135 1

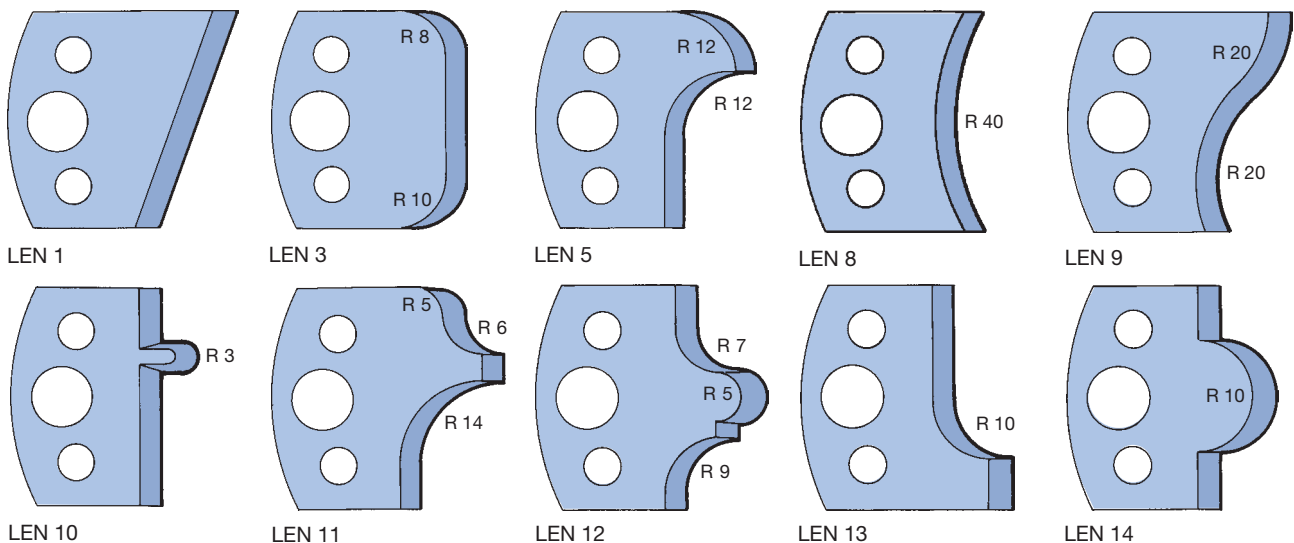
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|-------------|----------|
| 1           | 026101 ● |
| 3           | 026103 ● |
| 5           | 026105 ● |
| 8           | 026108 ● |
| 9           | 026109 ● |
| 10          | 026110 ● |
| 11          | 026111 ● |
| 12          | 026112 ● |
| 13          | 026113 ● |
| 14          | 026114 ● |
| 15          | 026115 ● |
| 16          | 026116 ● |
| 17          | 026117 ● |
| 18          | 026118 ● |
| 19          | 026119 ● |
| 20          | 026120 ● |
| 21          | 026121 ● |
| 22          | 026122 ● |
| 31          | 026131 ● |
| 34          | 026134 ● |
| 35          | 026135 ● |
| 36          | 026136 ● |
| 39          | 026177 ● |
| 41          | 026179 ● |
| 45          | 026183 ● |
| 47          | 026185 ● |
| 48          | 026186 ● |
| 50          | 026188 ● |
| 55          | 026193 ● |
| 57          | 026195 ● |
| 58          | 026196 ● |
| 66          | 026254 ● |
| 68          | 026256 ● |
| 75          | 026263 ● |
| 76          | 026264 ● |
| 83          | 690000 ● |
| 84          | 690001 ● |
| 91          | 690003 ● |
| 97          | 690005 ● |
| 127         | 690007 ● |

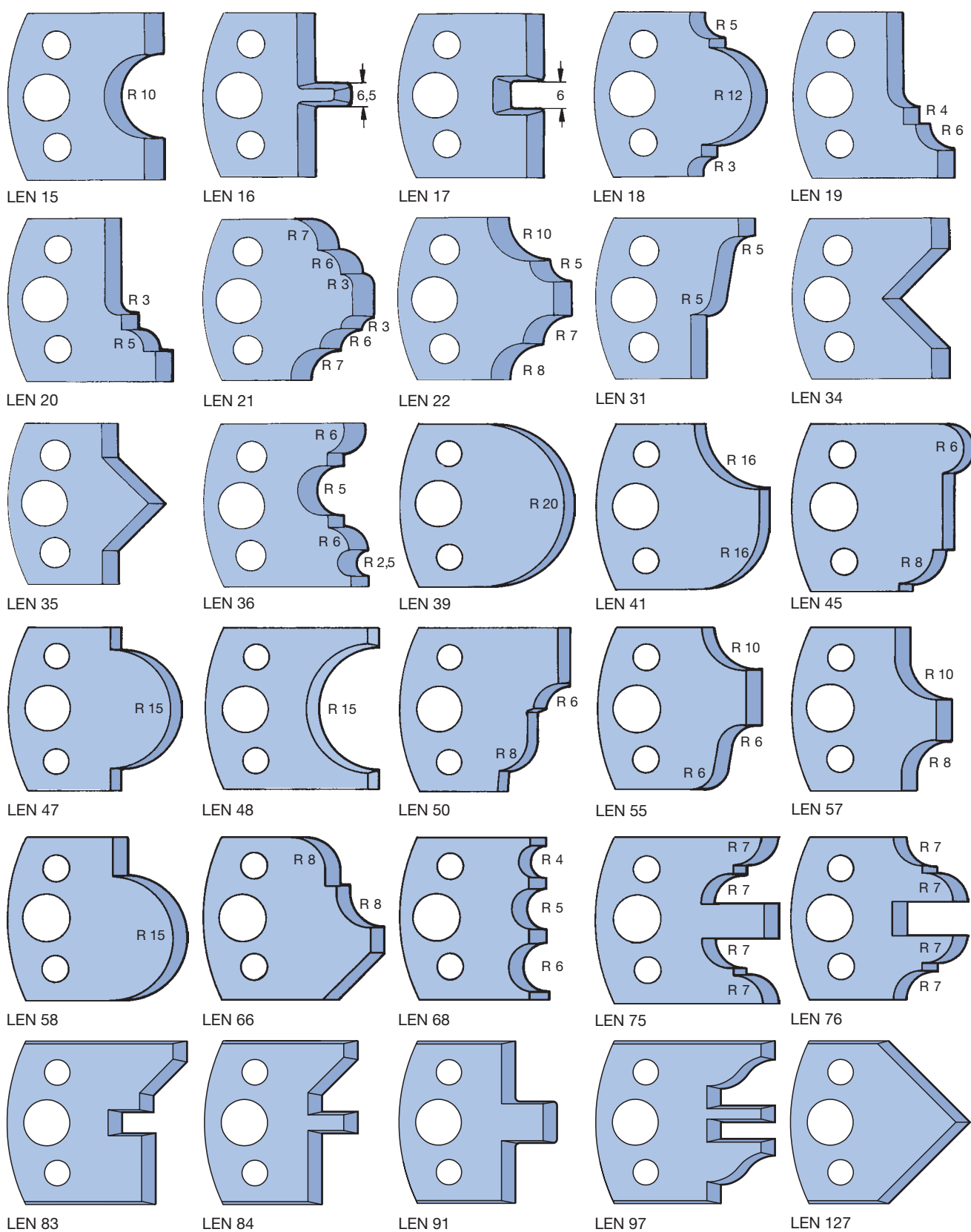
#### Limitors

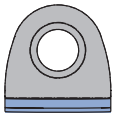
TA 300 1

| LEN Profile | ID       |
|-------------|----------|
| 1           | 026301 ● |
| 3           | 026303 ● |
| 5           | 026305 ● |
| 8           | 026308 ● |
| 9           | 026309 ● |
| 10          | 026310 ● |
| 11          | 026311 ● |
| 12          | 026312 ● |
| 13          | 026313 ● |
| 14          | 026314 ● |
| 15          | 026315 ● |
| 16          | 026316 ● |
| 17          | 026317 ● |
| 18          | 026318 ● |
| 19          | 026319 ● |
| 20          | 026320 ● |
| 21          | 026321 ● |
| 22          | 026322 ● |
| 31          | 026331 ● |
| 34          | 026334 ● |
| 35          | 026335 ● |
| 36          | 026336 ● |
| 39          | 026384 ● |
| 41          | 026386 ● |
| 45          | 026390 ● |
| 47          | 026392 ● |
| 48          | 026393 ● |
| 50          | 026395 ● |
| 55          | 026400 ● |
| 57          | 026402 ● |
| 58          | 026403 ● |
| 66          | 026411 ● |
| 68          | 026413 ● |
| 75          | 026420 ● |
| 76          | 026421 ● |
| 83          | 695000 ● |
| 84          | 695001 ● |
| 91          | 695003 ● |
| 97          | 695005 ● |
| 127         | 695007 ● |

Sold in pairs only.







### WhisperCut DP edges for hybrid tools

WhisperCut DP edges; suitable for the combination with the tool systems  
ProfilCut, ProFix, turnblade or HeliPlan

TM 160 0 02, TM 160 0 13

| BEM                      | SB<br>mm | R<br>mm | FAW<br>° | QAL | ID              |
|--------------------------|----------|---------|----------|-----|-----------------|
| Jointing                 | 14       |         |          | DP  | <b>091052</b> ● |
| Jointing of glued joint* | 14       |         |          | DP  | <b>091056</b> ● |
| Radius on bottom         | 14       | 1,0     |          | DP  | <b>091057</b>   |
| Radius on top            | 14       | 1,0     |          | DP  | <b>091058</b>   |
| Radius on bottom         | 14       | 1,5     |          | DP  | <b>091059</b>   |
| Radius on top            | 14       | 1,5     |          | DP  | <b>091060</b>   |
| Radius on bottom         | 14       | 2,0     |          | DP  | <b>091061</b>   |
| Radius on top            | 14       | 2,0     |          | DP  | <b>091062</b>   |
| Bevel on bottom          | 14       |         | 45       | DP  | <b>091063</b>   |
| Bevel on top             | 14       |         | 45       | DP  | <b>091064</b>   |

\* = If the knife mounted has a 0° cutting area bevel, it can be used **preferably for glued joints** due to the crown.

### Replaceable knives for minifinger joint cutterheads

Replaceable knives for minifinger joint cutterheads

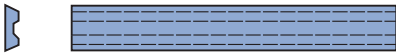
AT 103 0 16, AT 103 0 17, AT 103 0 18

| QAL | Cut-off<br>saws | Tip gap  | Profile<br>knife | ZL<br>mm | TG<br>mm | ZA<br>PCS | SET<br>PCS | ID              |
|-----|-----------------|----------|------------------|----------|----------|-----------|------------|-----------------|
| HW  | without         | standard | right            | 10/10    | 3,8      | 4         | 2          | <b>611300</b> □ |
| HW  | without         | standard | left             | 10/10    | 3,8      | 4         | 2          | <b>611302</b> □ |
| MC  | with            | standard | right            | 10/11    | 3,8      | 4         | 2          | <b>611450</b> □ |
| MC  | with            | standard | left             | 20/22    | 6,2      | 3         | 2          | <b>611451</b> □ |
| MC  | with            | standard | left             | 10/11    | 3,8      | 4         | 2          | <b>611458</b> □ |
| MC  | with            | standard | right            | 20/22    | 6,2      | 3         | 2          | <b>611461</b> □ |
| MC  | with            | standard | right            | 10/11    | 3,8      | 4         | 3          | <b>611550</b> □ |
| MC  | with            | standard | left             | 10/11    | 3,8      | 4         | 3          | <b>611558</b> □ |
| MC  | with            | standard | right            | 15/16,5  | 3,8      | 4         | 3          | <b>611559</b> □ |
| MC  | with            | standard | left             | 15/16,5  | 3,8      | 4         | 3          | <b>611560</b> □ |

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.8 For portable planers and semi-stationary machines



Turnblade knife

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

##### Cutting material:

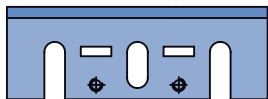
HW

#### Planer knives for portable planers

##### Turnblade knives HW

TM 410 0

| Machine                                                        | SB<br>mm | H<br>mm | DIK<br>mm | QAL | ID              |
|----------------------------------------------------------------|----------|---------|-----------|-----|-----------------|
| AEG, Bosch, Festool, Haffner, Holz-Her, Mafell, Metabo, Scheer | 75,5     | 5,5     | 1,1       | HW  | <b>005064 •</b> |
| Elu                                                            | 80,5     | 5,9     | 1,2       | HW  | <b>005131 •</b> |
| AEG, Black & Decker, DeWalt, Elu, Mafell, Makita, Metabo       | 82       | 5,5     | 1,1       | HW  | <b>005066 •</b> |



Makita

##### Planer knife HS / HW

TM 105 0

| Machine | SB<br>mm | H<br>mm | DIK<br>mm | ID<br>HS        | ID<br>HW        |
|---------|----------|---------|-----------|-----------------|-----------------|
| Makita  | 82       | 29      | 3         | <b>027530 •</b> | <b>027598 •</b> |

##### Workpiece material:

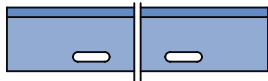
Softwood and hardwood, chipboard and fibre materials, glulam

##### Cutting material:

HS / HW



Kity



Metabo



Scheppach

#### Planer knives for semi-stationary machines

##### HS

TM 100 0, TM 105 0

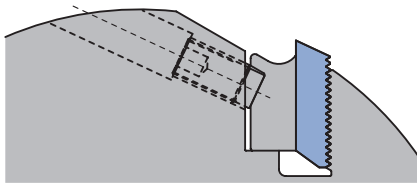
| Machine   | SB<br>mm | H<br>mm | DIK<br>mm | QAL | ID              |
|-----------|----------|---------|-----------|-----|-----------------|
| Kity      | 260      | 20      | 2,5       | HS  | <b>027154 •</b> |
| Metabo    | 263      | 20      | 3         | HS  | <b>027157 •</b> |
| Scheppach | 260      | 18      | 3         | HS  | <b>027158 •</b> |

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

##### Cutting material:

HS

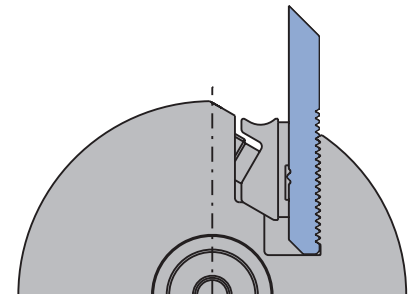


### Back-serrated profile cutterheads

Filler pieces for knife thickness 8 - 10 mm

TD 510 0 05

| BEZ          | for SB<br>mm | ID       |
|--------------|--------------|----------|
| Filler piece | 40           | 005305 ● |
| Filler piece | 60           | 005306 ● |
| Filler piece | 80           | 005307 ● |
| Filler piece | 100          | 005308 ● |
| Filler piece | 130          | 005310 ● |
| Filler piece | 150          | 005311 ● |
| Filler piece | 170          | 620770 ● |
| Filler piece | 180          | 005312 ● |
| Filler piece | 190          | 620772 ● |
| Filler piece | 210          | 620773 ● |
| Filler piece | 230          | 005313 ● |
| Filler piece | 240          | 620771 ● |
| Filler piece | 270          | 620774 ● |
| Filler piece | 310          | 620775 ● |



Filler pieces for profiling of PKS-system backing plates

TF 200 0

| BEZ          | for SB<br>mm | ID       |
|--------------|--------------|----------|
| Filler piece | 40           | 008355 □ |
| Filler piece | 80           | 008356 □ |
| Filler piece | 130          | 008357 □ |
| Filler piece | 240          | 008221 ● |

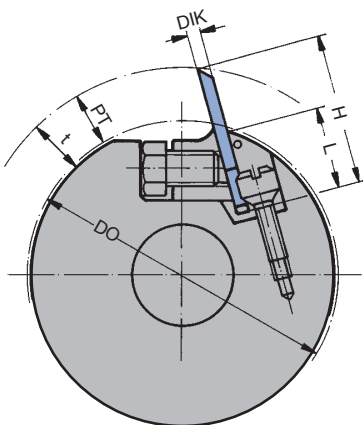
Profile cutterhead  
PKS-system

### Profile cutterhead WM 502 2

Profile cutterhead WM 502 2

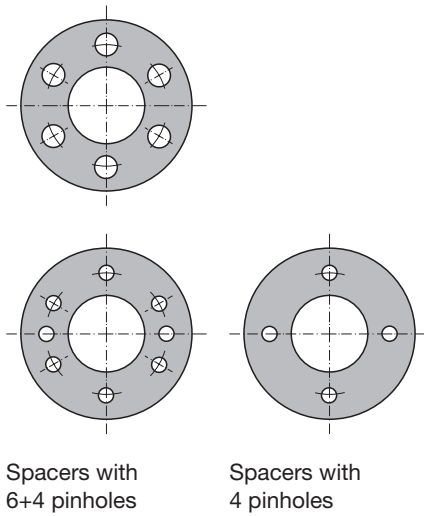
TC 105 0

| BEZ                 | SB<br>mm | QAL | ID       |
|---------------------|----------|-----|----------|
| Profile blank knife | 40       | HS  | 007284 ● |
| Profile blank knife | 50       | HS  | 007285 ● |
| Profile blank knife | 60       | HS  | 007286 ● |



**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
SP / HS

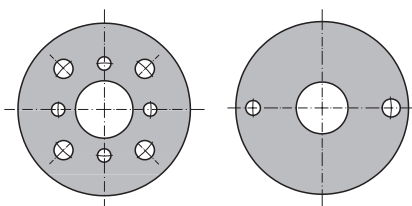


## With pinholes

Spacers with 1 pitch  
TR 100 0

| D<br>mm | B<br>mm | BO<br>mm | NLA<br>mm | ID       |
|---------|---------|----------|-----------|----------|
| 45      | 3       | 20       | 4/5,5/32  | 028088 ● |
| 45      | 5       | 20       | 4/5,5/32  | 028089 ● |
| 45      | 10      | 20       | 4/5,5/32  | 028090 ● |
| 45      | 20      | 20       | 4/5,5/32  | 028639 ● |
| 45      | 0,1     | 20       | 4/5,5/32  | 029208 ● |
| 45      | 0,3     | 20       | 4/5,5/32  | 029209 ● |
| 45      | 0,5     | 20       | 4/5,5/32  | 029210 ● |
| 45      | 1       | 20       | 4/5,5/32  | 029211 ● |
| 60      | 0,1     | 30       | 4/7/48    | 029237 ● |
| 60      | 0,3     | 30       | 6/7/48    | 029238 ● |
| 60      | 0,5     | 30       | 6/7/48    | 029239 ● |
| 60      | 1       | 30       | 6/7/48    | 029240 ● |
| 60      | 3       | 30       | 6/7/48    | 028580 ● |
| 60      | 4       | 30       | 6/7/48    | 028581 ● |
| 60      | 5       | 30       | 6/7/48    | 028582 ● |
| 60      | 6       | 30       | 6/7/48    | 028583 ● |
| 60      | 7       | 30       | 6/7/48    | 028584 ● |
| 60      | 8       | 30       | 6/7/48    | 028585 ● |
| 60      | 10      | 30       | 6/7/48    | 028586 ● |
| 60      | 11      | 30       | 6/7/48    | 028587 ● |
| 60      | 12      | 30       | 6/7/48    | 028588 ● |
| 60      | 15      | 30       | 6/7/48    | 028589 ● |
| 60      | 20      | 30       | 6/7/48    | 028591 ● |
| 70      | 0,1     | 30       | 6/7/58    | 027952 ● |
| 70      | 0,3     | 30       | 6/7/58    | 027953 ● |
| 70      | 0,5     | 30       | 6/7/58    | 027954 ● |
| 70      | 1       | 30       | 6/7/58    | 027955 ● |
| 70      | 3       | 30       | 6/7/58    | 028599 ● |
| 70      | 4       | 30       | 6/7/58    | 028600 ● |
| 70      | 5       | 30       | 6/7/58    | 028601 ● |
| 70      | 10      | 30       | 6/7/58    | 028605 ● |
| 70      | 20      | 30       | 6/7/58    | 028608 ● |
| 60      | 0,1     | 35       | 6/7/48    | 027930 ● |
| 60      | 0,3     | 35       | 6/7/48    | 027931 ● |
| 60      | 0,5     | 35       | 6/7/48    | 027932 ● |
| 60      | 1       | 35       | 6/7/48    | 027933 ● |
| 60      | 3       | 35       | 6/7/48    | 028592 ● |
| 60      | 5       | 35       | 6/7/48    | 028594 ● |
| 60      | 10      | 35       | 6/7/48    | 028598 ● |
| 62      | 0,1     | 35       | 4/7/52    | 028667 ● |
| 62      | 0,3     | 35       | 4/7/52    | 028668 ● |
| 62      | 0,5     | 35       | 4/7/52    | 028669 ● |
| 62      | 1       | 35       | 4/7/52    | 028670 ● |
| 64      | 3       | 35       | 4/7/52    | 028671 ● |
| 64      | 4       | 35       | 4/7/52    | 028672 ● |
| 64      | 5       | 35       | 4/7/52    | 028673 ● |
| 70      | 0,1     | 35       | 6/7/58    | 027966 ● |
| 70      | 0,3     | 35       | 6/7/58    | 027967 ● |
| 70      | 0,5     | 35       | 6/7/58    | 027968 ● |
| 70      | 1       | 35       | 6/7/58    | 027969 ● |
| 70      | 3       | 35       | 6/7/58    | 028609 ● |
| 70      | 5       | 35       | 6/7/58    | 028611 ● |
| 70      | 10      | 35       | 6/7/58    | 028615 ● |
| 70      | 20      | 35       | 6/7/58    | 028616 ● |
| 70      | 0,1     | 40       | 6/7/58    | 027978 ● |
| 70      | 0,3     | 40       | 6/7/58    | 027979 ● |
| 70      | 0,5     | 40       | 6/7/58    | 027980 ● |
| 70      | 1       | 40       | 6/7/58    | 027981 ● |
| 70      | 3       | 40       | 6/7/58    | 028617 ● |
| 70      | 4       | 40       | 6/7/58    | 028618 ● |
| 70      | 5       | 40       | 6/7/58    | 028619 ● |
| 70      | 6       | 40       | 6/7/58    | 028620 ● |

| D<br>mm | B<br>mm | BO<br>mm | NLA<br>mm | ID       |
|---------|---------|----------|-----------|----------|
| 70      | 7       | 40       | 6/7/58    | 028621 ● |
| 70      | 8       | 40       | 6/7/58    | 028622 ● |
| 70      | 10      | 40       | 6/7/58    | 028623 ● |
| 70      | 12      | 40       | 6/7/58    | 028624 ● |
| 70      | 15      | 40       | 6/7/58    | 028625 ● |
| 70      | 20      | 40       | 6/7/58    | 028626 ● |
| 76,5    | 0,1     | 50       | 6/7/65    | 028005 ● |
| 76,5    | 0,3     | 50       | 6/7/65    | 028006 ● |
| 76,5    | 0,5     | 50       | 6/7/65    | 028007 ● |
| 76,5    | 1       | 50       | 6/7/65    | 028008 ● |
| 77      | 3       | 50       | 6/7/65    | 028627 ● |
| 77      | 4       | 50       | 6/7/65    | 028628 ● |
| 77      | 5       | 50       | 6/7/65    | 028629 ● |
| 77      | 6       | 50       | 6/7/65    | 028630 ● |
| 77      | 8       | 50       | 6/7/65    | 028631 ● |
| 77      | 10      | 50       | 6/7/65    | 028632 ● |
| 77      | 20      | 50       | 6/7/65    | 028633 ● |
| 90      | 0,1     | 60       | 6/9/75    | 028020 ● |
| 90      | 0,3     | 60       | 6/9/75    | 028021 ● |
| 90      | 0,5     | 60       | 6/9/75    | 028022 ● |
| 90      | 1       | 60       | 6/9/75    | 028023 ● |
| 90      | 3       | 60       | 6/9/75    | 028634 ● |
| 90      | 4       | 60       | 6/9/75    | 028635 ● |
| 90      | 5       | 60       | 6/9/75    | 028636 ● |
| 90      | 10      | 60       | 6/9/75    | 028637 ● |
| 90      | 20      | 60       | 6/9/75    | 028638 ● |

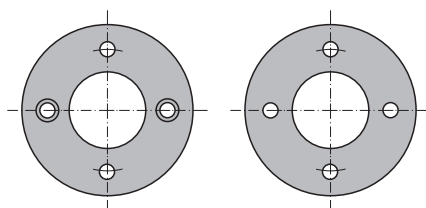
Spacers with  
4+4 pinholesSpacers with  
2 pinholes

### With pinholes

#### Spacers with different pitches

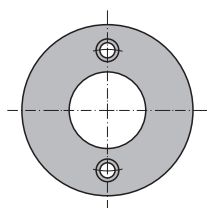
TR 100 0

| D<br>mm | B<br>mm | BO<br>mm | NLA<br>mm | ID       |
|---------|---------|----------|-----------|----------|
| 90      | 0,1     | 30       | 4/7/48    | 028422 ● |
| 90      | 0,3     | 30       | 4/10/60   | 028423 ● |
| 90      | 0,5     | 30       | 4/7/48    | 028424 ● |
| 90      | 1       | 30       | 4/10/60   | 028425 ● |
| 90      | 3       | 30       | 4/7/48    | 028426 ● |
| 90      | 5       | 30       | 4/10/60   | 028427 ● |
| 90      | 10      | 30       | 4/7/48    | 028428 ● |
| 90      | 20      | 30       | 4/10/60   | 028429 ● |
| 100     | 0,1     | 30       | 1/8,5/80  | 028029 ● |
| 100     | 0,3     | 30       | 1/10,5/80 | 028030 ● |
| 100     | 0,5     | 30       | 1/8,5/80  | 028031 ● |
| 100     | 1       | 30       | 1/10,5/80 | 028032 ● |



Spacers with  
4 pinholes (two of  
them with cylindri-  
cal countersink)

Spacers with  
4 pinholes



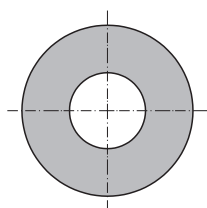
Spacers with 2 pinholes with cylindrical  
countersink

### With pinholes, aluminium

#### Aluminium spacers

TR 100 0

| D<br>mm | B<br>mm | BO<br>mm | NLA<br>mm        | BEM                                        | ID              |
|---------|---------|----------|------------------|--------------------------------------------|-----------------|
| 60      | 10      | 30       | 2/7/48<br>2/7/48 | 2 pinholes with cylindrical<br>countersink | <b>029244 •</b> |
| 64      | 5       | 35       | 4/7/52           |                                            | <b>029246 •</b> |
| 64      | 10      | 35       | 4/7/52           |                                            | <b>029247 •</b> |
| 64      | 10      | 35       | 2/7/52           | Cylindrical countersink<br>pinholes        | <b>029248 •</b> |
| 64      | 20      | 35       | 4/7/52           |                                            | <b>029249 •</b> |



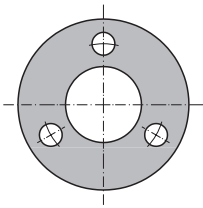
### Without pinholes

#### Without pinholes

TR 100 0

| D<br>mm | B<br>mm | BO<br>mm | ID              |
|---------|---------|----------|-----------------|
| 34      | 0,1     | 20       | <b>028400 •</b> |
| 34      | 0,3     | 20       | <b>028401 •</b> |
| 34      | 0,5     | 20       | <b>028402 •</b> |
| 34      | 1       | 20       | <b>028403 •</b> |
| 34      | 3       | 20       | <b>028404 •</b> |
| 34      | 4       | 20       | <b>028405 •</b> |
| 34      | 5       | 20       | <b>028406 •</b> |
| 50      | 0,1     | 30       | <b>027901 •</b> |
| 50      | 0,3     | 30       | <b>027902 •</b> |
| 50      | 0,5     | 30       | <b>027903 •</b> |
| 50      | 1       | 30       | <b>027904 •</b> |
| 50      | 3       | 30       | <b>027905 •</b> |
| 50      | 4       | 30       | <b>027906 •</b> |
| 50      | 5       | 30       | <b>027907 •</b> |
| 50      | 6       | 30       | <b>027908 •</b> |
| 50      | 7       | 30       | <b>027909 •</b> |
| 50      | 8       | 30       | <b>027910 •</b> |
| 50      | 10      | 30       | <b>027911 •</b> |
| 50      | 14      | 30       | <b>027912 •</b> |
| 50      | 20      | 30       | <b>027913 •</b> |
| 60      | 3       | 30       | <b>027918 •</b> |
| 60      | 4       | 30       | <b>027919 •</b> |
| 60      | 5       | 30       | <b>027920 •</b> |
| 60      | 6       | 30       | <b>027921 •</b> |
| 60      | 7       | 30       | <b>027922 •</b> |
| 60      | 8       | 30       | <b>027923 •</b> |
| 60      | 10      | 30       | <b>027924 •</b> |
| 60      | 11      | 30       | <b>027925 •</b> |
| 60      | 12      | 30       | <b>027926 •</b> |
| 60      | 15      | 30       | <b>027927 •</b> |
| 60      | 17,5    | 30       | <b>027928 •</b> |
| 60      | 20      | 30       | <b>027929 •</b> |
| 60      | 3       | 35       | <b>027934 •</b> |
| 60      | 5       | 35       | <b>027936 •</b> |
| 60      | 6       | 35       | <b>027937 •</b> |
| 60      | 7       | 35       | <b>027938 •</b> |
| 60      | 8       | 35       | <b>027939 •</b> |
| 60      | 10      | 35       | <b>027940 •</b> |

| D   | B   | BO | ID       |
|-----|-----|----|----------|
| mm  | mm  | mm |          |
| 60  | 0,1 | 40 | 027941 ● |
| 60  | 0,3 | 40 | 027942 ● |
| 60  | 0,5 | 40 | 027943 ● |
| 60  | 1   | 40 | 027944 ● |
| 60  | 3   | 40 | 027945 ● |
| 60  | 4   | 40 | 027946 ● |
| 60  | 5   | 40 | 027947 ● |
| 60  | 6   | 40 | 027948 ● |
| 60  | 7   | 40 | 027949 ● |
| 60  | 8   | 40 | 027950 ● |
| 60  | 9   | 40 | 028449 ● |
| 60  | 10  | 40 | 027951 ● |
| 70  | 3   | 30 | 027956 ● |
| 70  | 4   | 30 | 027957 ● |
| 70  | 5   | 30 | 027958 ● |
| 70  | 6   | 30 | 027959 ● |
| 70  | 7   | 30 | 027960 ● |
| 70  | 8   | 30 | 027961 ● |
| 70  | 10  | 30 | 027962 ● |
| 70  | 12  | 30 | 027963 ● |
| 70  | 15  | 30 | 027964 ● |
| 70  | 20  | 30 | 027965 ● |
| 70  | 3   | 35 | 027970 ● |
| 70  | 4   | 35 | 027971 ● |
| 70  | 5   | 35 | 027972 ● |
| 70  | 6   | 35 | 027973 ● |
| 70  | 7   | 35 | 027974 ● |
| 70  | 8   | 35 | 027975 ● |
| 70  | 10  | 35 | 027976 ● |
| 70  | 20  | 35 | 027977 ● |
| 70  | 3   | 40 | 027982 ● |
| 70  | 4   | 40 | 027983 ● |
| 70  | 5   | 40 | 027984 ● |
| 70  | 6   | 40 | 027985 ● |
| 70  | 7   | 40 | 027986 ● |
| 70  | 8   | 40 | 027987 ● |
| 70  | 10  | 40 | 027988 ● |
| 70  | 12  | 40 | 027989 ● |
| 70  | 15  | 40 | 027990 ● |
| 70  | 20  | 40 | 027991 ● |
| 70  | 0,1 | 50 | 027992 ● |
| 70  | 0,3 | 50 | 027993 ● |
| 70  | 0,5 | 50 | 027994 ● |
| 70  | 1   | 50 | 027995 ● |
| 70  | 3   | 50 | 027996 ● |
| 70  | 4   | 50 | 027997 ● |
| 70  | 5   | 50 | 027998 ● |
| 70  | 6   | 50 | 027999 ● |
| 70  | 7   | 50 | 028000 ● |
| 70  | 8   | 50 | 028001 ● |
| 70  | 10  | 50 | 028002 ● |
| 70  | 15  | 50 | 028003 ● |
| 70  | 20  | 50 | 028004 ● |
| 77  | 3   | 50 | 028009 ● |
| 77  | 4   | 50 | 028010 ● |
| 77  | 5   | 50 | 028011 ● |
| 77  | 6   | 50 | 028012 ● |
| 77  | 8   | 50 | 028013 ● |
| 77  | 10  | 50 | 028014 ● |
| 77  | 20  | 50 | 028015 ● |
| 90  | 3   | 60 | 028024 ● |
| 90  | 4   | 60 | 028025 ● |
| 90  | 5   | 60 | 028026 ● |
| 90  | 10  | 60 | 028027 ● |
| 90  | 20  | 60 | 028028 ● |
| 100 | 4   | 30 | 028033 ● |



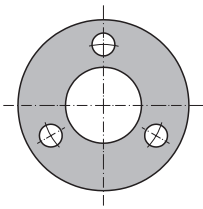
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

### Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

TR 100 0

| D  | B  | BO | NLA    | ID       |
|----|----|----|--------|----------|
| mm | mm | mm | mm     |          |
| 90 | 10 | 60 | 3/9/75 | 030684 ● |
| 90 | 15 | 60 | 3/9/75 | 030685 ● |
| 90 | 20 | 60 | 3/9/75 | 030686 ● |



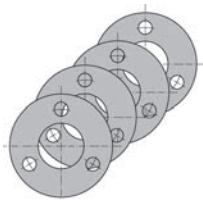
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

### High precision spacers for adjusting tongue and groove cuttersets

High precision spacers for adjusting tongue and groove cuttersets

TR 100 0

| D  | B   | BO | NLA    | ID       |
|----|-----|----|--------|----------|
| mm | mm  | mm | mm     |          |
| 90 | 3,1 | 60 | 3/9/75 | 030687 ● |
| 90 | 3,3 | 60 | 3/9/75 | 030688 ● |
| 90 | 3,5 | 60 | 3/9/75 | 030689 ● |
| 90 | 3,7 | 60 | 3/9/75 | 030690 ● |
| 90 | 3,9 | 60 | 3/9/75 | 030691 ● |
| 90 | 4,1 | 60 | 3/9/75 | 030692 ● |
| 90 | 4,3 | 60 | 3/9/75 | 030693 ● |
| 90 | 4,5 | 60 | 3/9/75 | 030694 ● |
| 90 | 4,7 | 60 | 3/9/75 | 030695 ● |
| 90 | 4,9 | 60 | 3/9/75 | 030696 ● |
| 90 | 5   | 60 | 3/9/75 | 030697 ● |
| 90 | 5,1 | 60 | 3/9/75 | 030698 ● |



AT 100 0 01

8 part spacer set with total clamping length 125 mm, surface ground face parallel, spacers black-finished, to DIN 8837

#### Set consisting of:

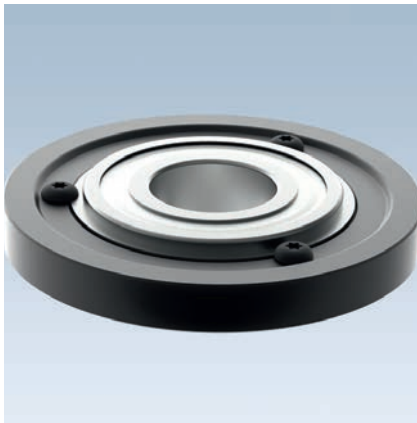
- 2 pieces: B 5.0 mm
- 2 pieces: B 16.0 mm
- 1 piece: B 8.0 mm
- 1 piece: B 10.0 mm
- 1 piece: B 25.0 mm
- 1 piece: B 40.0 mm

### Spacer sets

Set of standard cutter spindle spacers

AT 100 0 01

| D  | BO | ID       |
|----|----|----------|
| mm | mm |          |
| 50 | 30 | 028381 ● |
| 60 | 40 | 028382 ● |

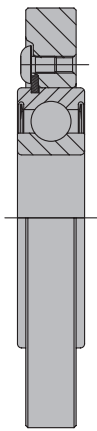


## Ball bearings

### Ball bearings

TL 510 0

| BEZ          | Type | D<br>mm | D Ring<br>mm | B<br>mm | BO<br>mm | ID              |
|--------------|------|---------|--------------|---------|----------|-----------------|
| Ball bearing | A    | 62      | min. 85      | 16      | 30       | <b>008114 ●</b> |
| Ball bearing | A    | 62      | min. 90      | 16      | 31,75    | <b>008142</b>   |
| Ball bearing | B    | 80      | min. 102     | 18      | 40       | <b>008116 ●</b> |
| Ball bearing | C    | 90      | min. 112     | 20      | 50       | <b>008117 ●</b> |
| Ball bearing | D    | 110     | min. 132     | 22      | 60       | <b>008118</b>   |



## Guide rings

### Guide rings

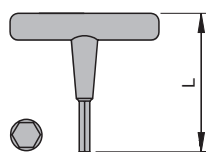
TR 500 0

| BEZ        | Type | D<br>mm | ID              |
|------------|------|---------|-----------------|
| Guide ring | A    | 85      | <b>027826 ●</b> |
| Guide ring | A    | 90      | <b>027799 □</b> |
| Guide ring | A    | 100     | <b>027800 ●</b> |
| Guide ring | A    | 105     | <b>027801 □</b> |
| Guide ring | A    | 110     | <b>027802 ●</b> |
| Guide ring | A    | 120     | <b>027803</b>   |
| Guide ring | A    | 125     | <b>027804 ●</b> |
| Guide ring | A    | 130     | <b>027805 ●</b> |
| Guide ring | A    | 140     | <b>027806 ●</b> |
| Guide ring | A    | 150     | <b>027807 ●</b> |
| Guide ring | B    | 105     | <b>027808</b>   |
| Guide ring | B    | 110     | <b>027809</b>   |
| Guide ring | B    | 120     | <b>027810</b>   |
| Guide ring | B    | 125     | <b>027811</b>   |
| Guide ring | B    | 130     | <b>027812</b>   |
| Guide ring | B    | 140     | <b>027813</b>   |
| Guide ring | B    | 150     | <b>027814</b>   |
| Guide ring | C    | 112     | <b>027815</b>   |
| Guide ring | C    | 120     | <b>027816</b>   |
| Guide ring | C    | 125     | <b>027817</b>   |
| Guide ring | C    | 130     | <b>027818</b>   |
| Guide ring | C    | 140     | <b>027819</b>   |
| Guide ring | C    | 150     | <b>027820</b>   |
| Guide ring | C    | 160     | <b>027821</b>   |
| Guide ring | D    | 140     | <b>027822</b>   |
| Guide ring | D    | 150     | <b>027823</b>   |
| Guide ring | D    | 160     | <b>027824</b>   |
| Guide ring | D    | 170     | <b>027825</b>   |

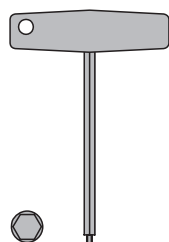
● available ex stock

□ available at short notice

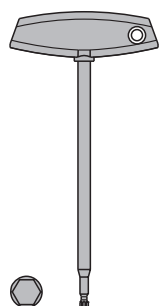
Instruction manual visit [www.leitz.org](http://www.leitz.org)



Hexagon key



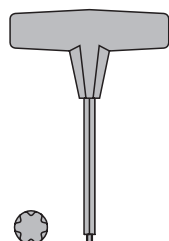
Hexagon key, with tenon



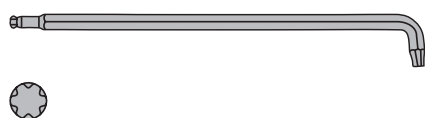
Hexagon key, for quick-change sleeve



Hexagon key, 90° angle



Torx® key with T-handle



Torx® key, 90° angle

## Hexagon allen keys

### T-handle without tenon

TH 500 0

| ABM<br>mm | L<br>mm | ID       |
|-----------|---------|----------|
| SW 2.5    | 100     | 005472 ● |
| SW 3      | 75      | 005444 ● |
| SW 4      | 75      | 005445 ● |
| SW 6      | 100     | 005447 ● |

### T-handle with tenon

TH 500 0

| ABM<br>mm | ID       |
|-----------|----------|
| SW 5      | 005452 ● |

### For quick-change chuck

TH 505 0

| ABM<br>mm | L<br>mm | ID       |
|-----------|---------|----------|
| SW 6      | 240     | 117516 ● |

### 90° angle

TH 500 0

| ABM<br>mm | L<br>mm | ID       |
|-----------|---------|----------|
| SW 5      | 154     | 117509 ● |
| SW 6      | 172     | 117543 ● |

## Torx® keys

### T-handle

TH 500 0

| ABM<br>mm | L<br>mm | ID       |
|-----------|---------|----------|
| Torx® 8   | 40      | 006092 ● |
| Torx® 9   | 40      | 005463 ● |
| Torx® 15  | 130     | 117507 ● |
| Torx® 20  | 130     | 117503 ● |
| Torx® 25  | 130     | 117504 ● |

### 90° angle

TH 500 0

| ABM<br>mm | L<br>mm | ID       |
|-----------|---------|----------|
| Torx® 20  | 149     | 117511 ● |

● available ex stock

□ available at short notice

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



### Torque tool set

**TorqueVario®-STplus T-handle torque tool set, 11 parts**  
AT 199 0

| BEZ                           | BEM                                                                                                                                                                                     | ID              |
|-------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| TorqueVario-STplus<br>5-14 Nm | Bitholder 1/4 inch for bits with drive E 6.3 and C 6.3;<br>Bits of series 7045 Torx and 7043 Hexagon in<br>lengths 70 mm; Torx T 15 - T 20 - T 25;<br>Hexagon SW 4 - SW 5 - SW 6 - SW 8 | <b>009103 •</b> |

**Application:**

Controlled tightening with predefined torque for changing knife tool systems

**Design:**

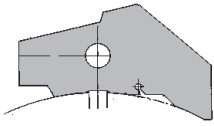
Model 5-14 Nm. Numeric torque indicator in the window scale. Steplessly controlled torque by control tool Torque Setter (included in delivery). Comfortable T-handle with soft zones for optimal torque transmission.

**Precision:**

±6%, based on national standards

**Extra:**

Delivery in stable metal box, incl. test protocol



### Setting gauge for hydro planerhead / planerhead wedge-type system

VN 265 0

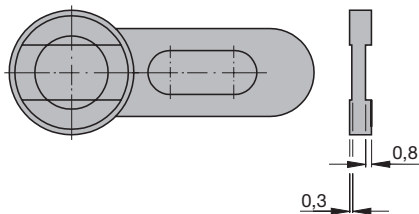
| ABM  | ID       |
|------|----------|
| mm   |          |
| D163 | 007989 ● |
| D203 | 008002 ● |



Setting gauge 0.3/0.8 mm



Setting gauge 1 mm



Magnetic setting gauge 0.3/0.8 mm

### Setting gauge for turnblade

VN 230 0

| BEZ                      | ABM     | ID       |
|--------------------------|---------|----------|
|                          | mm      |          |
| Setting gauge for knives | 0,3/0,8 | 005374 ● |
| Setting gauge for knives | 43x12x6 | 005350 ● |
| Magnetic setting gauge   | 0.3/0.8 | 005376 ● |

### Mounting device

VN 799 0

| BEZ                                                     | ID       |
|---------------------------------------------------------|----------|
| Mounting device for SK 30/BT30 with grooves and notches | 079000 ● |
| Mounting device for SK40                                | 079001   |
| Mounting device for HSK-F50                             | 079002 ● |
| Mounting device for HSK-E63 and HSK-F63                 | 079044 ● |
| Mounting device for SCM/Morbidelli ISO30                | 079004 ● |
| Mounting device for CMS ISO30                           | 079005   |
| Mounting device for Alberti HSK-E 40                    | 079006   |



#### Application:

For the assembly of shank tools in clamping chucks or tools with borehole on arbors with adaptors for automatic tool change

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting



### Mounting device

**Mounting device for tools with HSK 85 / HSK-F 63 adaptor**  
VN 799 0

| BEZ                                           | Machine | l<br>mm  | d<br>mm | ID              |
|-----------------------------------------------|---------|----------|---------|-----------------|
| Mounting device EASY-Hold HSK 85 WS           | Weinig  | 30 - 310 | 20 - 50 | <b>079010 •</b> |
| Mounting device EASY-Hold HSK-F 63 / HSK-E 63 |         |          |         | <b>079009 •</b> |

For quick and easy mounting of knives or tools on arbors.

#### Application:

For mounting saws, tools, tool sets and cutterheads



### Mounting device

**Clamping device for drills with 10 mm shank and clamping flat**  
VN 799 0

| BEZ                                   | ID              |
|---------------------------------------|-----------------|
| Clamping device for drill 10 mm shank | <b>079020 •</b> |

#### Application:

For clamping drills (10 mm shank with clamping flat) when altering the length adjusting screw.

#### Advantages:

- reduced risk of injury when mounting the tools
- easy and stable tool clamping during mounting



### Lifting device for large circular sawblades

#### MagneticGrip Lifting device

VZ 999 0

| BEZ            | BEM                   | ID              |
|----------------|-----------------------|-----------------|
| Lifting device | 10 kg load capacity   | <b>119900 ●</b> |
| Lifting device | 22.5 kg load capacity | <b>119901 ●</b> |

For optimal lifting, 2 pcs. are recommended.

#### Application:

For easy lifting of large circular saw blades by means of magnetic power

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### Jointing stones for Leitz Marathon planer knife

FS 100 0, FS 199 0

| BEZ                      | Machine           | BEM           | ABM<br>mm | ID              |
|--------------------------|-------------------|---------------|-----------|-----------------|
| Jointing stone (angular) | WACO              | Colour: brown | 20x15x60  | <b>008238 ●</b> |
| Jointing stone (round)   | Weinig, Leadermac | Colour: grey  | 12x32     | <b>008237 ●</b> |

Grinding wheels suitable for sharpening Marathon planer knives available on request.



### RFID reader

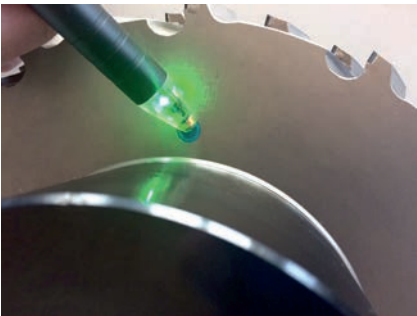
**RFID reader**  
FZ 999 0

| BEZ         | ABM    | ID       |
|-------------|--------|----------|
| RFID Reader | 130x12 | 081550 ● |

#### Application:

For reading data from tools with RFID data chip.

- RFID air interfaces 13,56 MHz
- Standards ISO 15693 and ISO 14443
- Operating distance 0-40 mm
- HOST Interface USB 2.0
- Cable length 1,5 m



## Key to pictograms



|  |                                   |  |                                   |  |                             |  |                                   |  |                                           |  |                                                                          |  |                                  |
|--|-----------------------------------|--|-----------------------------------|--|-----------------------------|--|-----------------------------------|--|-------------------------------------------|--|--------------------------------------------------------------------------|--|----------------------------------|
|  | Sawing, multiple cut              |  | Sawing solid transparent plastic  |  | Copy shaping                |  | Slotting                          |  | Profiling                                 |  | Mechanical knife clamping, adjustable - serrated                         |  | Resharpenable cutting face       |
|  | Sawing, thin kerf                 |  | Sawing hollow metal               |  | Rebating                    |  | Spiral boring                     |  | Profiling joints                          |  | Mechanical knife clamping, adjustable - plane                            |  | Resharpenable clearance face     |
|  | Sawing, horizontal                |  | Sawing crosscut metal             |  | Bevelling                   |  | Non-axial boring                  |  | Mortising                                 |  | Constant Mechanical knife clamping, re-sharpenable and constant diameter |  | Low noise                        |
|  | Sawing along grain                |  | Scoring, top and bottom           |  | Panel raising               |  | Plug cutting                      |  | MEC Mechanical feed                       |  | Spindle without twist protection                                         |  | DFC Optimised chip flow          |
|  | Sawing across grain               |  | Scoring, hogging                  |  | Profiling                   |  | Carving                           |  | MAN Manual feed                           |  | Spindle with anti-twist keyway                                           |  | SP Alloyed tool steel            |
|  | Sawing, universal                 |  | Hogging                           |  | Profiling joints            |  | Grooving, sizing                  |  | Solid metal tool                          |  | Spindle with anti-twist hexagon                                          |  | HL High-alloyed tool steel       |
|  | Scoring, sawing                   |  | Double hogging                    |  | Profiling tongue and groove |  | Finish sizing                     |  | Tipped tool                               |  | Hydro clamping system - open                                             |  | HS High-speed steel              |
|  | Scoring and sawing stacks         |  | Hogging, folding                  |  | Planing                     |  | Grooving, horizontal and vertical |  | Heavy Special body alloy                  |  | Hydro clamping system - closed                                           |  | ST Stellite                      |
|  | Sawing hollow sections            |  | End trimming                      |  | Planing, profiling          |  | Joining                           |  | Light Light alloy body                    |  | Hydro-Duo (bi-directional) clamping                                      |  | HW Tungsten carbide              |
|  | Sawing, honeycomb panels          |  | Edge trimming                     |  | Drilling blind holes        |  | Copy shaping                      |  | Inter-changeable knives                   |  | Hydro clamping arbors                                                    |  | DP Polycrystalline diamond (PCD) |
|  | Sawing plastic single             |  | Grooving, horizontal and vertical |  | Drilling, through holes     |  | Rebating                          |  | Mechanical knife clamping, reversible     |  | Hydro clamping                                                           |  | DM Monocrystalline diamond (MKD) |
|  | Sawing plastic stacks             |  | Grooving honeycomb panels         |  | Step drilling               |  | Bevelling                         |  | Centrifugal knife clamping, reversible    |  | Shrink-fit clamping                                                      |  | Marathon Carbide metal coating   |
|  | Sawing hollow transparent plastic |  | Joining                           |  | Counter-sinking             |  | Panel raising                     |  | Mechanical knife clamping, non-adjustable |  | Quick Quick clamping system                                              |  | Diamond Diamond coating          |

