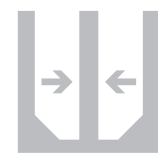


CATALOG
GENERAL PROGRAM 03
Date 10/2014



SOLID WOOD

SAWING

THROUGH-FEED

STATIONARY

WELCOME

Ladies and gentlemen,

the edition "GP03" of the LEUCO catalog stands for a revised, innovative tool program according to the motto "An innovative tool for each process in your production field".

Have a regular look on our homepage leuco.com! It contains the digital version of the catalog GP 03 - and you will be kept up-to-date about the latest tools and about LEUCO.

Innovative, trend-setting and reliable are the basic principles of LEUCO - with regard to our tools, with regard to the service and as well with regard to the communication with you.

If you have any questions, information and recommendations, please do not hesitate to contact us via phone +49 (0) 74 51 93 0 and info@leuco.com.

Your LEUCO team.

**The new
one is called
"GP 03"**





**"KEEPING WITH TRADITION
DOESN'T MEAN ADMIRING
THE ASHES BUT CONTINUING
TO CARRY THE TORCH."**





LEUCO

BRANDS YOU CAN RELY ON




Sizing Saw Blades

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




Panel Sizing Saw Blades

	Panel sizing saw blade for universal use, for stack cuts and single cuts
	Panel sizing saw blade for good cutting quality even with large cutting heights
	Panel sizing saw blade for excellent edge quality in laminated panels, for single cuts and stack cuts with small stack height
	High-performance panel sizing saw blade for stack cuts with large stack height and high volumes



Hoggers

	Diamond compact hoggers with stepped cut
	Diamond compact hoggers for universal use
	Diamond compact hoggers with spherical cutting edge geometry




Cutterheads

	Universal cutterhead system with standard body
LEUCO EcoPro	Flexible cutterhead system with direct knife clamping
LEUCO SetProfiler	Back-serrated knife system with large resharpenable area
	High-performance cutterhead system with profilable clamping wedge
	High-performance diamond profile cutters for highest feed rates



Drill Bits


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


Clamping elements


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

System Tools



	System tools with optimized chip evacuation for aggregates with introversive chip jet
CM	All LEUCO tools with optimized chip removal design
	Shank-type tools and tools with bore with a shear angle of $\geq 55^\circ$ for the best cutting quality currently available on the market; additional applications which have been considered as impossible so far

	Saw blades and grooving cutters with a 5 tooth group combination: noise reduced, low cutting pressure, excellent cutting quality
---	--


	Noise-reduced saw blades
---	--------------------------

	Noise-reduced tools with bore
---	-------------------------------


Cutting materials and coatings

	LEUCO HW cutting materials
HL Board®	LEUCO HW cutting materials for the machining of panel boards
HL Solid®	LEUCO HW cutting materials for the machining of solid woods
	Coatings of the cutting edges, suited for the individual application

LEUCO oxytop	Coating of the tool body for protection against corrosion and adhesion
---------------------	--

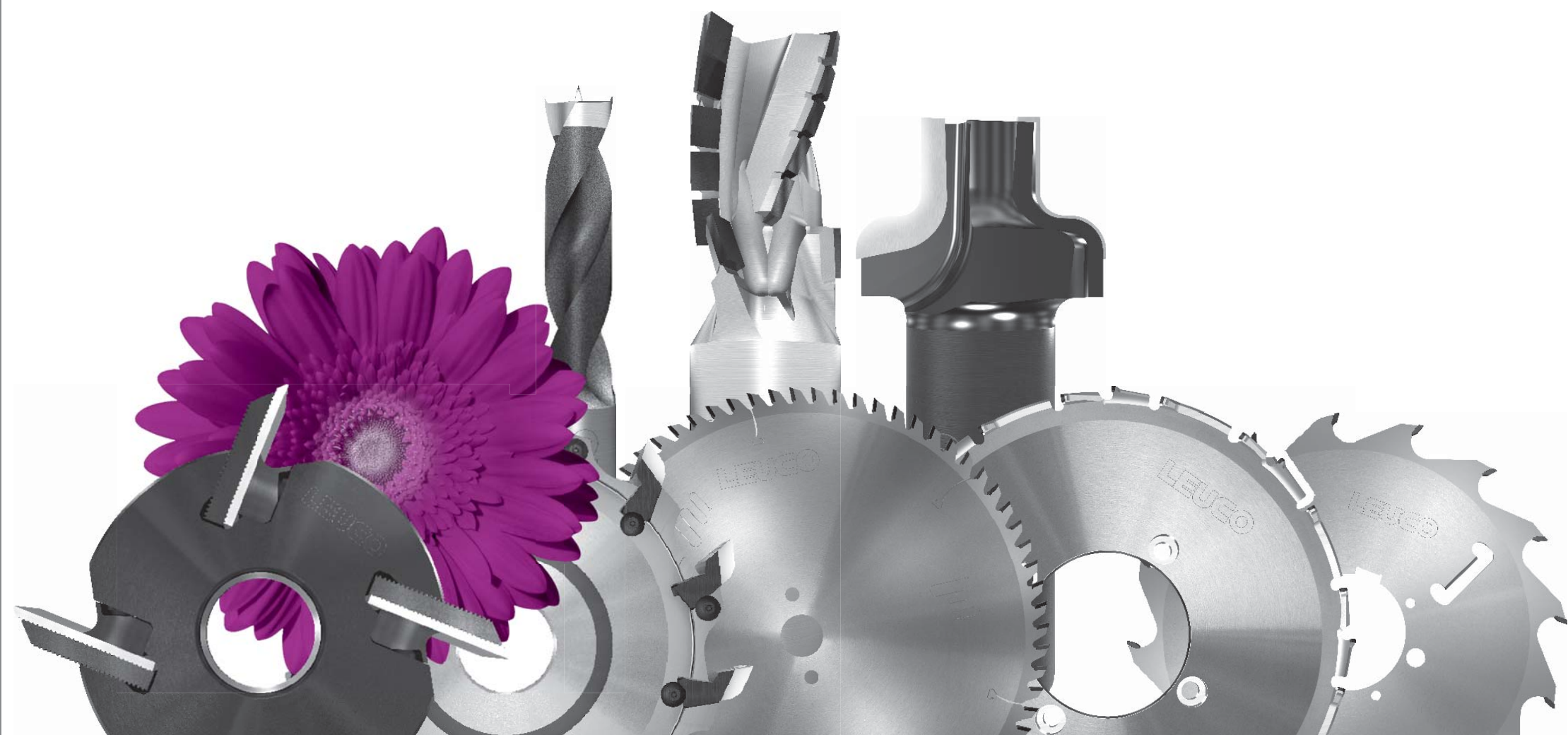
	Diamond high-performance cutting edge materials optimized as per application
---	--

LEUCO DIA	High-performance diamond tools with full height diamond tips (approx. 6 mm)
------------------	---

	Diamond-tipped tools with a resharpening area of 0.5 mm - 1.5 mm according to tool type and diameter
---	--

	Diamond-tipped tools with a resharpening area of 1.5 mm or 2.0 mm according to tool type
---	--

SUCCESS IS BONDING US TOGETHER!



**“WE CAN ONLY BE
SUCCESSFUL IF WE
MAKE OUR CUSTOMERS
SUCCESSFUL.**

**AND WE WANT TO BE
SUCCESSFUL.”**

TABLE OF CONTENTS

About LEUCO
News in the GP 03

Circular Saw Blades



Hoggers



Cutters with Bore



Shank-Type Cutters



Drill Bits



Turnover Knives
Profile Knives
Knives



Clamping Systems



Spare Parts
General Technical Information
LEUCO Addresses
Sharpening Service



Reprint, copy or duplicate requires written approval.

Subject to changes without prior notice. We will not be held responsible for printing errors. This catalog replaces all previous editions.

Date 10/2014

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LEUCO DIALOG

you're part of it. welcome!

For almost 60 years, LEUCO has been known for trend-setting innovations in tool technology. Duplovit, Segment Hogger, Super-Profiler, ZeroPlan, EcoPro, p-System, g5-System – tool developments unmatched in the industry segment.

This strong innovation force results from the intensive information exchange between all participants. We consider this dialog between our customers, machine manufacturers, cutting material and workpiece material manufacturers, research & teaching and ourselves as tool manufacturers as the decisive factor for success.

You are welcome to contact us and participate in this dialog.

**"OUR CUSTOMERS' NEEDS DRIVES
OUR INNOVATIONS.**

**THE DIALOG WITH OUR CUSTOMERS
IS THE KEY."**





CUSTOMER REQUIREMENTS



NEW MATERIALS



BASIC RESEARCH



MANUFACTURING QUALITY



MACHINE MANUFACTURER (OEM)

A modern industrial building with a large 'LEUCO' sign on the roof. The building features a combination of metal slat cladding and glass panels. Several international flags are flying in front of the building. The background shows a clear sky and some greenery.

LEUCO

1954

foundation of the Ledermann & Co. production site in Horb a.N
carbide-tipped tools for metal working, automotive engineering and machine construction

1956

brazed tools for milling and drilling in wood and plastic
introduction of the LEUCO hollow-ground circular saw blade

1957

Segment Hogger for stepped cut and circular cut

1962

first cutterhead with HW turnover knives for wood and plastic

1966

introduction LEUCOMAT (grinding machine)
Jointing / Chamfering Cutterhead with 12 mm turnover knife and with or without spurs



DAS IST LEUCO

The company Ledermann & Co. was founded in 1954 by Willi Ledermann and Josef Störzer in Horb am Neckar / Germany. The LEUCO brand was born.

Today, almost 60 years later, LEUCO is one of the world's largest suppliers of carbide and diamond-tipped machine tools for wood and plastic processing. Wealth of ideas and technical know-how have been the heart of LEUCO since the beginning. The product range includes circular saw blades, hogsers, bore-type and shank-type cutters, drills, clamping systems and inserts.

Sharpening service, application consulting and service packages bundled under the term „Tool management“ complete the spectrum. LEUCO sells via direct sales. Our customers are sawmills, building-, furniture- and paneling-industry as well as interior finishing.

Internationally, around 1,100 employees work for LEUCO. Sales affiliates are in Australia, Belgium, England, Japan, Malaysia, Poland, Russia, Singapore, Thailand, Ukraine, USA and Belarus. Sales and production subsidiaries are in China, France, Switzerland and South Africa.



1973

synchronously adjustable
jointing and pre-milling cutterhead

1975

s-System for Circular Saw Blades and Hogsers

Scoring Saw Blade
D192 and D110

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



1979

Cylinder Boring Bit with turnover knives

1983

SuperProfiler with bore



1985

Clamping chuck ps-System

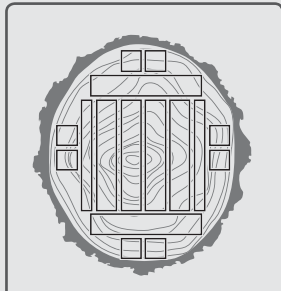
1987

Diamond Saw Blade

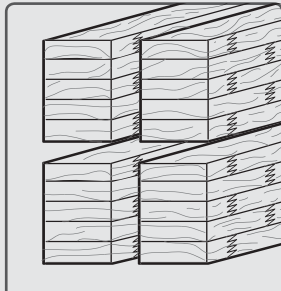
RANGE OF APPLICATIONS OF LEUCO TOOLS



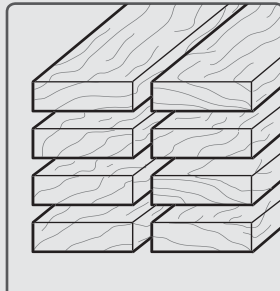
SOLID WOOD



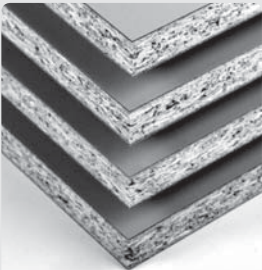
Saw mills



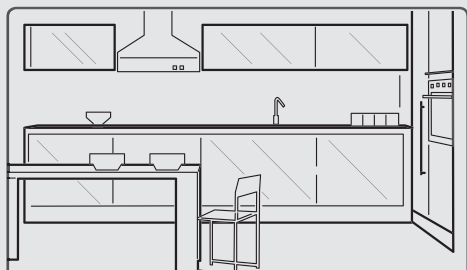
Beams and jointed goods



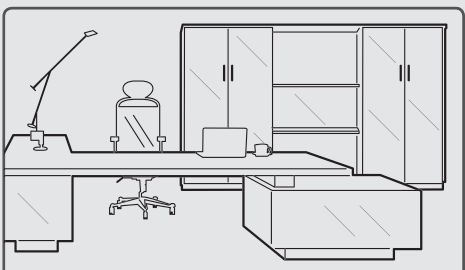
Boards and planed goods



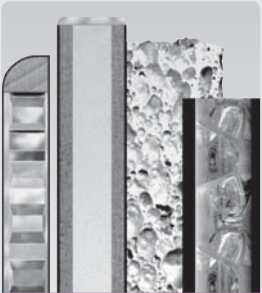
WOOD-BASED MATERIALS



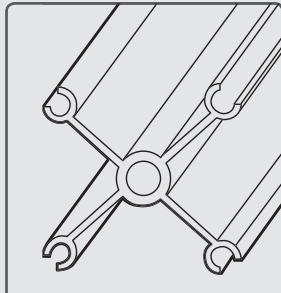
Kitchen



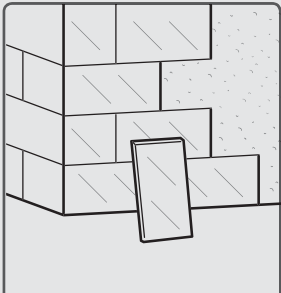
Office furniture



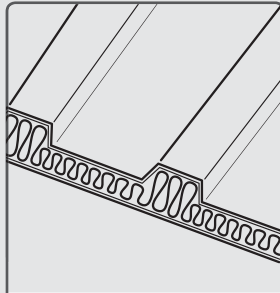
NON WOOD



Aluminum



Facade materials



Composite materials

1991
LEUCO DIAMAX
Topline Circular Saw Blade

1996
Tilted pre-cutting laminate flooring

1999
PowerTec Hoggers
i-System tools



2000
FinishCut Panel Sizing Saw Blade



2001
Clamping Chuck "Tribos"



2002
Hogger with cone-shaped gullets

2003
SpeedCut+ Panel Sizing Saw Blade

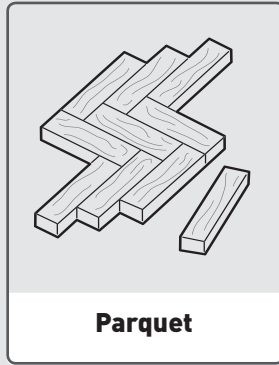


Hogger with optimized gullet

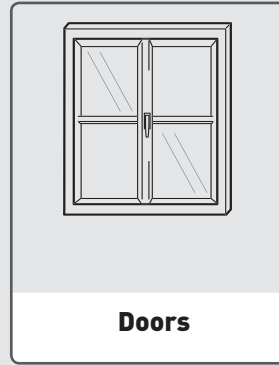




Staircase construction



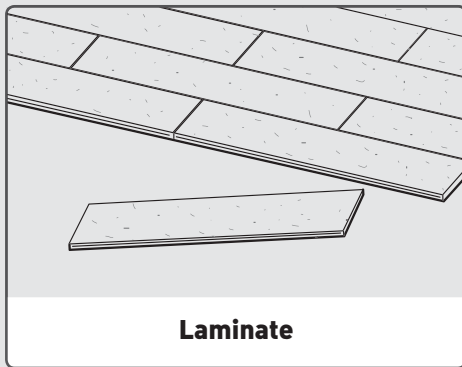
Parquet



Doors



Solid wood furniture



Laminate



Acrylics & plastics

INDUSTRY KNOW HOW

RANGE OF APPLICATIONS

LEUCO tools are used in the whole process chain of the woodworking and furniture industry, from the original material to the end product.

The tools are perfectly adapted to the application parameters, performance data, processing sequences and demands of the different industry segments.

2005
Topcoat Saw Blade coating
NF Diamond Saw Blade



2006
Power DIA Profiler

2007
g5 Sizing Saw Blade
(for excellent cutting)

2008
Solid Tungsten Carbide High-Performance
Drill Bit

2010
LEUCO p-System tools
PowerTec III Hogsers



2011
Aerodynamic LowNoise
Jointing Cutters



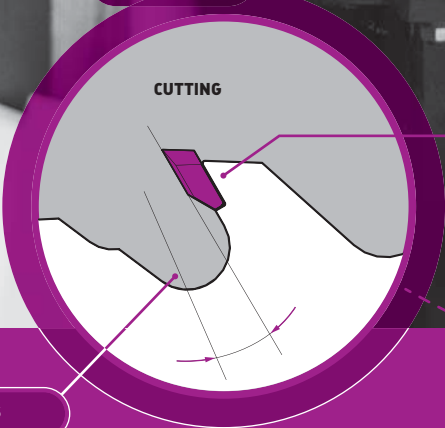
2013
LEUCO g5-System
Saw Blades and Grooving Cutters
with a tooth group combination of 5 teeth: noise reduced, low cutting pressure, excellent cutting quality



Sawing

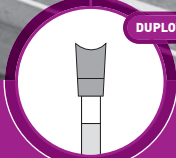


EDGE LIFE
CUTTING QUALITY




LEUCO SERVICE

TOOTH CONFIGURATION

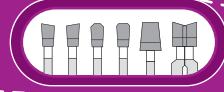


COATING

- OXY TOP NON-STICK
- TOP COAT
- PTFE

GULLETS

- NOISE LEVEL
- CHIP EVACUATION



CUSTOMER "From saw blades we expect cutting quality and long edge lives to be able to produce efficiently."



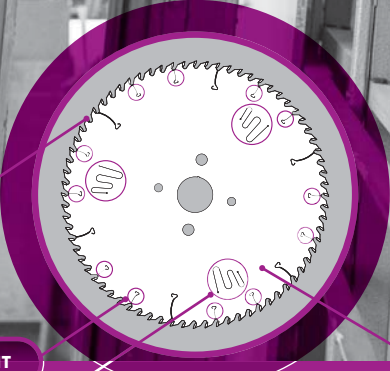
LEUCO "A saw blade is optimal if the customer demands as to quality and performance meet the best price-performance ratio according to the machine type and the material to be machined."

Thanks to the "LEUCO Dialog", i.e. the information exchange between all participants, LEUCO knows the decisive parameter for saw blades and thus for the performance of your production."



EDGE LIFE

CUTTING QUALITY



CUTTING HEIGHT



CUTTING PRESSURE

RESOURCE EFFICIENCY

03+

03

06

CUTTING MATERIAL



HL BOARD®

HL SOLID®



EXPANSION JOINT



LASER ORNAMENTS

AN INNOVATIVE TOOL FOR EACH PROCESS

PANEL SIZING SAW BLADES

OVERVIEW OF PANEL SIZING SAW BLADE PROGRAM

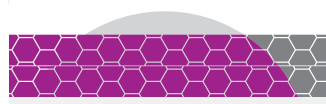
Innovative program of carbide tipped panel sizing saw blades



SPEEDCUT PLUS

The powerful saw blade for stack cuts with high running meter performance is available from stock in diameters from 480 - 730 mm.

The maximal cutting height is 215 mm.



UNICUT g5-SYSTEM

For excellent cutting results in plywood boards, wood core plywood, veneered or paper-laminated panels and – due to the very low cutting pressure – also in honeycomb panels. Cutting width of 4.0 mm available from stock with diameters from 350 - 450 mm. Matching the main saw blades we offer scoring saw blades with a cutting width of 4.0 - 4.8 mm.



UNICUT / UNICUT PLUS

The multi-functional saw blade for pressure beam machines is available from stock in diameters from 350 - 450 mm.

Excellent cutting results can be obtained in single sheets and stacks up to 80 mm.



FINISHCUT PLUS

For single cuts in finish-cut edge quality. Stack cuts are possible up to a max. height of 100 mm. Available from stock with diameters from 280 - 520 mm.



THE RIGHT SAW BLADE FOR EACH APPLICATION!

Cutting quality, volumes, material variety ... the LEUCO Panel Sizing Saw Blade program offers the opportunity to meet these demands in an individual way. In 2012/2013 LEUCO optimized the whole program of HW-tipped saw blades with regard to cutting material, grinding technology and tool body.

The advantages are: less tooth breaking, improvement of edge lives up to 30% as well as audibly comfortable working noise-reduced by 4 dB (A).

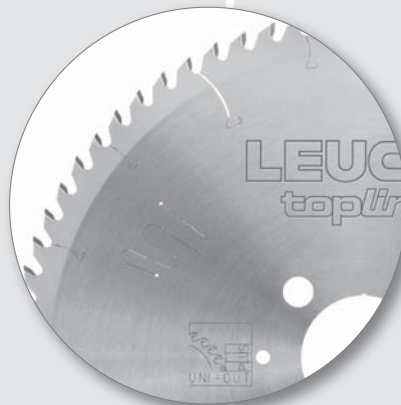
Catalog page 1 - 20-28

ESSENTIAL FEATURES OF THE HW-PROGRAM

SpeedCut-, UniCut- and FinishCut-Family

SPEEDCUT PLUS UNICUT PLUS FINISHCUT PLUS

- | cutting material grade HL Board O3 plus
- | tooth configuration TR-F-FA for SpeedCut Plus and UniCut Plus
- | tooth configuration TR-TR for FinishCut Plus
- | laser ornaments and expansion slots



UNICUT

- | cutting material grade HL Board O3 plus (TR-F)
- | HL Board O6 (WS)



UNICUT g5-SYSTEM

- | HL Board O3 plus
- | tooth geometry „g5-System“
- | laser ornaments and expansion slots



NEW CONICAL "ECO" SCORING SAW BLADES LEUCO HIGHLINE

Achieve more with less efforts!

In the case of the new conical scoring saw blades, visibly less tungsten carbide is used for tipping than in the case of other scoring saw blades. Thus, tungsten carbide is saved which reduces the price. Nevertheless, the number of possible resharpenings remains constant in spite of the smaller tipping height.

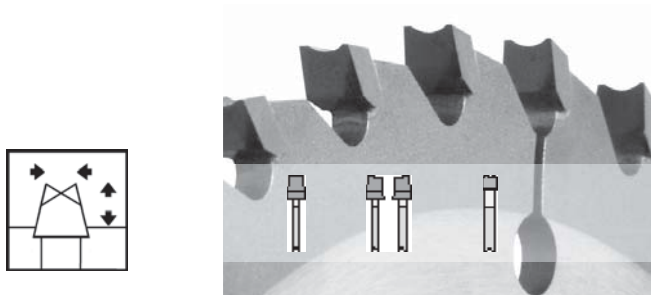
The scoring depth of the new scoring saw blades is smaller than usual; e.g. in the case of a conical scoring saw blade with hollow back with a cutting width of 5.2 mm requires now a scoring depth of only 1.6 mm whereas previously 2.4 mm were necessary. Cutting pressure is reduced, current consumption decreases.

The new program is equipped with a new higher quality carbide grade and offers edge lives increased in average by 20%.

The new conical scoring saw blades are suitable for all common table saws and panel sizing saws and are available with flat, alternate top bevel or hollow back teeth.

Catalog page 1 - 33-34;39-41

Adjustment of the scoring depth in relation to the scoring width: ± 1 mm height adjustment results in a change of cutting width of $\pm 0,21$ mm



The new saw blade quality standard at LEUCO

With immediate effect, LEUCO offers the most popular sizing saw blades with different tooth rows and tooth configurations for the machining of the most various materials - e.g. solid wood, particle boards, composite materials – in the new LEUCO quality standard "LEUCO Highline". This quality standard is also available for scoring, trimming and NF saw blades. It replaces the previous LEUCO quality level Proline.

Saw blades of the "LEUCO Highline" quality standard have a multitude of new features in common:

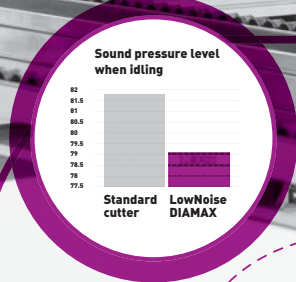
- | All saw blades are heat-treated and thermally adjusted for an ideal runout tolerance.
- | Carbide tipped saw teeth in ultra grain quality: "HL Board 06" for sizing saw blades and "HL Board 10b" for trimming and NF-saw blades
- | Special laser ornaments for vibration dampening and a clearly perceptible noise reduction.

With the LEUCO Highline saw blades, the customers benefit from the excellent cutting results with convincing edge lives. The new "Highline" quality standard by LEUCO convinces through an excellent price-performance ratio and is the ideal start for users of standard saw blades.

Catalog page 1 - 8-11;13;52;55



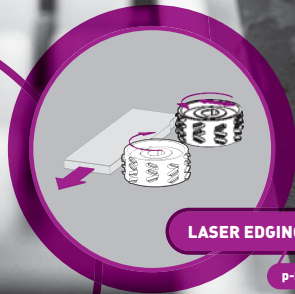
THROUGH-FEED MANUFACTURING



TOOL BODY MATERIAL

STEEL ALUMINUM

QUALITY INCREASE



TWINBLADE SCRAPER

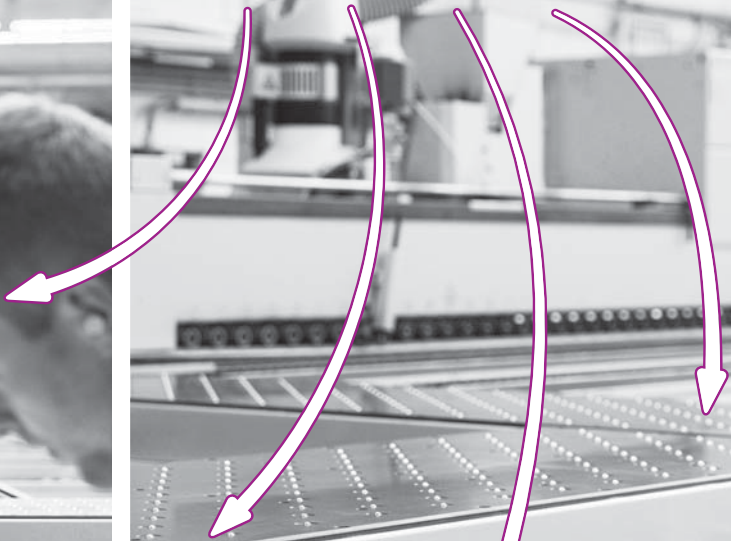
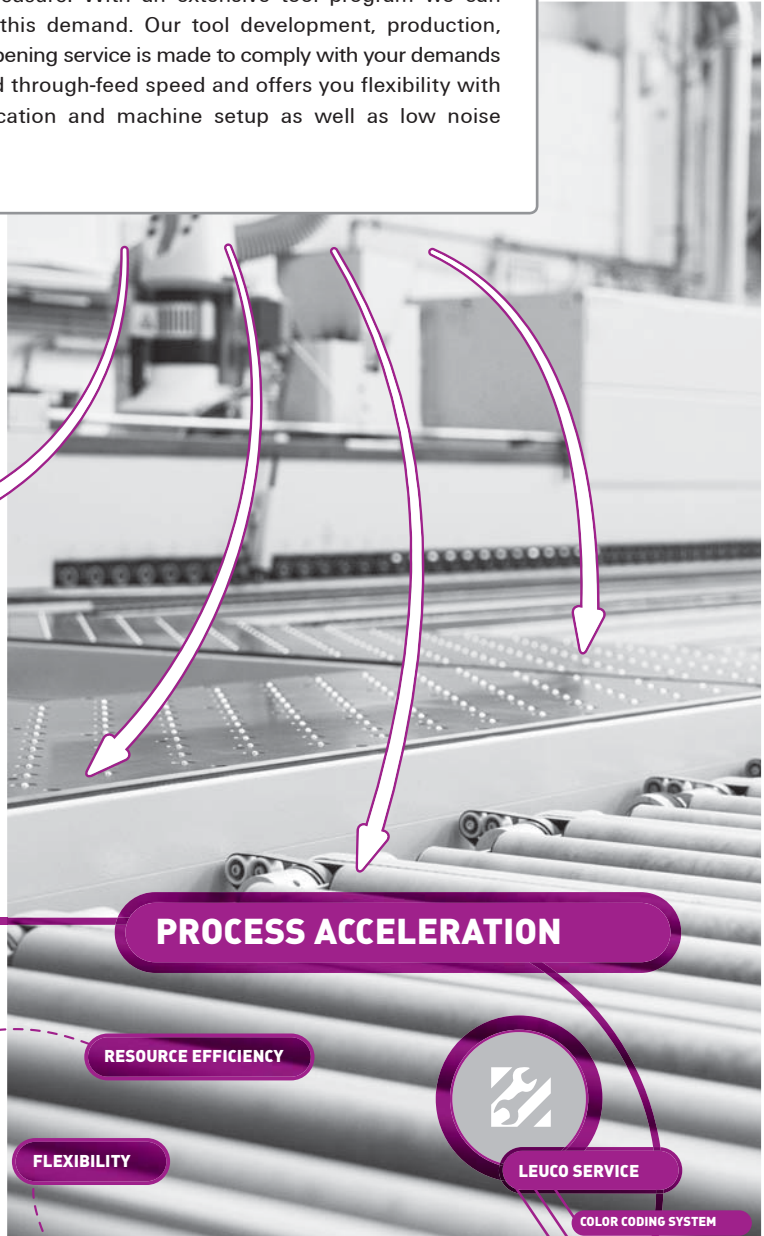


NOISE REDUCTION

CUSTOMER "We opted for through-feed edge trimming because of the high production output. This is exactly what we expect from the tools, too."



LEUCO "With pleasure. With an extensive tool program we can precisely meet this demand. Our tool development, production, design to resharping service is made to comply with your demands as to quality and through-feed speed and offers you flexibility with regard to application and machine setup as well as low noise working."



PROCESS ACCELERATION

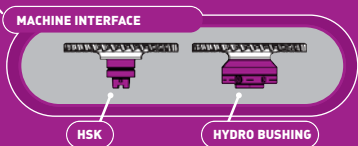
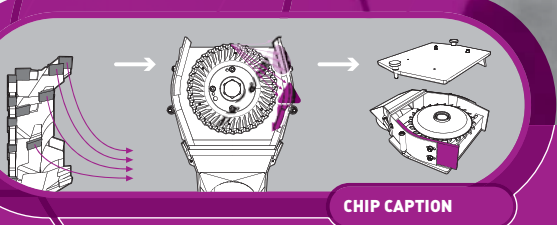
- THROUGH-FEED SPEED
- TOOTH GEOMETRY
- GULLET GEOMETRY
- CHIP FLOW OPTIMIZATION

RESOURCE EFFICIENCY

FLEXIBILITY



- LEUCO SERVICE
- COLOR CODING SYSTEM
- TOOL CARD
- IBLADE



AN INNOVATIVE TOOL FOR EACH PROCESS

JOINTING CUTTERS FOR THROUGH-FEED MACHINING

OVERVIEW: THE RIGHT JOINTING CUTTER FOR ALL APPLICATIONS


Jointing Cutters for each demand

The DIAREX FinishJointer (now new in the GP 03) completes the current LEUCO jointing cutter program.

The advantages of the cost-optimized DIAMAX LowNoise jointing cutter and the LowNoise SmartJointer are combined with an increased resharpening area prolongating tool life and an optimized tooth geometry.

In detail, this means excellent cutting quality in coatings and middle layers, long edge lives and low noise as well as a good price-performance ratio.

The overview shows the details:

Features	LEUCO DIAMAX LowNoise	LEUCO SmartJointer	LEUCO DIAREX FinishJointer	LEUCO p-System
tool body features				
tool body features	Steel	Aluminum	Steel	Steel
shear angle	35+°	35+°	43+°	70°
tooth length	approx. 12.35 mm	ca. 14.2 mm	ca. 8.5 mm	ca. 14 mm
flow optimization / LowNoise design	++++	++++	+++	+
resharpening area	1.5 mm	1.5 mm	3 mm	4 mm
suitable for laser-edge technology	++	++	+++	++++
running meter performance	++	++	+++	++++
cutting quality cover layer	++	++	+++	++++
cutting quality middle layer	++	++	++++	+++
number of teeth	2-3	2-3	3-5	2-4
Catalog page	3 - 76;78;79;81	3 - 77	3 - 80	3 - 81-82

+ suitable ++ good +++ very good ++++ maximal

"LEUCO POWERTEC III" AND "POWERTEC III TOPLINE"

High speed and hogging of materials which have been unthinkable so far

POWERTEC III HOGGERS

Since its market launch approx. 2 years ago, the DP hogger PowerTec III has developed to the LEUCO best-seller among the DP compact hoggers.

Compared to the PowerTec predecessors, the difference is that - thanks to a new manufacturing process - the finish-cut cutting edge (negative hook angle) and the pre-hogging cutting edge (positive hook angle) can be positioned on one wing. This allows twice as many cutting edges with the same diameter, i.e. the possible feed rate on double-end tenoners is almost without limits. In the meantime, the PowerTec III hogger is applied with a feed rate of more than 100 m/min with excellent edge lives.



SELECTIVE OPTIMIZATION OF SINGLE FEATURES OF THE "POWERTEC III TOPLINE"

The peripheral cutting edge is subject to the highest mechanical strain which is why it partly shows signs of bad damage at the end of the edge life. LEUCO geometrically optimized these peripheral cutting edges. Less material has to be removed when resharpening which increases the number of possible resharpenings.

The number of pre-hogging cutting edges is adapted to the number of finish-cut cutting edges as well. Even middle layers of extremely poor quality can be cut with excellent cutting quality and edge lives. This advantage pays particularly when cutting across the grain when the cutting edges emerge against the edge.



Advantages

- | pre-hogging cutting edge and finish-cut cutting edge on the same wing
- | feedrate of 100 m/min and more are possible with long edge lives
- | hogging of materials which have been unthinkable so far

Advantages

- | optimized peripheral cutting edge
- | no. of pre-hogging peripheral cutting edges = no. of finish-cut cutting edges
- | possibility of more resharpenings
- | quality increase in the case of cutting across the grain when the cutting edges emerge against the edge.

Catalog page 2 - 3

Catalog page 2 - 4

STATIONARY MANUFACTURING



PRODUCTIVITY INCREASE

REDUCTION OF WORK STEPS

REDUCTION OF TOOL CHANGES

INCREASE OF FEEDRATE

EDGE LIFE

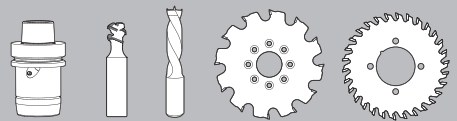
BALANCE QUALITY

CONCENTRIC ACCURACY

TOOL BODY DESIGN

TOOTH GEOMETRY

PERFORMANCE



QUALITY

GULLET DESIGN

TOOL BODY SURFACES

COATING

FLEXIBILITY

SMARTCNC

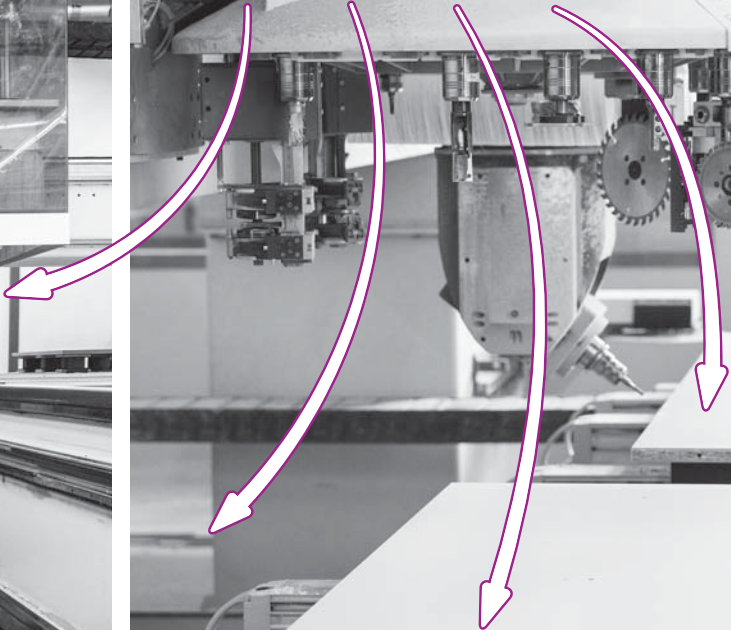
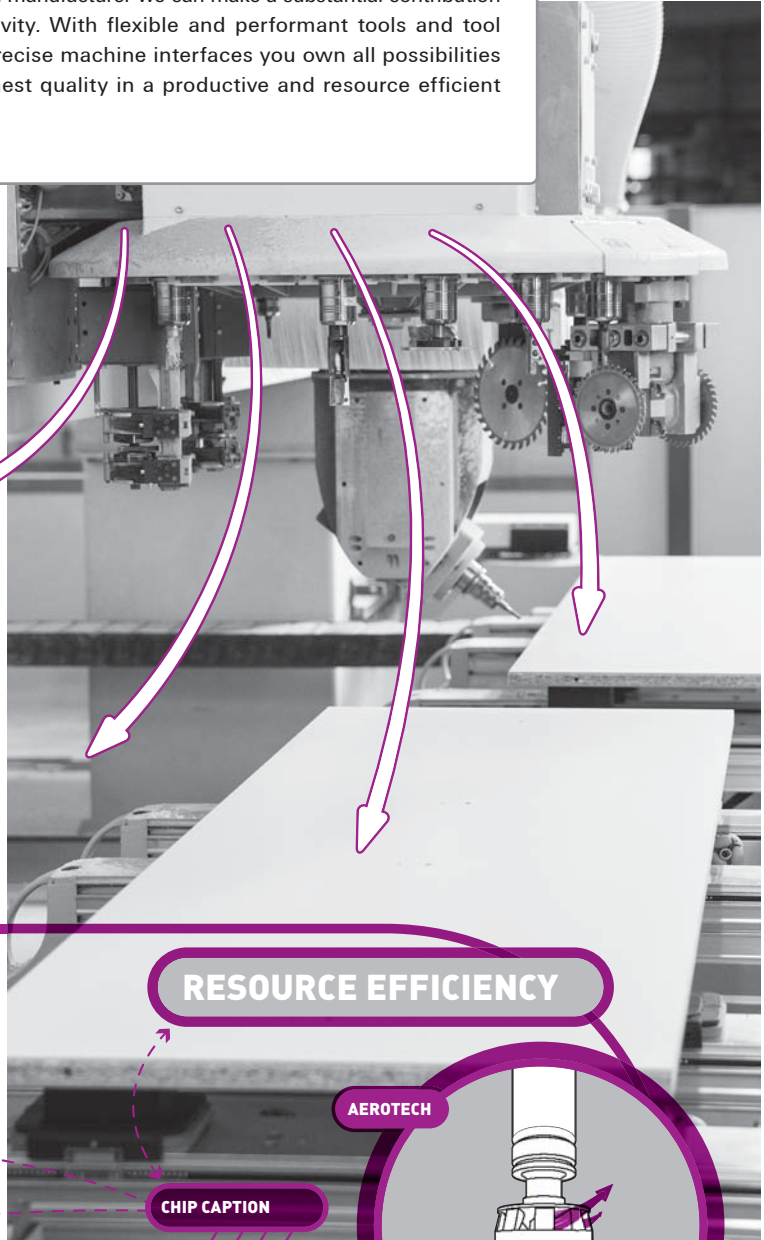
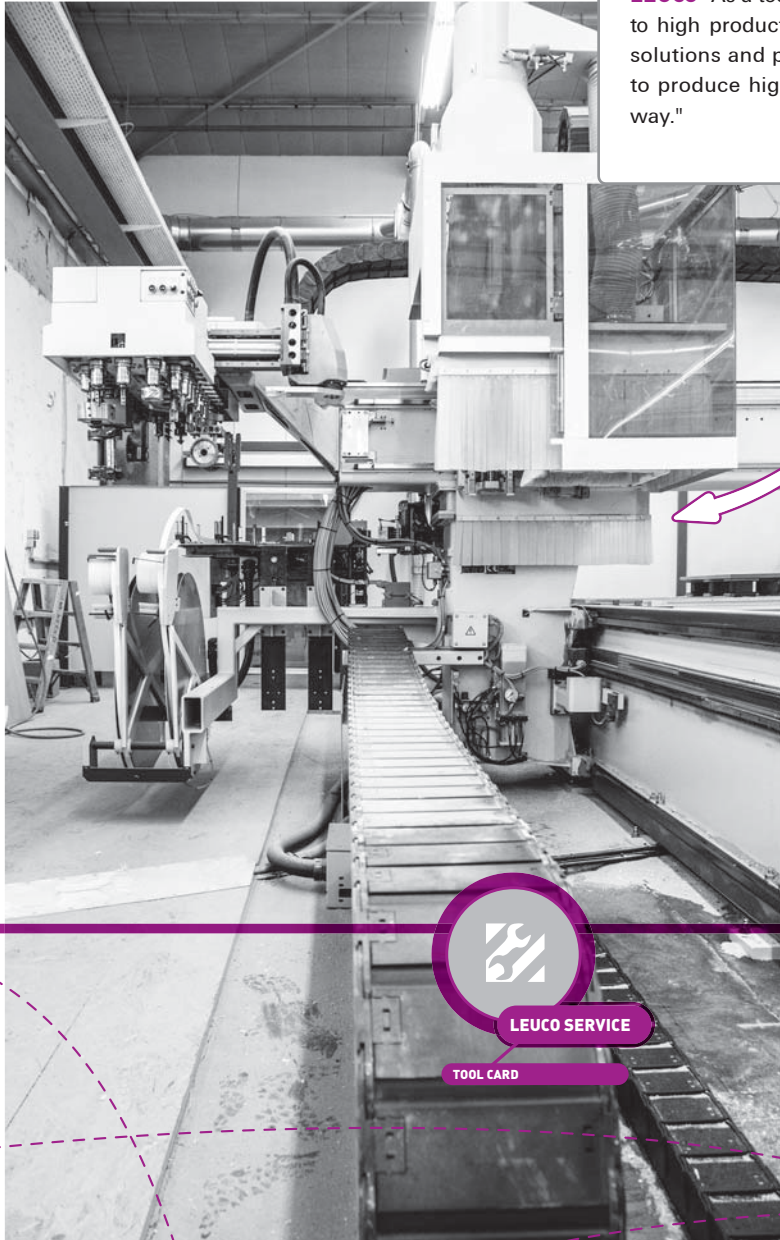
MODULA



CUSTOMER "Stationary processing supplies high flexibility as to shapes and batch sizes. We count on suitable tool solutions to guarantee efficient working in spite of all freedom offered by stationary processing."

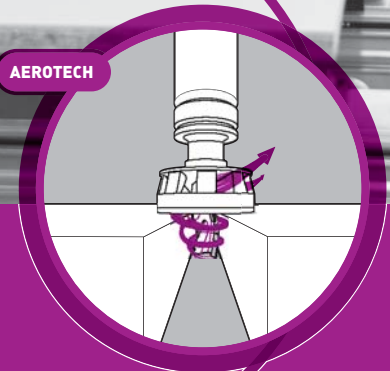


LEUCO "As a tool manufacturer we can make a substantial contribution to high productivity. With flexible and performant tools and tool solutions and precise machine interfaces you own all possibilities to produce highest quality in a productive and resource efficient way."

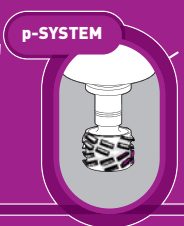


LEUCO SERVICE
TOOL CARD

RESOURCE EFFICIENCY



- COOLING
- CLEANLINESS
- HEALTH
- DUST DEVELOPMENT



AN INNOVATIVE TOOL FOR EACH PROCESS





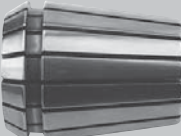
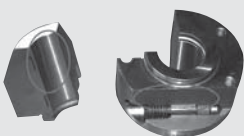

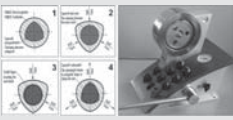
OVERVIEW OF CLAMPING ELEMENTS

COMPARISON OF CLAMPING ELEMENTS

Which clamping element is most suitable for you?

The main task of a clamping system is to create a link between tool and spindle regardless whether it is a shank-type tool or a tool with bore. It has to be made sure that the necessary torque can be transmitted and that during operation the emerging longitudinal and lateral forces can be absorbed. In addition, the clamping element must create a perfectly aligned link to the tool as well as to the motor spindle. The LEUCO range of clamping elements covers applications with low demands as well as high-end applications.

CLAMPING ELEMENTS FOR CNC TECHNOLOGY AT LEUCO

Clamping System	Draw-in collet chuck	Hydro Clamping Chuck ps-System	Heat shrink-fit chuck	Power Shrink-Fit Chuck Tribos
				
Operating principle	The collet chuck (1) is cone-shaped on the outside and has a cylindrical bore where tools are inserted. The collet chuck is radially slotted. The round head screw (2) clamps the collet chuck in the draw-in collet chuck (3); thus the tool is fixed.	The closed hydraulic system allows highest clamping forces. By means of an allen wrench the liquid (1) is squeezed and compresses the cylindrical bore (2). This creates high clamping forces which fix the tools safely.	In a special shrinking device the chuck is warmed by induction to up to 250° so that the clamping area is widened and the tool can be inserted. During the following cooling process the clamping area shrinks and the tool shaft is clamped.	
				
Concentric accuracy	0.02 to 0.06 mm	< 0.006 mm	< 0.003 mm	< 0.003 mm
Max. RPM	18,000 min ⁻¹ (24,000 min ⁻¹)	30,000 min ⁻¹	30,000 min ⁻¹	40,000 min ⁻¹
Sense of rotation right / left	Ri/Le suitable (Attention with large Ø diameter and heavy tools!)	Right/Left to be used without problems	Right/Left to be used without problems	Right/Left to be used without problems
Handling	Simple handling in cost-effective tool holders by means of hook wrenches.	Very simple handling, impressurement without effort by means of hexagonal allen wrench.	Complex handling by means of shrinking device. Trained staff and separate room (high temperatures when clamping) necessary.	Simple handling by means of hydraulic press.
Clamping errors	Operating error possible when building up the clamping force. User determines the torque.	Operating error improbable when building up the clamping force.	Operating error improbable when building up the clamping force.	No operating error when building up the clamping force.
Smooth running	good	excellent	excellent	excellent
Cutting quality	good	excellent	excellent	excellent
Edge life	good	excellent	excellent	excellent
Recommended application area	Low demand applications (e.g. drill bits, Z1-shank-type cutters). Cost-effective and flexible clamping element.	High demand applications. User-friendly clamping element.	High demand applications. Shrinking device and possibly additional induction coils for larger tool diameter necessary.	High demand applications. Very slim design.
Catalog page	7- 30;35;39;49;65	7- 24;33;43	7- 46	7- 38;44

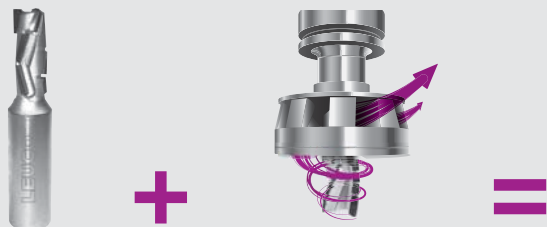
LORD OF THE CHIPS

LEUCO Chip Meister (CM) tools, chip extraction turbine „AEROTECH Universal“

Long edge lives, excellent cutting quality in the top layers and on the edges combined with high economic efficiency. These are the demands on high performance shank-type cutters.

In this case, the "CM" cutter concept developed by LEUCO takes effect.

CM stands for "Chip Meister", casually formulated "Lord of the chips". This version of high performance shank-type cutters specially designed for optimized chip removal mostly with positive spiral leads chips upwards in a more efficient and unobstructed way than conventional cutters do.



The chip extraction turbine AEROTECH Universal allows the use of shank diameters from 6 to 16 mm. The "Lord of the chips" is characterized by maximum gullet size designed to optimize the chip flow. The CM concept was realized for the DP Nesting High Performance Shank-Type Cutters, too.

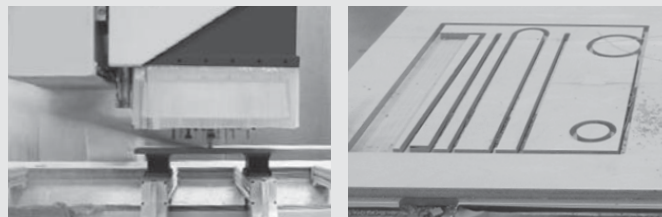
Clean environment thanks to the chip turbo

Another step to optimize the whole system of CNC operators is made by the use of the AEROTECH Universal. The turbine-like clamping and chip removal system funnels the chips which are lead upwards by the CM cutter and guides them through integrated openings to the dust extraction of the machine. The impressive effectiveness of the system is shown by the small quantity of chips remaining on the workpiece or in the cutting gaps. In addition, the cooling effect which is created has a positive effect on the edge lives of the tools. The positive effects are increased edge lives.

The special features of the AEROTECH take effect in Nesting processes but also in the case of chip- and dust-intensive processes such as in series production of shutter grooves, door fillings, pockets in stair stringers, grooves or pockets in acoustic panels, milling of MDF or machining of Eternit panels.

Catalog page 4 - 43-44;47-48

Chip extraction turbine AEROTECH Catalog page 7 - 50-51



LEUCO G5-SYSTEM FOR CNC MANUFACTURING

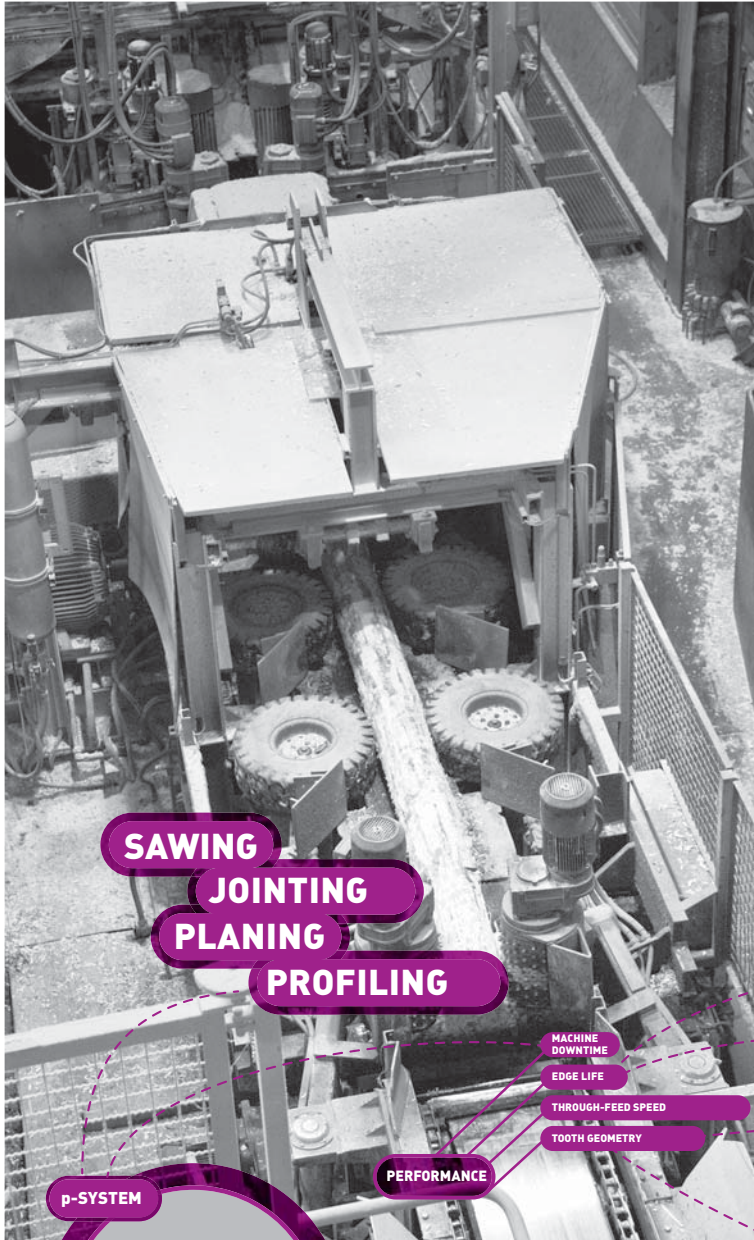
Excellent cutting; especially low noise level and suitable for a great variety of materials

For CNC manufacturing, LEUCO offers a tool series with the successful cutting edge combination "LEUCO g5-System". For the first time in the industry sector this cutting edge geometry has been applied to a CNC grooving cutter with a cutting width of 4 and 5 mm. For chip-free grooving and for sizing as well as clipping and miter cuts in wood-based panels, solid woods and plastics on CNC machining centers and aggregates (Biesse, SCM, Weeke BHX-Serie and other machining centers and aggregates) **Catalog page 3 - 70**



**LEUCO
g5-SYSTEM**

MACHINING OF SOLID WOOD



SAWING

JOINTING

PLANING

PROFILING

PERFORMANCE

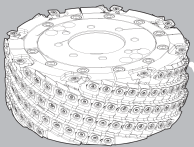
MACHINE DOWNTIME

EDGE LIFE

THROUGH-FEED SPEED

TOOTH GEOMETRY

p-SYSTEM



CUTTING MATERIAL



COMPETENCE IN CUTTING MATERIALS



LEUCO SERVICE

REDUCTION OF DEPOSITS

COATING

QUALITY

CONCENTRIC ACCURACY



PRECISION

CUTTING QUALITY

NO KNIFE MARKS

SMOOTH SURFACES

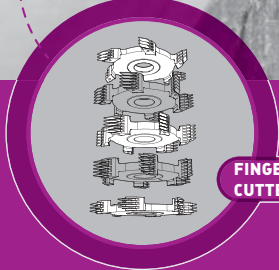
CUSTOMER "In our segment, resource saving and optimal exploitation of waste products is not only a nice savings effect but part of our overall business. Our products often are at the beginning of the process chain. If we supply good quality, the following processors will benefit."



LEUCO "With our tools we take this responsibility very seriously. Our measures for sawing, finger jointing, planing and profiling are high concentric accuracy, long edge lives, reduction of deposits. This is how you reach best quality, low machine downtimes, high through-feed speed and optimal "waste products".



- SAWING
- JOINTING
- PLANING
- PROFILING

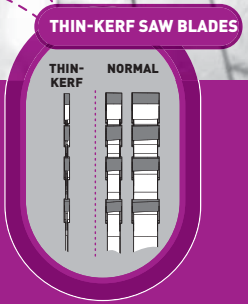


FINGER JOINT CUTTERS



POWER DIA PROFILER

- RESOURCE EFFICIENCY
- THIN KERFS
- CHIP OPTIMIZATION
- WASTE OPTIMIZATION



THIN-KERF SAW BLADES

AN INNOVATIVE TOOL FOR EACH PROCESS

FINGER JOINT CUTTERS

FINGER JOINT CUTTER PROGRAM OF LEUCO

Simple tool choice: By means of this overview you will quickly find the suitable cutter!

Application / Design		Finger Joint Cutters									Disc-Type Finger Joint Cutters						Cutterheads				
		Finger Joint Cutters HS			Finger Joint Cutters HS Solid 34			Finger Joint Cutters HW			Finger Joint Cutters HW soft wood	Finger Joint Cutters HW hard wood			Finger Joint Cutters HW exotic wood			Finger Joint Cutterheads			
Glue- ing	normal	++			++			++			++	++			++			++			
	fiber free	++			o			o			o	o			o			o			
Wood types	coniferous wood	++			++			o			++	++			o			++			
	deciduous wood	+			++			++			-	++			++			o			
	exotic wood	o			+			+			-	+			++			o			
Dimensions on machine	machines (with hogger)	10/11	15/16,5	20/22	10/11	15/16,5	20/22	10/11	15/16,5	-	10/11	10/11	15/16,5	-	10/11	15/16,5	-	-			
	machines (without hogger)	10/10	15/15	20/20	10/10	15/15	20/20	10/10	15/15	-	-	-	-	-	-			10/10	10/11	15/15	15/16,5
Coating possibilities	non-stick coating	-			-			-			topcoat	topcoat			-			-			
	edge life coating	topcoat			topcoat			topcoat			topcoat/ topcoat plus	(*)			(*)			topcoat			
Comparison of edge lives	uncoated	100%			up to 300% - 400 %			up to 400% (increased risk of breaking)			100%	100%			100%			100%			
	topcoat	up to 200% - 300%			> 500 % (*)			(*)			up to 200%	up to 200%			-			up to 200% - 300%			
	topcoat plus	-			-			-			> 400%	(*)			(*)			-			

*on request ++ very well suited + well suited o possible - not possible / not suitable

Finger joint cutters Catalog page 3 - 118-122
Disc-type finger joint cutters Catalog page 3 - 123-124

CROSS-CUT SAW BLADE PROGRAM

The design (tooth geometry and tool body design) guarantees universal application in soft and hard, dry and naturally humid solid woods as well as excellent cutting quality and tool life. For chop cuts (one-sided, double-sided) for precise lengths of boards, lamellas, etc.

- | the saw blades are applied on joinery machines and double clipping saws and on special machines e.g. by Kalfass, Springer, Krüsli, Hundegger, Weinmann. Thanks to the good chip evacuation, less postprocessing is necessary.
- | cutting material: HL Board 10
- | WSA cutting geometry: ATB 20° and shear angle of +5° for excellent cutting quality



Catalog page 1 - 43

OPTIMIZING CHOP SAW BLADE PROGRAM

The LEUCO Optimizing Chop Saw Blade family was optimized especially for clipping and cross cuts in solid woods, MDF, HDF, ledges on manual or automatic optimizing chop saws. Special attention was given to the tool body stability and the increase of edge lives, thus higher productivity and economic efficiency.

- | the chop saw blades are applied on undertable cross-cut saws, push-feed saws, through-feed saws, e.g. DIMTER Opticut „C“, „S 90“, „Quantum“ and PAUL machines
- | cutting material: HL Board 06 for long edge lives
- | WSA cutting geometry: extreme angle of 40° and shear angle of +5°



Catalog page 1 - 44

HIGH-PERFORMANCE PROFILING

LEUCO Power DiaProfiler

Today, the profiling of ledges made from MDF and hard woods is possible with a feedrate of 100 m/min. The excellent surface quality obtained in spite of these enormous feedrates are the result of efficient development realized by machine and tool manufacturers. The basic premise is the new Powermat machine generation with HSK technology by Weing which has increasingly become standard for molders as well as the new POWER DIA-Profilier by LEUCO. In the case of profile ledges, this combination between machine and tool creates a surface quality like with jointed HW tools.

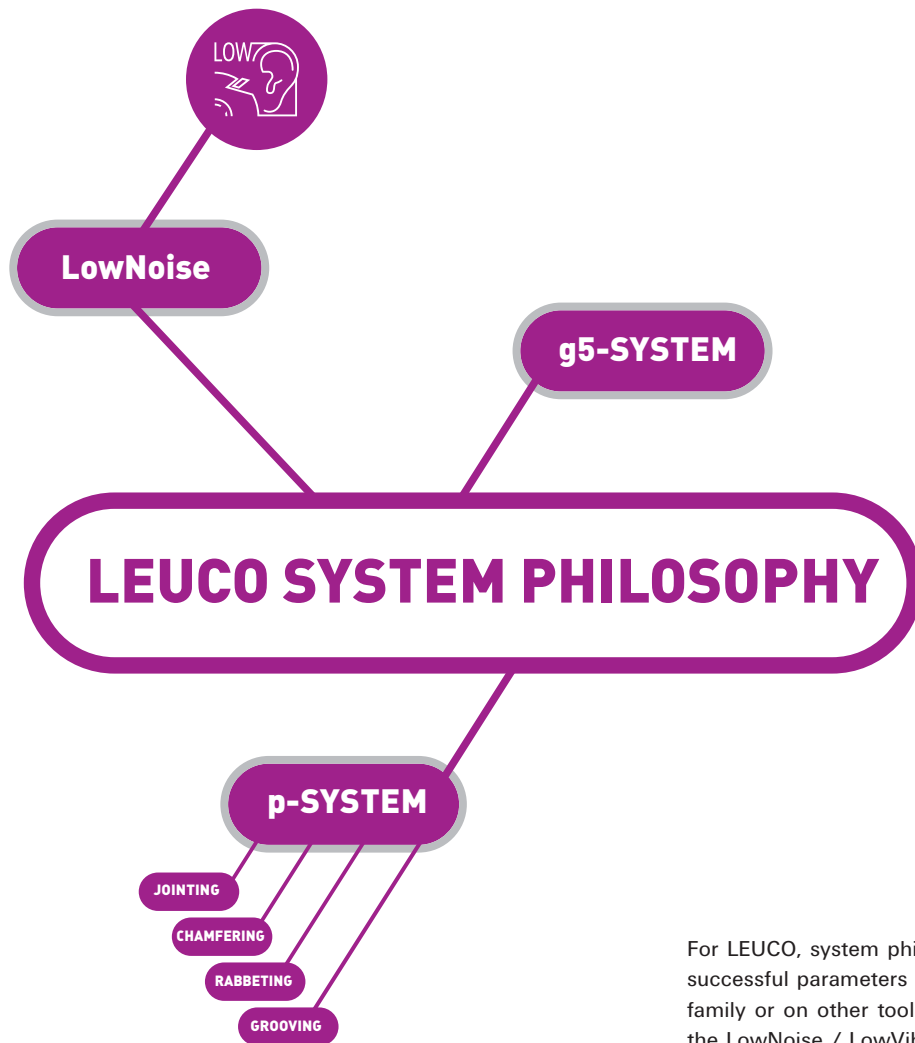
But there is more to it than that - economic efficiency thanks to increased edge life

The edge lives when profiling ledges made from MDF or hard wood are in average 30-50 times higher compared to the conventional HW tool. The saving in machine downtimes lead to an additional

productivity increase and offer a particularly economic solution. Profitability calculations prove the outstanding customer benefit. Plainly speaking, a reduction of tool costs of more than 50% per running meter is possible.

Catalog page 3 - 115





For LEUCO, system philosophy means to transfer successful parameters of a tool to the whole tool family or on other tool groups. The focus lies on the LowNoise / LowVibration technology, the g5-System as well as the enhancement of the LEUCO p-System.



LowNoise

LEUCO LowNoise TOOLS AUDIBLY REDUCE THE NOISE LEVEL WHEN IDLING AND DURING OPERATION.

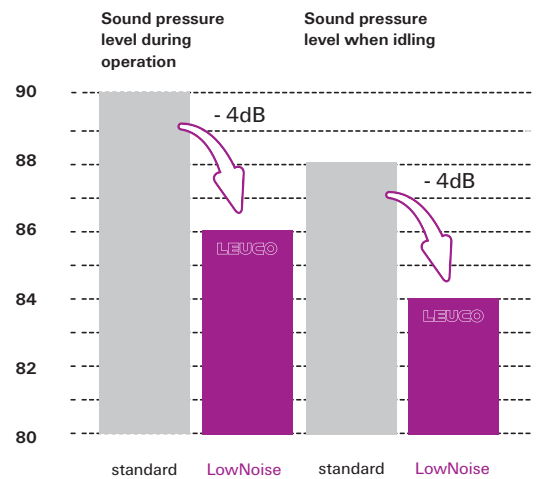
DEPENDING ON THE TOOL TYPE DIFFERENT MEASURES ARE APPLIED:

- | noise reduction via material choice and thus tool body weight: steel/aluminum
- | mechanical tool body treatment e.g. expansion slots and laser ornaments
- | aerodynamic design of tooth geometries and gullets

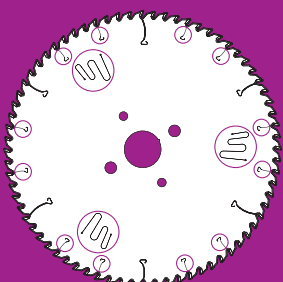
Hear, hear! LOW-NOISE TOPLINE SIZING SAW BLADES

With immediate effect, all LEUCO Topline sizing saw blades are noise-reduced (LowNoise) and cause low vibration (LowVibration). The saw blade bodies have a new design combined with expansion slots and laser ornaments. This provides an audible noise reduction when cutting and idling.

Low-vibration saw blades stand for high cutting quality and longer edge lives. Compared to standard saw blades, the dampening effect of these LEUCO saw blades is increased by 4 times.



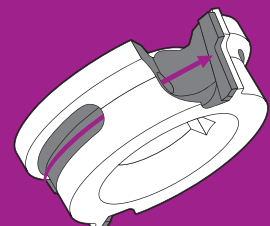
SAWING



JOINTING



EDGE TRIMMING



p-SYSTEM



PEELING

LEUCO is the first tool manufacturer to realize tools with shear angles $\geq 55^\circ$.

We call these tools »LEUCO p-System«.

The process is called »Peeling«.

PEELING – THE REVOLUTIONARY WOOD PROCESSING TECHNOLOGY BY LEUCO

What is peeling?

FEATURES

Wood processing standard: milling with shear angles of up to 54°

To date, the state of technology considers the positioning of the cutting edge under a shear angle as a "drawing cut". This results from the fact that in the direction of cut, the wedge angle of a cutting edge with shear angle is smaller than the wedge angle of a cutting edge without shear angle. In fact, however, it is just an "inclined" cut.

Wood processing NEW: peeling with shear angle $\geq 55^\circ$

New and unnoticed by the technique is the real drawing cut with the cutting edge being positioned under a very large shear angle. Here, the cutting edge functions like a knife blade, really drawing. It is more than a mere improvement of a tool, it is a new way of wood processing apart from sawing, planing and milling. Peeling enables applications which have been considered as impossible so far.

Applications which have been considered as technically impossible so far

- | machining of solid wood by means of diamond tips with large wedge angle
- | cutting across the grain against the feed without chipping
- | chip-free cutting edge exit when jointing thick edges
- | finish-quality when peeling Multiplex; no additional work steps needed
- | finish-quality when peeling fiber materials such as fabric, laminated panels, linoleum with jute fibers etc.

**LEUCO
PATENT**



shear angle $\geq 55^\circ$
only from LEUCO!

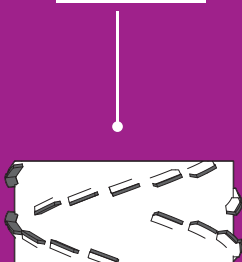
LEUCO p-SYSTEM TOOLS OPEN NEW POSSIBILITIES AND CUTTING QUALITY DIMENSIONS FOR:

- | a brilliant cutting quality presently unmatched on the market
- | mostly higher edge lives than in the case of common diamond tools

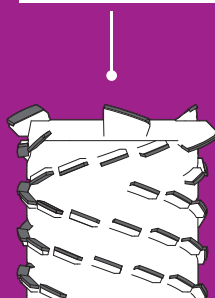
APPLIED FOR THE CLASSICAL WOOD-BASED PANELS AND SOLID WOODS, LEUCO p-SYSTEM TOOLS OFFER:

- | processors of special materials ("material mix")
- | production processes requiring extensive postprocessing

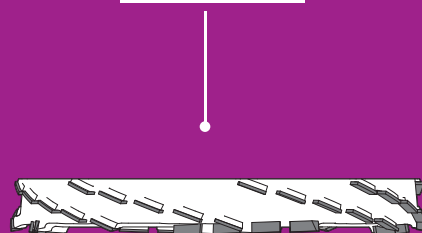
JOINTING



CHAMFERING



RABBETING



GROOVING



p-SYSTEM

APPLICATION

LEUCO p-System tools are applied for jointing, rabbeting, chamfering, dividing and grooving on stationary- and through-feed machines.

INDUSTRY SEGMENT

Universal application in the most various production areas such as corpus production, individual machining of linoleum, flooring or machining of high-gloss boards. Can be used by joineries as well as by industrial woodworking companies.

FEATURES

Uncommon, eye-catching optics of the tools due to the extreme shear angles (shear angle $\geq 55^\circ$)	LEUCO DIA DP cutting edges	Peeled chips which are finer and lighter
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Peel it, see it, feel it!

Catalog page -
3-81,82 and 4-47,48

Further dimensions as well as p-System rabbeting cutters, chamfering cutters, grooving cutters and tools with crowned design on request. Video and information see www.leuco.com → Products → p-System

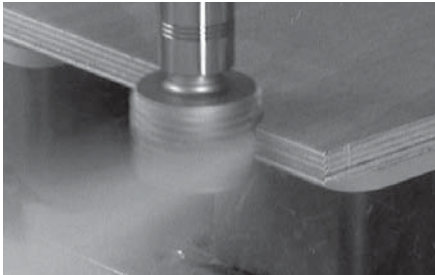
NEW APPLICATION: p-SYSTEM GROOVING CUTTER



Brilliant quality

Especially in the case of small grooving depths it is difficult to reach a good quality with conventional tools. Thanks to the new grooving shank-type cutter on p-System basis the usual p-System quality of the edges is obtained already with 1 mm grooving depth. The p-System grooving cutter even removes and replaces faults in the veneer. It goes without saying that the cutter can also handle the milling of pockets or cut-outs. It is available for various groove width and depths.

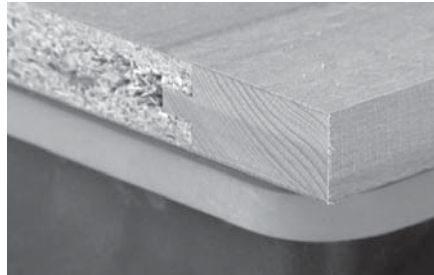
FINISHED



Milling in finish-cut quality without postprocessing

Advantage: The p-System produces edges in finish-cut quality, time-consuming sanding is no longer necessary.

CHIP-FREE



Chip-free jointing of veneer boards

Advantage: The cutting edges of the p-System cut veneer like a sharp knife. Across the veneer they exert less cutting pressure and make a clean cut, regardless whether the veneer overlap is 2 or 10 mm.

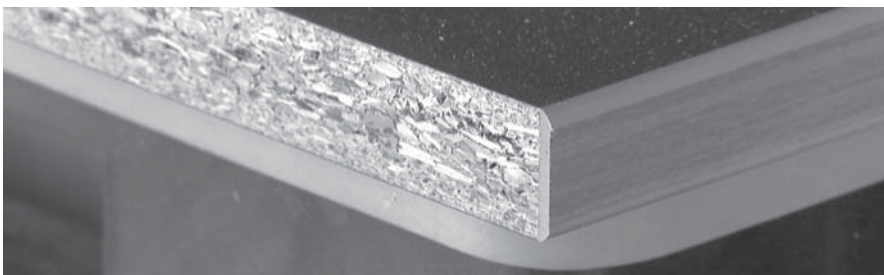
PROTECTION FOIL



Long edge lives in the case of high-gloss material with protection foil

Advantage: Thanks to the shear angle design the p-System cuts the foil „sharp as a razor“.

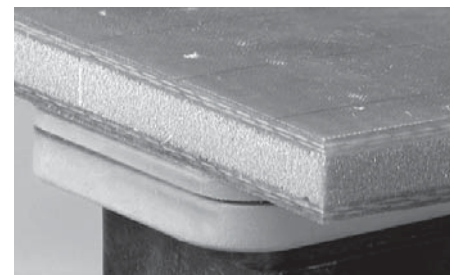
SAVE TIME



Reduction of downtimes

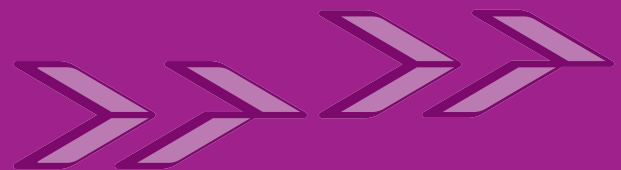
Advantage: In the case of end-grain cutting, the p-System often allows to pass the edge against the feed without causing edge chipping. This also works with edged workpiece materials depending on edge thickness and board quality. Tool changes are no longer necessary, thus machine downtimes can be reduced.

EXOTICS



Fibrous and exotic materials

Advantage: Thanks to the large shear angle the fibers are cleanly cut, often not even additional work steps are needed.



g5-SYSTEM

EXCELLENT CUTTING THANKS TO THE g5-SYSTEM

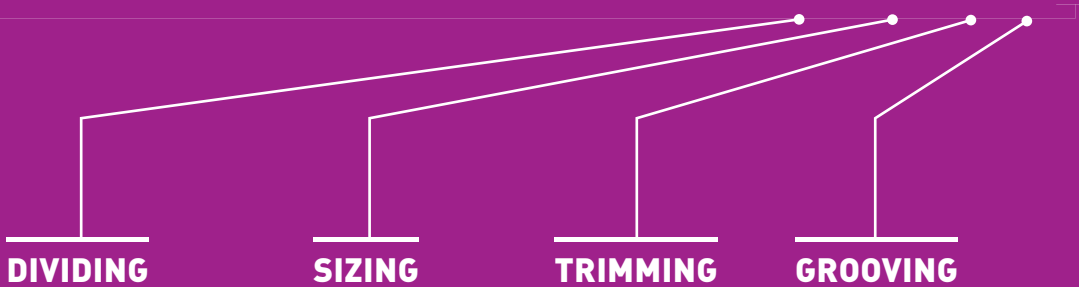
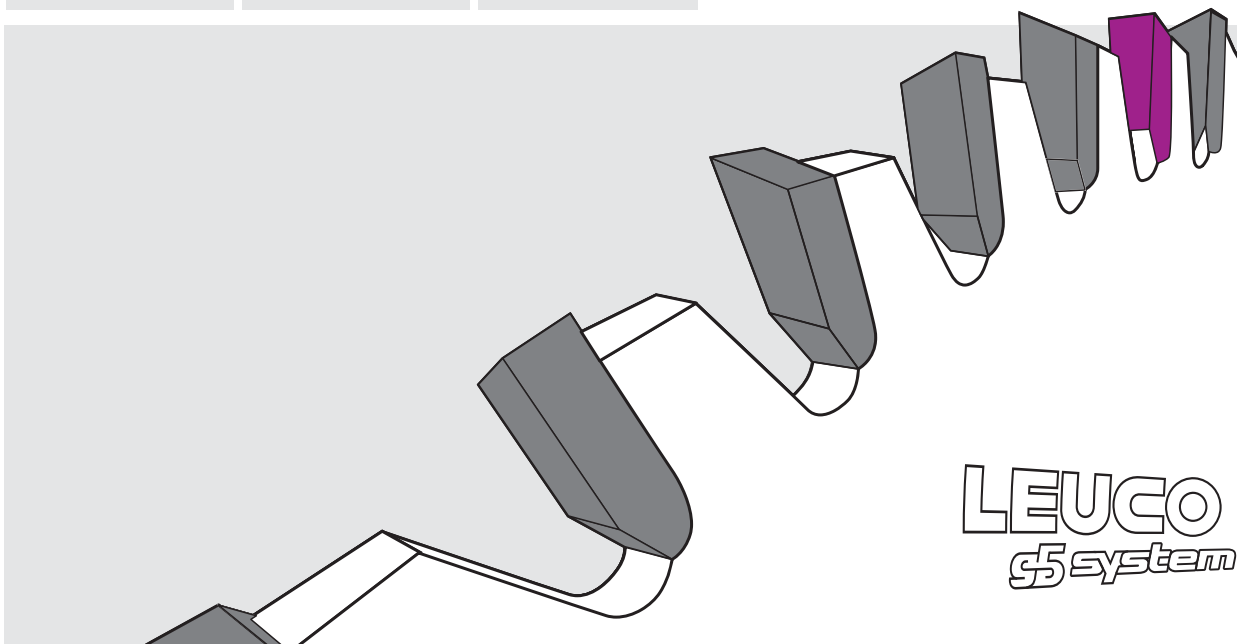
The successful LEUCO g5 tooth combination consisting of ATB right-left-right-left and a flat tooth was transferred to further applications.

g5-SYSTEM STANDS FOR:

- | excellent cutting quality
- | low cutting pressure
- | thin kerfs
- | long edge lives
- | low noise level

FIELDS OF APPLICATION

- | wood-based panels
- | solid wood
- | plastics
- | material mix
- | lightweight materials
- | table saws
- | panel sizing saws
- | clipping saws
- | CNC





„HIGH FIVE” FOR EXCELLENT CUTS

Four alternate top bevel teeth followed by a flat one – that is the LEUCO line up for extremely precise and clean cuts. Much ado about nothing? The user and cabinet manufacturer WOCHNER reports

Excellent cutting quality achieved with a G5 sawblade without counter-piece

The first G5 experience for MD and owner Wolfgang Wochner and his staff was two years ago, when LEUCO ordered cutting samples in various materials for the LIGNA fair. LEUCO supplied the latest developed saw blade to cut the samples. The idea was to prove the precision and quality of the cuts in various materials and profiles. Even when cutting against the grain and without a counter-piece, the cutting quality is absolutely chip-free.

Approximately 50 people are employed by the expert in cabinet making and exclusive timber products in Rosenfeld-Heiligenzimmern. Among the clients are clockwork manufacturers and producers of luxury goods that have wooden components and/or wooden surfaces. They all value the quality and precision of Wochner products, exactly what they expect from their own products, too.

Whether cutting with or against the grain, the G5 gives such a precise and fine finish – it even saves additional treatment. The cutting surfaces have a fine finish and are immediately ready for lacquering or painting. With end cuts across the grain there is no chipping. Therefore no additional grinding is required as is necessary with conventional sawblades. The cutting quality is also identical on both sides. The production process is easier and more efficient.

Special tooth configuration

The secret is the „group-of-five” tooth configuration, combining four alternate top bevel teeth (with shear angle) and one flat tooth. The precision achieved convinced Wolfgang Wochner and his staff immediately, particularly because they process expensive and exclusive solid wood for grandfather clock cabinets, exclusive side boards and cabinets, jewellery boxes, automatic watch movers, Humidors, desks and safe casings. The original and main product still is, however, solid wood grandfather clock cabinets.

Nice and easy

WOCHNER have installed the G5 sawblades on various table saws as well as on their 4 and 5-axis CNC work centers. The employees at these machines are not only satisfied with the quality achieved, but also with the reduced noise emission of the sawblades. Specific laser ornaments reduce the vibration of the saw body and therefore the noise emission.

Low cutting pressure

According to WOCHNER, the reduced kerf of 3 mm for format sawblades and 4 mm for panel sizing sawblades is an additional advantage, because smaller cutting widths mean less cutting pressure. This effect becomes evident when contemplating the power consumption of the machines and the quality, especially when cutting veneer or paper-faced wood-based panels, materials that are frequently in use at WOCHNER.

Universal tool

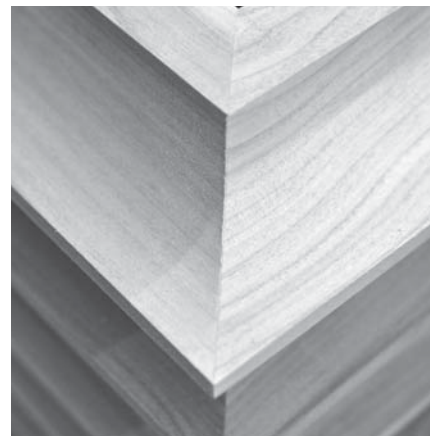
The G5 sawblade also shows its wide range of cutting applications when cutting honeycomb lightweight panels, or when cutting thin plastic profiles. Wolfgang Wochner appreciates the fact that no additional sawblades are required for these types of materials. In addition the G5 sawblades is also a top solution for groove cuts. It is available as a standard item in cutting widths of three, four and 5 mm. Wolfgang Wochner also attaches importance to the fact that materials such as high-gloss, carbon foil coated panels can be cut cleanly. The very demanding manufacturers of high-end loudspeakers like to use this material.

Pictures: Wolfgang Rüter.

Abstract, original report was published in the dds magazine 04/2013



Groove cuts on CNC machining center. WOCHNER carries out inclined cuts.



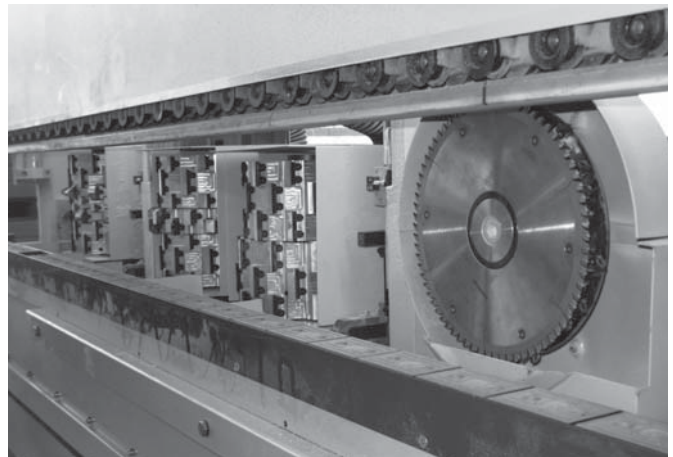
Tight: Whoever has had to do a mitre joint by hand, knows what it takes to achieve such a result.

HIGH PERFORMANCE THANKS TO THE LEUCO APPLICATION CONSULTING

LEUCO is manufacturer and service provider

LEUCO offers consulting to pick the most suitable tool from the product range or to develop individual solutions for the customer for

- | various material requirements and
- | complete machine equipment concepts



OUR MOTIVATION AND CHALLENGE ARE TO TRANSFER THE UNIQUE AND INDIVIDUAL DEMANDS OF OUR CUSTOMERS INTO REALIZABLE SOLUTIONS.

A special challenge in this machine equipment project was to implement the entire process for panel thicknesses of 40 - 240 mm with shiplap implement, trapezoidal groove and tongue, as well as single and double groove with tongue without a tool change.

LEUCO A COMPETENT PARTNER FOR DOOR MANUFACTURERS

Small production batch, high quality expectations – producing door panels in a batch size of 1

Neuform –Türenwerk Hans Glock GmbH & Co. KG manufactures door panels at 2 locations with approximately 240 employees in Germany. Door sizes of up to 3200 x 1600 mm, with a thickness of up to 90 mm and therefore a mass of up to 250 kg per panel, illustrate the extremity of the necessary specifications of the machine and tooling.

Whether 4 or 10 passes are needed per door until finished, the selection of LEUCO tools meets the necessary requirements.

At stations 1 and 2, the panel is scored with the feed. This is carried out by a scoring hogger, which inwardly removes various top surfaces and core materials in a step cut design, which prevents chipping of the trailing edge during cross-processing.

Station 3 is a servo-controlled scoring unit, and at station 4 the whole cutting width is milled with a hogging tool. It is important to cut with a minimised feed rate per tooth; this is also the case for the second and third hogging lines. At stations 5 and 6 the rebate is milled in alternate directions, the second aggregate is a jumping spindle.

At stations 7, 8, 9, 37, 38 and 39 the whole range of door panels are trimmed and Schalllex-grooved in alternate directions with an automatic controlled z-axis. The Neuform product range covers 8 – 34mm and all common double-grooves for the complete door panel.

The jointing cutters are all specifically designed for each door panel width to achieve maximum cutting quality and edge life. For example, the cutters for processing fire-doors have special tooth geometry and cutting material. It is remarkable, that in between these corresponding aggregates there are 26 further stations. The reason for this is the limited space in the formatting section, at the same time this proves the precision of machine and tooling when the same Schalllex-groove is processed over such a distance without any offset.

There is yet another LEUCO specialty at station 10. The rabbet is processed with a special prism rabbeting cutter at an inclination of 45°. In this way a long and soft tooth en-



trance can be achieved. This helps to smoothen the surface and to make the usual cutter marks almost invisible – even after lacquering or spraying.

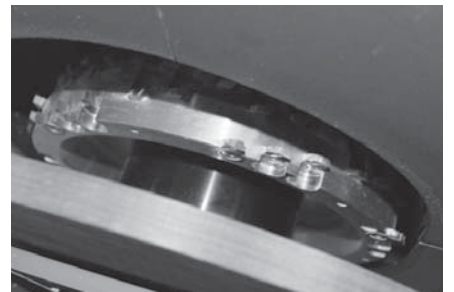
Now the conventional part of door panel and rebate processing is commenced.

At stations 34 and 35 there is a rebate clipping saw with a lower positioned raker tip to avoid adhesion on the side of the teeth. On the multi-profiling units, different radii and bevels can be processed in a batch size 1 manner, within a gap of less than 400mm.

All these rebate processing aggregates have in common that they are specifically designed to cover the extreme variety of door panels and ensure the highest possible productivity of the line.

In a project like this, the challenge for the tool manufacturer is to define together with the customer and the machine manufacturer the technical parameter, performance requirements and processing line-up as well as to support the customer during installation and set-up of the line. LEUCO proves once more to be an innovative, trend-setting and reliable partner for the door manufacturing industry.

The new machine is a unilateral IMA Combi through-feed system, which is equipped with a double feed chain due to the heavy workpieces that can be processed.



This scoring hogger inwardly removes various top surfaces and core materials in a step cut design, which prevents chipping of the trailing edge during cross-processing.



Perfect quality from Neuform: Door panel with foiled edges without chipping; double rebate and 3.5mm door seal



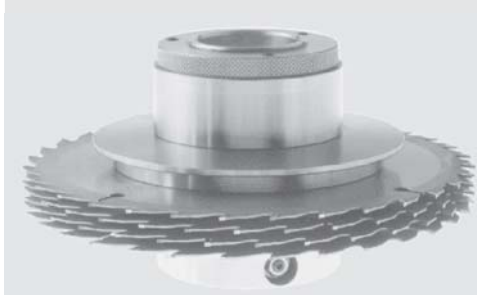
Circular Saw Blades

Product	Page
Thin-Kerf Saw Blades	1-1
Gang-Rip Saw Blades	1-3
Trimming Saw Blades	1-8
Sizing Saw Blades	1-10
Panel Sizing Saw Blades	1-20
Scoring Saw Blades	1-37
Chop Saw Blades	1-50
Chop / Chamfering Saw Blades	1-57
NF Circular Saw Blades	1-58
Portable Saw Blades	1-66
Technical Information	1-69

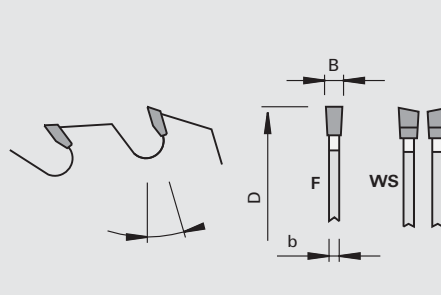
102317 / 102327

Thin-Kerf Saw Blades HW for parquet manufacturing

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- | specially treated tool body with Oxytop coating
- | tooth configuration:
 - | flat "F" for european hard woods (oak, beech, ...)
 - | alternate top bevel "WS" for exotic woods
- | cutting material: HW HL Board 08

Advantages

- | optimum wood yield thanks to thin kerfs

Notes

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

Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry		Ident-No.
180	1,0	0,8	65	24	18	3/11/80	F	Schröder	80254254 o
180	1,0	0,8	65	30	20	3/11/80	WS	Schröder	80254256 o
220	1,2	0,9	60	27	18	3/10/74	F	Weinig	80252288 o
220	1,2	0,9	65	27	18	3/11/80	F	Schröder	80252289 o
220	1,2	0,9	60	30	20	3/10/74	WS	Weinig	80252290 o
220	1,2	0,9	65	30	20	3/11/80	WS	Schröder	80252291 o
220	3,8/3,5	3,0	60	30	18	3/10/74 + 3/11/80	F	Weinig, Schröder	80252292 o
[mm]	[mm]	[mm]	[mm]		[°]				

Saw Blade Adapter Weinig HSK	Ø D	Ø d	Ø d1	L2	L1	Class-No.	Ident-No.
	105	Weinig HSK	60	68	148	997300	182974 o
	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Lock Nuts	105x15xM58x1,5 [mm]	995290	182993 o

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

Spare parts	Ø D	B	Ø d	Class-No.	Ident-No.
Spacer Rings	94	28	60	955520	182198 s
Spacer Rings	94	30	65	955520	182199 s
Cover flange top with handhold	130	16	60	997300	182194 s
Cover flange top with handhold	130	16	65	997300	182196 s
Cover flange bottom	130	14	60	997300	182195 s
Cover flange bottom	130	14	65	997300	182197 s
Spacers	130	4,2	60	955520	182200 s
Spacers	130	4,3	60	955520	182201 s
Spacers	130	4,4	60	955520	182202 s
Spacers	130	4,5	60	955520	182203 s
Spacers	130	4,6	60	955520	182204 s
Spacers	130	4,7	60	955520	182205 s
Spacers	130	4,8	60	955520	182206 s
Spacers	130	4,9	60	955520	182207 s
Spacers	130	5,0	60	955520	182208 s
Spacers	130	4,5	65	955520	182209 s
Spacers	130	4,6	65	955520	182210 s
Spacers	130	4,7	65	955520	182211 s
Spacers	130	4,8	65	955520	182212 s
Spacers	130	4,9	65	955520	182213 s
Spacers	130	5,0	65	955520	182214 s
	[mm]	[mm]	[mm]		

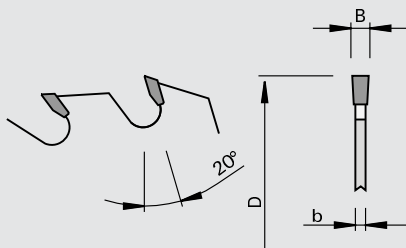
101310 / 101311

Gang-Rip Saw Blades HW „F“

Product



Drawing



LEUCO topline

LEUCO DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	DKN	NL	Class-No.	Ident-No.
200	2,0	1.4	40	20			101311	188029
200	2,4	1.6	40	20			101311	188148
225	2,4	1.6	40	20			101311	188150
250	2,4	1.6	40	24			101311	188151
250	3,2	2.2	70	20	20x5		101310	189300
250	2,8	1.8	70	24	20x5		101311	188030
300	3,2	2.2	70	24	20x5		101310	189301
300	3,2	2.2	80	24	18,5x4	2/13/100	101310	189302
350	3,5	2.5	70	28	20x5		101310	189303
350	3,5	2.5	80	28	18,5x4	2/13/100	101310	188027 &
[mm]	[mm]	[mm]	[mm]		[mm]			

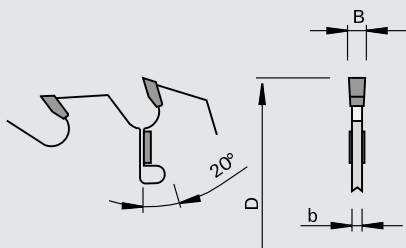
101715

Gang-Rip Saw Blades HW with HW-rakers - solid „F“

Product



Drawing



LEUCO solid

LEUCO DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

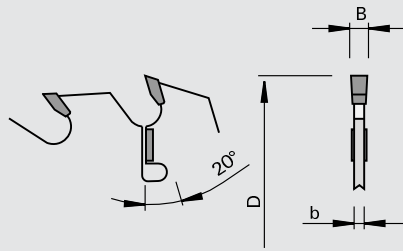
101315

Gang-Rip Saw Blades HW with HW-rakers „F“

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

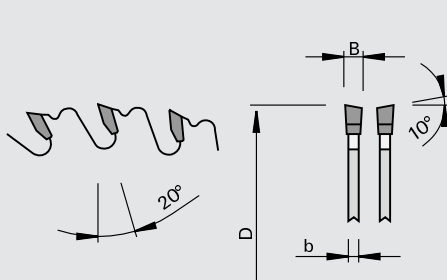
101725

Gang-Rip Saw Blades HW with internal HW-rakers - solid „WS“

Product



Drawing



LEUCO
solid

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	NL	Ident-No.
350	3,5	2,45	30	70	140	24	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189643
400	3,5	2,45	30	80	160	28	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189644
450	4,2	2,8	30	80	160	36	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189645
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

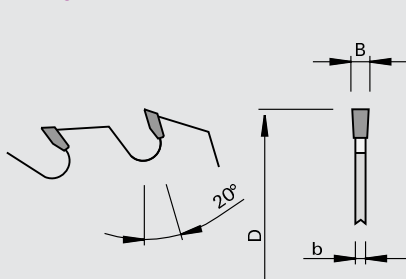
101310

Gang-Rip Saw Blades HW with cooling slots „F“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of cooling slots	DKN	NL	Ident-No.
250	3,4	2,2	30	80	120	24	3			189275
300	3,4	2,2	80	100	140	28	4	18,5x3,5	6/5,5/91 + 4/6,6/95 + 2/13/100	189276
300	3,4	2,2	30	100	130	28	4			189277
350	3,6	2,4	30	100	140	32	4			189279
350	3,6	2,4	80	100	140	32	4	18,5x3,5	6/5,5/91 + 4/6,6/95 + 2/13/100	189280
500	4,0	2,8	30	100	165	40	4			189282
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

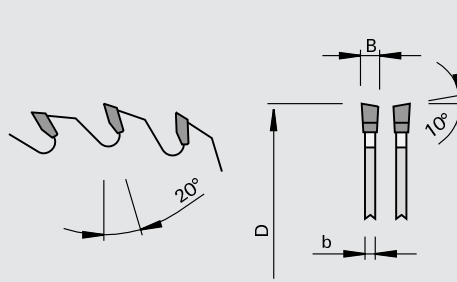
101320

Gang-Rip Saw Blades HW „WS“

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- | staggered double keyways of type A and C
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06 for wood-based materials
- | cutting material: HW HL Solid 15 for solid woods

Advantages

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

Notes

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

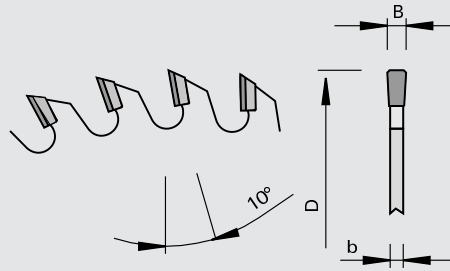
Ø D	B	b	Ø d	Z	DKN	NL	LEUCODUR	Ident-No.
190	3,4	2.2	30	20			HL Solid 15	188049
200	3,2	2.2	60	34		Paul	HL Board 06	188038
200	3,2	2.2	60	42		Paul	HL Board 06	188041
210	3,2	2.2	100	34	12,5x4		HL Board 06	189283
220	3,4	2.2	50	24			HL Solid 15	188051
300	3,2	2.2	80	28	18,5x4	2/13/100	HL Solid 15	188054
300	3,2	2.2	70	36	20x5		HL Solid 15	189285
300	3,2	2.2	80	36	18,5x4	2/13/100	HL Solid 15	189286
300	3,2	2.2	70	48	20x5		HL Solid 15	189287
[mm]	[mm]	[mm]	[mm]		[mm]			

203040

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

Product

Drawing



LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

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

Design

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

Advantages

Notes

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

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

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

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

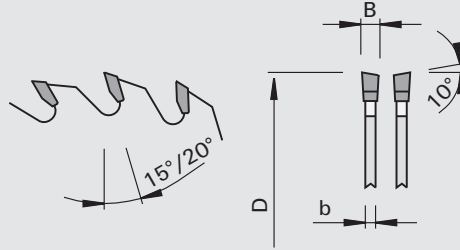
101620/107520

Trimming Saw Blades HW „WS“

Product



Drawing

LEUCO
highlineLEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

- table saws
- for sizing cuts in solid woods

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	Hook angle	NL	Class-No.	Ident-No.
200	3,2	2.2	30	24	20	2/7/42	107520	189932
250	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189933
250	4,4	2.8	30	20	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189934 s
300	3,2	2.2	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189935
300	3,2	2.2	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189936
300	3,2	2.2	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189937
350	3,5	2.5	30	24	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189938
350	3,5	2.5	30	32	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189939
350	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189940
350	4,4	2.8	30	28	15	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189941
400	3,5	2.5	30	28	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189942
400	3,5	2.5	30	36	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189943
450	3,8	2.8	30	40	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189944
500	3,8	2.8	30	44	20	2/7/42 + 2/9,5/46,5 + 2/10/60	101620	189945
[mm]	[mm]	[mm]	[mm]		[°]			

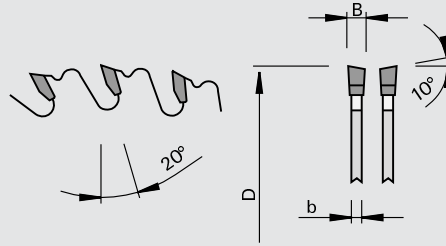
101620

Trimming Saw Blades HW with chip limiter „WS“

Product



Drawing



LEUCO
highline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

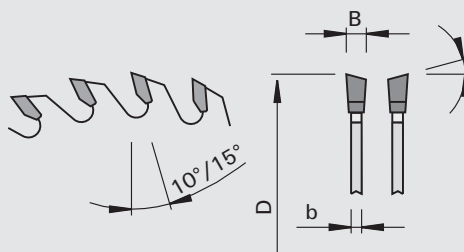
102620/102628/107520

Sizing Saw Blades HW „WS“

Product



Drawing

LEUCO
HighlineLEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

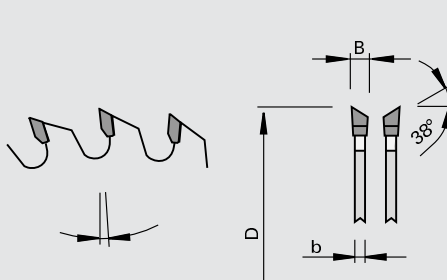
102628

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

Product



Drawing



LEUCO
highline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

- l for profiles, ledges and plastic profiles

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

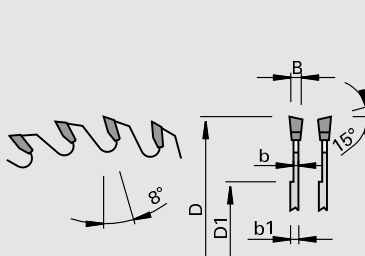
102323

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

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

- l improved stability thanks to relieved tool body

Notes

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

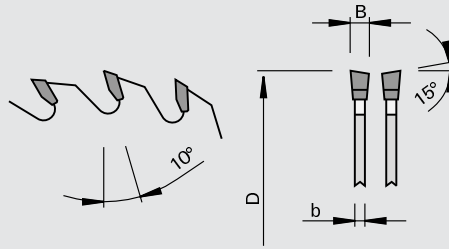
102321

Sizing Saw Blades HW - thin „WS“ - wood-based panels

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

- | long edge lives

Notes

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

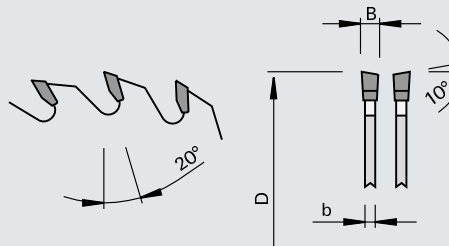
102321

Sizing Saw Blades HW - thin „WS“ - solid woods

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

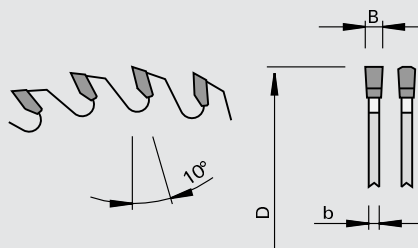
102678

Sizing Saw Blades HW „TR-F“ - hook angle 10°

Product



Drawing



LEUCO
highline

LEUCO
DUR

tungsten carbide [HW]



Machine / Application

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

Design

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

Advantages

- | noise-reduction thanks to laser ornaments

Notes

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

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

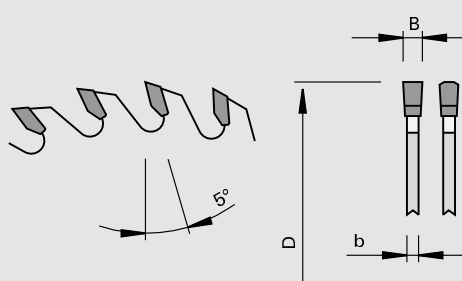
102678

Sizing Saw Blades HW „TR-F“ - hook angle 5°

Product



Drawing



LEUCO
highline

LEUCO
DUR

tungsten carbide [HW]



Machine / Application

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

Design

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

Advantages

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

Notes

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

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

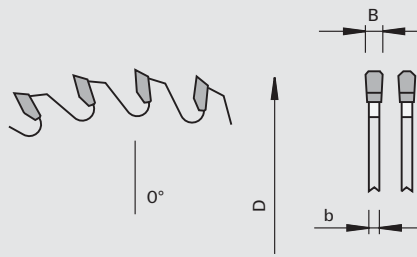
108380

Sizing Saw Blades HW - Solid Surface „TR-F-FA“

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

LOW
VIBRATION

Machine / Application

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

Design

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

Advantages

less vibration and noise thanks
to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303 [mm]	3,2 [mm]	2.5 [mm]	30 [mm]	84	2/7/42 + 2/9,5/46,5 + 2/10/60	189531

202180

DIAREX Sizing Saw Blades DP

Product



Drawing

LEUCO
DIAREX

polycrystalline diamond [DP]

LOW
VIBRATION

Machine / Application

table saws
vertical panel sizing saws
for finished cuts in melamine-
paper- or HPL-laminated panels
and composite materials

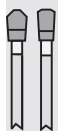
Design

resharpening area 2.0 mm
with laser ornaments

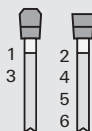
Advantages

long edge lives thanks to tooth
group with higher number of
quality-forming cutting edges
less vibration and noise thanks
to laser ornaments

Notes

**TR-F-FA**

for melamine- or HPL-laminated
panels and composite materials
in combination with scoring
saw blades

**G6**

for melamine-laminated boards
in combination with scoring
saw blades for optimum cutting
quality compared to TR-F-FA

**HR-FA**

- for fine cuts in a great variety of
materials, in many cases even
without scoring saw blade
- for thin composite materials such
as Cfk / Gfk projection 5-10 mm

Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	3,2	2.2	30	48	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	189635
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	189636
303	3,2	2.2	30	84	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	189637
350	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	TR-F-FA	189638
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	G6	189623
303	3,2	2.2	30	60	2/7/42 + 2/9/46 + 2/10/60	HR-FA	189624

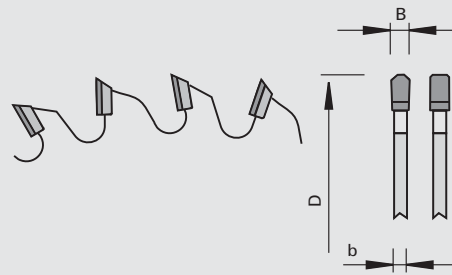
202380

Sizing Saw Blades DP „TR-F-FA“ pos.-neg.

Product



Drawing



polycrystalline diamond [DP]



Machine / Application

- | table saws
- | vertical panel sizing saws
- | for sizing cuts in MDF and hard materials (e.g. Corian, Epoxyplatten, Cfk, Gfk,...)

Design

- | asymmetric chip evacuation gap geometry
- | resharpening area 3.5 mm
- | tooth configuration: triple chip / flat with chamfer "TR-FA" with alternating hook angle positive - negative

Advantages

- | optimized chip removal
- | low cutting pressures
- | noise-reduction thanks to laser ornaments
- | improved cutting quality thanks to optimized entrance and exit angle

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
303	3,2	2.2	30	56	2/7/42+2/9,5/46,5+2/10/60	189560 s
350	3,5	2.5	30	63	2/7/42+2/9,5/46,5+2/10/60	189561 s
[mm]	[mm]	[mm]	[mm]			

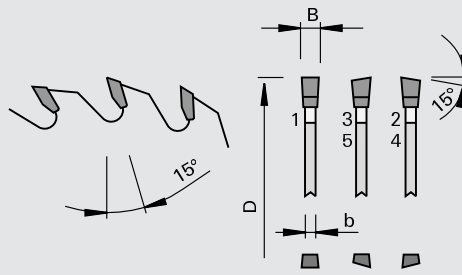
102348

Sizing Saw Blades HW „G5“

Product



Drawing

LEUCO
G5 systemLEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

- | tooth configuration: G5
- | cutting material: HW HL Board O3 plus

Advantages

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

Notes

- | pay attention to nmax!!!

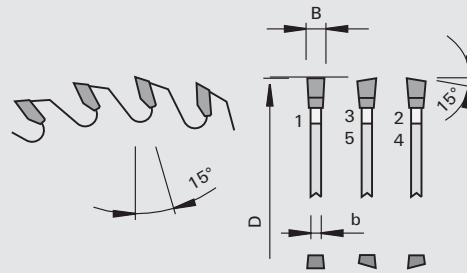
Ø D	B	b	Ø d	Z	NL	Ident-No.
200	3,0	2.2	30	65		192076
220	3,0	2.2	30	70		192077
240	3,0	2.2	30	75		192078
250	3,0	2.2	30	80	2/7/42 + 2/9/46 + 2/10/60	192079
280	3,0	2.2	30	85	2/7/42 + 2/9/46 + 2/10/60	192080
300	3,0	2.2	30	100	2/7/42 + 2/9/46 + 2/10/60	192081
303	3,2	2.2	30	100	2/7/42 + 2/9/46 + 2/10/60	Striebig 192082
315	3,0	2.2	30	100	2/7/42 + 2/9/46 + 2/10/60	192088
350	3,0	2.2	30	100	2/7/42 + 2/9/46 + 2/10/60	192083
380	3,0	2.2	32	120		elumatec 192089
400	3,0	2.2	30	120	2/7/42 + 2/9/46 + 2/10/60	192084
450	3,6	2.8	30	130	2/7/42 + 2/9/46 + 2/10/60	192085
500	3,6	2.8	30	145	2/7/42 + 2/9/46 + 2/10/60	192086
550	4,0	3.2	30	160	2/7/42 + 2/9/46 + 2/10/60	192090
[mm]	[mm]	[mm]	[mm]			
Ø D	B	b	Ø d	Z	NL	Ident-No.
12"	3,0	2.2	1"	100	2/7/42 + 2/9/46 + 2/10/60	192087 s
[inch]	[mm]	[mm]	[inch]			

202380

Sizing Saw Blades DP „G5“

Product

Drawing



LEUCO
G5 system

LEUCO
DIA

polycrystalline diamond [DP]

LOW
noise



Machine / Application

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

Design

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

Advantages

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

Notes

- | pay attention to nmax!!!

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

1023...

Sizing Saw Blades HW - LowNoise

Product



Drawing

LEUCO
topLineLEUCO
DUR

tungsten carbide [HW]



Machine / Application

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

Design

- vibration and noise damping ornaments
- additional expansion slots
- cutting material: HL Board 03 plus and HL Board 06

Advantages

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

Notes

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

**WS**

- HW HL Board 03 plus for raw and laminated panels
- HL Board 06 for solid woods in combination with scoring saw blade

**TR-F / TR-F-FA**

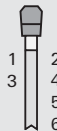
- for raw and laminated panels
- 10° hook angle in combination with scoring saw blade
- 5° hook angle improved bottom edge even without scoring saw blade
- TR-F-FA especially for the machining of Alucobond

**DA-D**

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

**WSA**

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

**G6**

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

**TRD-D-D**

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

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

Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2,2	30	64	10	2/7/42	WS	HL Board 03 plus	102328	192099
250	3,2	2,2	30	60	10	Combi2	WS	HL Board 03 plus	102328	192100
250	3,2	2,2	30	80	10	Combi2	WS	HL Board 03 plus	102328	192101
300	3,2	2,2	30	72	10	Combi2	WS	HL Board 03 plus	102328	192102 \$
300	3,2	2,2	30	96	10	Combi2	WS	HL Board 03 plus	102328	192103 \$
350	3,5	2,5	30	84	10	Combi2	WS	HL Board 03 plus	102328	192104
350	3,5	2,5	30	108	10	Combi2	WS	HL Board 03 plus	102328	192105
350	3,5	2,5	35	84	10		WS	HL Board 03 plus	102328	192106 &
400	3,5	2,5	30	96	10	2/10/60	WS	HL Board 03 plus	102328	192107
400	3,5	2,5	30	120	10	2/10/60	WS	HL Board 03 plus	102328	192108
450	4,0	2,8	30	132	10		WS	HL Board 03 plus	102328	192109
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
300	3,2	2,2	30	96	10	Combi2	WSA	HL Board 03 plus	102328	192110
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2,2	30	64	10	2/7/42	TR-F	HL Board 03 plus	102378	192111
250	3,2	2,2	30	60	10	Combi2	TR-F	HL Board 03 plus	102378	192112
250	3,2	2,2	30	80	10	Combi2	TR-F	HL Board 03 plus	102378	192113
300	3,2	2,2	30	72	10	Combi2	TR-F	HL Board 03 plus	102378	192114
300	3,2	2,2	30	96	5	Combi2	TR-F	HL Board 03 plus	102378	192115 \$
300	3,2	2,2	30	96	10	Combi2	TR-F	HL Board 03 plus	102378	192116 \$
350	3,5	2,5	30	84	10	Combi2	TR-F	HL Board 03 plus	102378	192117
350	3,5	2,5	30	108	10	Combi2	TR-F	HL Board 03 plus	102378	192118
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
250	3,2	2,2	30	60	10	Combi2	TR-F-FA	HL Board 03 plus	102378	192121 &
250	3,2	2,2	30	80	10	Combi2	TR-F-FA	HL Board 03 plus	102378	192122 &
300	3,2	2,2	30	72	10	Combi2	TR-F-FA	HL Board 03 plus	102378	192123 &
300	3,2	2,2	30	96	10	Combi2	TR-F-FA	HL Board 03 plus	102378	192124 &
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
300	3,2	2,2	30	96	5	Combi2	G6	HL Board 03 plus	102378	192119
300	3,2	2,2	30	96	10	Combi2	G6	HL Board 03 plus	102378	192120
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
220	3,2	2,2	30	42	10	2/7/42	DA-D	HL Board 06	102338	189688
250	3,2	2,2	30	48	10	Combi2	DA-D	HL Board 06	102338	189689 \$
303	3,2	2,2	30	60	10	Combi2	DA-D	HL Board 06	102338	189690
303	3,2	2,2	30	60	10	Combi2	DA-D	HL Board 06	102338	189617 \$
350	3,5	2,5	30	72	10	Combi2	DA-D	HL Board 06	102338	189691
400	3,5	2,5	30	84	10	2/10/60	DA-D	HL Board 06	102338	189692
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
250	3,2	2,2	30	48	-6	Combi2	DA-D	HL Board 06	102338	189693
303	3,2	2,2	30	60	-6	Combi2	DA-D	HL Board 06	102338	189694
350	3,5	2,5	30	72	-6	Combi2	DA-D	HL Board 06	102338	189695
[mm]	[mm]	[mm]	[mm]		[°]					
Ø D	B	b	Ø d	Z	Hook angle	NL	Tooth geometry	LEUCODUR	Class-No.	Ident-No.
303	3,2	2,2	30	60	10	Combi2	TRD-D-D	HL Board 03	102338	189842
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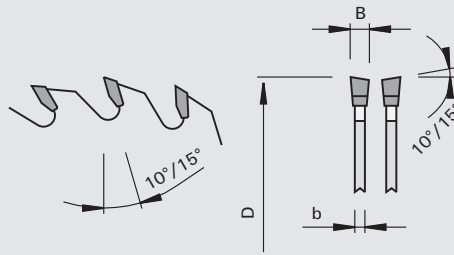
104320

Panel Sizing Saw Blades HW - UniCut „WS“

Product



Drawing



LEUCO
topline

UNICUT

tungsten carbide [HW]

Machine / Application

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

Design

- | up to ØD=355, 10 degree hook angle and 15 degree corner angle
- | from ØD=400, 15 degree hook angle and 10 degree corner angle
- | tooth configuration: alternate top bevel "WS"
- | cutting material: HW HL Board 06

Advantages

Notes

- | for main/scoring saw combinations see specifications (appendix)
- | on double-end tenoners in combination with large hoppers

Ø D	B	b	Ø d	Z	NL	Ident-No.
305	4,4	2,8	30	48		Mayer, Panhans 188498
305	4,4	2,8	60	48		188499
350	4,4	3,0	30	54		SCM, Panhans, Schelling 188503
355	4,4	3,0	30	72		Schelling, Mayer, Irion 188506
355	4,4	3,0	60	54		188504
355	4,4	3,0	60	72		188507
355	4,4	3,0	80	54		S.M.A. 188505
355	4,4	3,0	80	72		S.M.A. 188508
380	4,8	3,5	60	54		S.M.A. 191959
400	4,6	3,2	30	60	2/7/42 + 2/10/60	Schelling, Mayer, Irion, HOLZ-HER 188509
400	4,6	3,2	30	72	2/7/42 + 2/10/60	Schelling, Mayer, Irion, HOLZ-HER 188511
400	4,6	3,2	80	60		S.M.A. 188510 &
400	4,6	3,2	80	72		S.M.A. 188512
430	4,6	3,2	75	72	4/15/105	Giben Prismatic 2 188513
430	4,6	3,2	80	72		S.M.A. 188514
450	4,6	3,2	30	54		Panhans, Irion, Schelling 188515
450	4,6	3,2	80	72		S.M.A., Irion 188516
500	4,6	3,2	30	60		Schelling, Irion 188517
500	4,6	3,2	80	60		Teutomatic 188518
550	5,0	3,5	80	60		Teutomatic 188521
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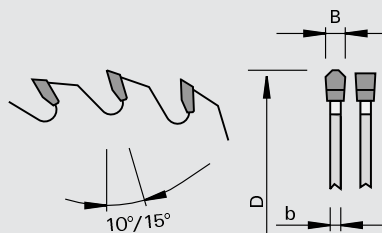
104378

Panel Sizing Saw Blades HW - UniCut „TR-F“

Product



Drawing



LEUCO
topline



tungsten carbide [HW]



Machine / Application

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

Design

l up to ØD=360, 10 degree hook angle
l from ØD=380, 15 degree hook angle
l tooth configuration: triple chip / flat "TR-F"
l cutting material: HW HL Board 03 plus

Advantages

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

Notes

l specifically for plastic-laminated panels and plywood in single sheets and stacks

Ø D	B	b	Ø d	Z	NL		Ident-No.
300	4,4	2,8	30	60	2/7/42 + 2/9/46 + 2/10/60	Panhans Euro P8	192025
300	4,4	3,0	75	72		Homag Espana	192026
305	3,2	2,2	30	60	2/7/42 + 2/9/46 + 2/10/60	Scheer FM 16	192027
305	4,4	2,8	30	60	2/7/42 + 2/9/46 + 2/10/60	Mayer, Panhans	192029
305	4,4	2,8	60	60		Hoggers	192028
320	4,4	3,2	65	60	2/9/110	Biesse, Selco EB 80	192031
320	4,4	3,2	75	72	3/13/95	Giben Smart	192030
350	4,4	3,0	30	72	2/7/42 + 2/9/46 + 2/10/60	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192033 \$
350	4,4	3,2	60	72	2/14/100	Holzma 72, HPP 350	192034
350	4,4	3,0	75	60		Giben MK Gamma	192032
355	4,4	3,0	75	60		Giben Trend, Homag CH06+10	192038
355	4,4	3,0	75	72	4/15/105	Giben	192037
355	4,4	3,0	80	72	4/19/120 + 2/8,4/130	S.M.A., hoggers	192035
355	4,4	3,0	80	72	4/8,5/100 + 2/14/110 + 2/7/110	Gabbiani PRIMA, SCM ALPHA	192036
360	4,4	3,2	65	72	2/9/110	Selco	192039
380	4,4	3,2	60	72	2/14/100 + 2/14/125	Holzma	192040
380	4,8	3,5	60	72	2/14/100 + 2/14/125	Holzma	192041 \$
400	4,25	3,2	30	72		Scheer	192042
400	4,4	3,2	30	72	2/7/42 + 2/10/60	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192045
400	4,4	3,2	30	96			192046
400	4,4	3,2	60	72		Anthon	192044 &
400	4,8	3,5	60	72	2/14/100 + 2/14/125	Holzma type 01	192048
400	4,4	3,2	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	192047 \$
400	4,4	3,2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	Selco WN / EB, S.M.A., Irion	192043
420	4,8	3,5	60	72	2/10/80 + 2/14/125	Holzma	192049
430	4,4	3,2	30	72	2/7/42 + 2/10/60		192053
430	4,4	3,2	60	72	1/11/85	Anthon	192052
430	4,4	3,2	75	96	4/15/105 + 2/7/110	Giben Prismatic 2 old	192051
[mm]	[mm]	[mm]	[mm]				

Ø D	B	b	Ø d	Z	NL	Ident-No.
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	Selco WN 192050
450	4,4	3.2	30	72		Irion, Schelling 192125
450	4,8	3.5	60	72	2/19/120 + 2/14/125	Holzma 192056 \$
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	S.M.A., Irion 192054
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	Selco WN 192055
460	4,4	3.2	30	72	2/13/94	Schelling FL, FH 6 192057
470	4,4	3.2	75	72	4/15/105	Giben 192059
470	4,4	3.2	75	96	4/15/105	Giben Prismatic 3 192058
480	4,4	3.2	30	72		Schelling FL ab 211.145 192060
480	4,8	3.5	60	72	2/11/115 + 2/19/120	Holzma 530 192062
480	4,8	3.5	80	72	4/19/120 + 2/8,4/130	Selco WN 192061
500	4,4	3.2	30	60		Schelling, Irion 192063
500	4,8	3.5	60	72	2/11/115	Holzma type 22 192064
520	4,8	3.5	30	72	2/13/94	Schelling FH 8 192066
520	4,8	3.5	60	72	2/11/115 + 2/19/120	Holzma type 23 192065
550	5,0	3.5	100	72		Giben 192067
565	5,0	3.5	100	72		Giben 192068
600	5,8	4.0	60	72	2/11/115 + 2/19/120	Holzma type 42 192069
650	6,2	4.0	40	72		Schelling 192070
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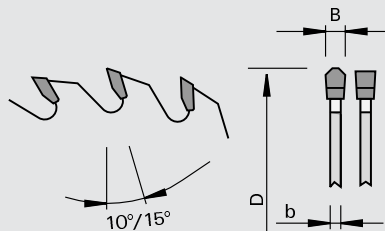
104278

Panel Sizing Saw Blades HW - UniCut Plus "TR-F" - LowNoise

Product



Drawing



LEUCO
topline

UNICUT PLUS

tungsten carbide [HW]

LOW NOISE

Machine / Application

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

Design

- vibration and noise damping ornaments
- additional expansion slots
- up to ØD=350, 10 degree hook angle
- from ØD=380, 15 degree hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW HL Board 03 plus

Advantages

- for highest performance demands
- impressive cutting quality thanks to exact and precise cuts without chippings
- reduced cutting pressure and power consumption thanks to optimized cutting geometry
- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- clearly increased edge life thanks to improved HW grade

Notes

- specifically for plastic-laminated panels and plywood in single sheets and small stacks

Ø D	B	b	Ø d	Z	NL		Ident-No.
320	4,4	3,2	30	72	2/7/42 + 2/9/46 + 2/10/60	Mayer / Format 4	192129
320	4,4	3,2	65	60	2/9/110	Biesse, Selco EB 80	191954
350	4,4	3,0	30	72	2/7/42 + 2/9/46 + 2/10/60	SCM, Panhans, Mayer, Schelling, HOLZ-HER	189898
350	4,4	3,2	60	72	2/14/100	Holzma 72, HPP350	189897
380	4,4	3,2	60	72	2/14/100 + 2/14/125	Holzma	191955
380	4,8	3,5	60	72	2/14/100 + 2/14/125	Holzma	189901
400	4,4	3,2	30	72	2/7/42 + 2/10/60	Schelling, Mayer, Irion, Scheer, HOLZ-HER	189899
400	4,4	3,2	75	72	4/15/105	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	189900 &
430	4,4	3,2	80	72	4/19/120 + 2/8,4/130	Selco WN	192017
450	4,4	3,2	30	72		Irion, Schelling	192018
450	4,8	3,5	60	72	2/19/120 + 2/14/125	Holzma	189902
450	4,8	3,5	80	72	4/19/120 + 2/8,4/130	Selco WN 600/132	192019 &
480	4,8	3,5	60	72	2/11/115 + 2/19/120	Holzma	192020
480	4,8	3,5	80	72	4/19/120 + 2/8,4/130	Selco WN	192021
520	4,8	3,5	30	72	2/13/94	Schelling fh8	192022
520	4,8	3,5	60	72	2/11/115 + 2/19/120	Holzma	192023
520	4,8	3,5	70	72	4/11/130	Selco Series 750	192024 &
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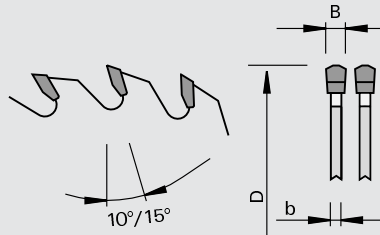
104378

Panel Sizing Saw Blades HW - UniCut „TR-TR“

Product



Drawing



LEUCO
topLine

UNI-CUT

tungsten carbide [HW]

LOW
VIBRATION

Machine / Application

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

Design

- up to $\text{ØD}=360$, 10 degree hook angle
- from $\text{ØD}=380$, 15 degree hook angle
- tooth configuration: triple chip / triple chip "TR-TR"
- cutting material: HW HL Board 03 plus

Advantages

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

Notes

- specifically for plastic-laminated panels and plywood in single sheets and stacks

Ø D	B	b	Ø d	Z	NL		Ident-No.
350	4,4	3,2	75	72		Homag Sawtech, Holzma 250	192071
500	4,8	3,5	60	72	2/11/115	Holzma type 22	192072 &
[mm]	[mm]	[mm]	[mm]				

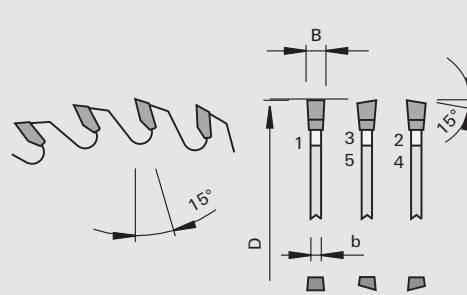
104378

Panel Sizing Saw Blades HW - UniCut G5 - LowNoise

Product



Drawing



LEUCO
G5 system



tungsten carbide [HW]



Machine / Application

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

Design

- | vibration and noise damping ornaments
- | additional expansion slots
- | tooth configuration: G5
- | cutting material: HW HL Board O3 plus

Advantages

- | excellent cutting quality for cross cuts
- | very low cutting pressure and reduced power consumption thanks to optimized cutting geometry
- | extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations

Notes

- | specifically for plastic-laminated panels and plywood in single sheets and small stacks

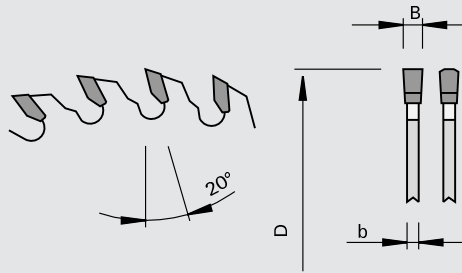
Ø D	B	b	Ø d	Z	NL	Ident-No.
350	4,0	3.2	30	80	2/7/42 + 2/9/46 + 2/10/60	SCM, Panhans, Mayer, Schelling, HOLZ-HER 192073
350	4,0	3.2	60	80	2/14/100	Holzma 192261
380	4,0	3.2	60	80	2/14/100 + 2/14/125	Holzma 192074
450	4,0	3.2	60	90	2/14/100 + 2/14/125	Holzma 192075
[mm]	[mm]	[mm]	[mm]			

104270

Panel Sizing Saw Blades HW - SpeedCut Plus "TR-F" - LowNoise

Product

Drawing

LEUCO
toplineLEUCO
HW HL Board
SPEED-CUT

tungsten carbide [HW]

LOW
NOISE

Machine / Application

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

Design

vibration and noise damping ornaments
additional expansion slots
tooth configuration: triple chip / flat "TR-F"
cutting material: HW HL Board 03 plus

Advantages

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

Notes

stack height: Ident-No. 189913 up to max. 190 mm / Ident-No. 189914 up to max. 210 mm / Ident-No. 189915 up to max. 215 mm
recommended projection: 20-30 mm

Ø D	B	b	Ø d	Z	NL		Ident-No.
480	4,8	3.5	60	48	2/11/115 + 2/19/120	Holzma 530	189903
520	4,8	3.5	60	60	2/11/115 + 2/19/120	Holzma	189904
530	5,0	3.5	30	60		Schelling	189905
530	5,8	4.0	60	60	1/11/85	Anthon	189906
565	5,0	3.5	100	60		Giben	189907
570	4,8	3.5	60	60	2/11/115 + 2/19/120	Holzma	189908
570	5,8	4.0	60	60	2/11/115 + 2/19/120	Holzma	189909
600	5,8	4.0	60	60	2/11/115 + 2/19/120	Holzma 33/42	189910
650	6,2	4.0	40	60		Schelling	189911
670	6,0	4.4	60	48	2/11/148 + 2/19/120	Holzma 66 (Tandem)	189912
680	6,4	4.4	40	60	2/17/140 + 2/13/140	Schelling AS	189913
700	6,4	4.4	80	60	2/17/110	Anthon	189914
720	6,4	4.4	40	60	2/13/114 + 2/13/140	Schelling	189915
730	6,4	4.4	60	60	2/11/148 + 2/19/120	Holzma 66 (Tandem)	189917
730	6,4	4.4	80	60	2/17/110	Anthon LNC	189916
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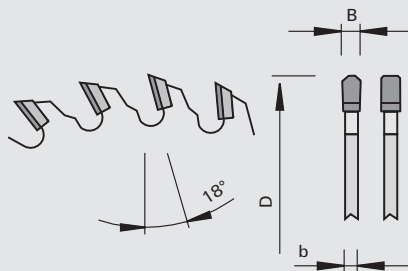
204385

Panel Sizing Saw Blades DP - SpeedCut Plus „TR-F-FA“

Product



Drawing



LEUCO
topline

LEUCO
SPEED-CUT

polycrystalline diamond [DP]

Machine / Application

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

Design

- | resharpening area 5 mm
- | tooth configuration: triple chip / flat with chamfer "TR-FA"

Advantages

- | for highest performance demands
- | reduced cutting pressure and power consumption thanks to optimized cutting geometry
- | improved vibration behaviour and chip removal thanks to asymmetric chip evacuation gap geometry
- | highest wear-resistance
- | extremely long teeth for better guide and improved service possibilities

Notes

- | recommended projection: 20-30 mm

Ø D	B	b	Ø d	Z	NL		Ident-No.
530	5,8	4.0	60	60	1/11/85	Anthon	189550 s
570	4,8	3.5	60	60	2/11/115 + 2/19/120	Holzma	189551 s
600	5,8	4.0	60	60	2/11/115 + 2/19/120	Holzma 33 / 42	189552 s
650	6,2	4.0	40	60		Schelling	189553 s
670	6,0	4.4	60	48	2/11/148 + 2/19/120	Holzma 66 (Tandem)	189554 s
680	6,4	4.4	40	60	2/17/140 + 2/12/140	Schelling AS	189555 s
700	6,4	4.4	80	60	2/17/110	Anthon	189556 s
720	6,4	4.4	40	60	2/13/114 + 2/13/140	Schelling	189557 s
730	6,4	4.4	60	60	2/19/120 + 2/11/148	Holzma 66 (Tandem)	189558 s
730	6,4	4.4	80	60	2/17/110	Anthon LNC	189559 s
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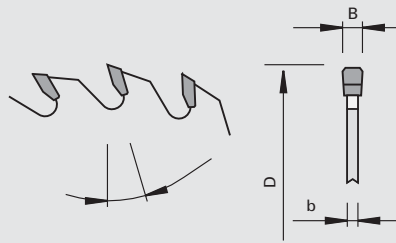
104348

Panel Sizing Saw Blades HW - FinishCut „F-FA“

Product



Drawing



LEUCO
topline

LEUCO
FINISH-CUT

tungsten carbide [HW]

LOW
noise

Machine / Application

panel sizing saws
for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 100 mm cutting height

Design

tooth configuration: flat with chamfer "F-FA"
cutting material: HW HL Board 03

Advantages

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

Notes




projection: min 20 - 25 mm
max 40 mm

Ø D	B	b	Ø d	Z	NL		Ident-No.
280	3,2	2.2	30	60		Panhans EURO 5	189205
300	4,4	3.2	60	72	2/14/100	Holzma HPP 230	192128
300	4,4	3.0	65	60	2/8,4/110	Selco EB 70	189203
300	4,4	3.0	75	60		Homag CH03	189204
305	4,4	2.8	30	60	2/7/42 + 2/9/46 + 2/10/60	Mayer, Panhans	189200
330	4,4	3.2	50	60	8/13/80	Giben	189251
350	4,25	3.2	30	72	2/7/42 + 2/9/46 + 2/10/60	Scheer	189195 &
350	4,4	3.2	30	72	2/7/42 + 2/9/46 + 2/10/60	SCM, Panhans, Mayer, Schelling, HOLZ-HER	189189
350	4,4	3.2	50	72	8/12,5/80	Giben Smart	189188
350	4,4	3.2	60	72	2/14/100	Holzma 72, HPP 350	189187
350	4,4	3.2	75	72		Homag Sawtech, Holzma 250	189229
355	4,4	3.2	75	72		Giben	189185
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	Gabbiani PRIMA, SCM ALPHA	189182 &
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	Selco EB 90	189179 &
360	4,4	3.2	75	72	4/15/105	Giben	189177
370	4,4	3.2	30	72		Schelling FM from 202180	189176
380	4,4	3.2	50	72	4/12,5/80	Giben Onyx	189175
380	4,4	3.2	60	72	2/14/100 + 2/14/125	Holzma	189174
380	4,8	3.5	60	72	2/14/100 + 2/14/125	Holzma	189172 \$
400	4,25	3.2	30	72		Scheer	189169 &
400	4,4	3.2	30	72	2/7/42 + 2/10/60	Scheer, HOLZ-HER	181691
400	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 1, Giben Starmatic, Homag CH08+12	189163
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	Gabbiani CLASS, Scm DELTA	189159
400	4,4	3.2	80	72	4/19/120 + 2/8,4/130	Selco WN / EB	189160 &
420	4,8	3.5	60	72	2/10/80 + 2/14/125	Holzma type 92	189156
430	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 2 old	189152
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	Selco WN	189150
450	4,4	3.2	30	72		Irion, Schelling	189147
450	4,65	3.5	30	72	2/9/60	Scheer	189144 &
450	4,8	3.5	30	72	2/9/60	Scheer	189143
[mm]	[mm]	[mm]	[mm]				




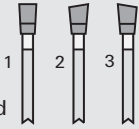
Ø D	B	b	Ø d	Z	NL	Ident-No.
450	4,8	3.5	60	72	2/19/120 + 2/14/125	Holzma 189140 \$
450	4,4	3.2	75	72	2/7/110	Gibben 189663
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	Gabbiani ELITE 189146 &
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	Selco WN 189139 &
460	4,4	3.2	30	72	2/13/94	Schelling FL, FH6 189249
470	4,4	3.2	75	72	4/15/105	Giben 189248 #
480	4,8	3.5	60	72	2/11/115 + 2/19/120	Holzma 530 189241
520	4,8	3.5	60	72	2/11/115 + 2/19/120	Holzma 23 / 550 189250
[mm]	[mm]	[mm]	[mm]			

2043..

Panel Sizing Saw Blades DP - flexible & quick

Product	Drawing	  polycrystalline diamond [DP] 
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Machine / Application	Design	Advantages	Notes
panel sizing saws for sizing cuts in raw and plastic-laminated panels	Saw blade body with vibration- and noise-dampening ornaments diamond cutting edges with polished design LEUCODIA tipping quality optimized cutting geometry depending on the respective tooth form for main and scoring saw blades	for each application case the correct tooth form short delivery times interesting scaled prices	all flat and alternate bevel teeth with protection chamfer further dimensions and tooth forms on request

 <p>TR-F-FA UniCut Single and book cuts, focus on universality</p>	 <p>G6 UniCut Plus Improved edge live compared to standard UniCut, reduced motor power</p>
 <p>WS-FA UniCut Single and book cuts in uncovered or veneered panel materials and plywood</p>	 <p>G3 UniCut Reduced cutting pressure and increased edge life</p>

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
350	4,4	3.2	75	72		TR-F-FA	Homag Sawtech, Holzma 250	189380 s
350	4,4	3.2	75	72		G6	Homag Sawtech, Holzma 250	189385 s
350	4,4	3.2	75	72		WS-FA	Homag Sawtech, Holzma 250	189395 s
350	4,4	3.2	75	72		G3	Homag Sawtech, Holzma 250	189390 s
350	4,4	3.2	60	72	2/14/100	TR-F-FA	Holzma 72, HPP350	189381 s
350	4,4	3.2	60	72	2/14/100	G6	Holzma 72, HPP350	189386 s
350	4,4	3.2	60	72	2/14/100	WS-FA	Holzma 72, HPP350	189396 s
350	4,4	3.2	60	72	2/14/100	G3	Holzma 72, HPP350	189391 s
350	4,4	3.2	50	72	8/12,5/80	TR-F-FA	Giben Smart	189382 s
350	4,4	3.2	50	72	8/12,5/80	G6	Giben Smart	189387 s
350	4,4	3.2	50	72	8/12,5/80	WS-FA	Giben Smart	189397 s
350	4,4	3.2	50	72	8/12,5/80	G3	Giben Smart	189392 s
350	4,4	3.2	30	72	2/10/60	TR-F-FA	SCM, Panhans, Mayer, Schelling, Scheer	189383 #
350	4,4	3.2	30	72	2/10/60	G6	SCM, Panhans, Mayer, Schelling, Scheer	189388 s
350	4,4	3.2	30	72	2/10/60	WS-FA	SCM, Panhans, Mayer, Schelling, Scheer	189398 s
350	4,4	3.2	30	72	2/10/60	G3	SCM, Panhans, Mayer, Schelling, Scheer	189393 s
350	4,25	3.2	30	72	2/10/60	TR-F-FA	Scheer	189384 s
350	4,25	3.2	30	72	2/10/60	G6	Scheer	189389 s
350	4,25	3.2	30	72	2/10/60	WS-FA	Scheer	189399 s
[mm]	[mm]	[mm]	[mm]					




Panel Sizing Saw Blades

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
350	4,25	3.2	30	72	2/10/60	G3	Scheer	189394 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco EB 90	189405 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G6	Selco EB 90	189408 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	WS-FA	Selco EB 90	189414 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G3	Selco EB 90	189411 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani PRIMA, SCM ALPHA	189406 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani PRIMA, SCM ALPHA	189409 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	WS-FA	Gabbiani PRIMA, SCM ALPHA	189415 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani PRIMA, SCM ALPHA	189412 s
355	4,4	3.2	75	72	4/15/105	TR-F-FA	Giben	189407 s
355	4,4	3.2	75	72	4/15/105	G6	Giben	189410 s
355	4,4	3.2	75	72	4/15/105	WS-FA	Giben	189416 s
355	4,4	3.2	75	72	4/15/105	G3	Giben	189413 s
380	4,8	3.5	60	72	2/14/100 + 2/14/125	TR-F-FA	Holzma	189420 #
380	4,8	3.5	60	72	2/14/100 + 2/14/125	G6	Holzma	189421 s
380	4,8	3.5	60	72	2/14/100 + 2/14/125	WS-FA	Holzma	189423 s
380	4,8	3.5	60	72	2/14/100 + 2/14/125	G3	Holzma	189422 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	TR-F-FA	Selco WN / EB	189425 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G6	Selco WN / EB	189430 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	WS-FA	Selco WN / EB	189440 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G3	Selco WN / EB	189435 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA		189426 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6		189431 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	WS-FA		189441 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3		189436 s
400	4,4	3.2	75	72	4/15/105	TR-F-FA	Giben, Homag CH08+12	189427 s
400	4,4	3.2	75	72	4/15/105	G6	Giben, Homag CH08+12	189432 s
400	4,4	3.2	75	72	4/15/105	WS-FA	Giben, Homag CH08+12	189442 s
400	4,4	3.2	75	72	4/15/105	G3	Giben, Homag CH08+12	189437 s
400	4,4	3.2	60	72		TR-F-FA	Anthon	189428 s
400	4,4	3.2	60	72		G6	Anthon	189433 s
400	4,4	3.2	60	72		WS-FA	Anthon	189443 s
400	4,4	3.2	60	72		G3	Anthon	189438 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	TR-F-FA	Schelling, Mayer, Irion, Scheer, HOLZ-HER	189429 #
400	4,4	3.2	30	72	2/7/42 + 2/10/60	G6	Schelling, Mayer, Irion, Scheer, HOLZ-HER	189434 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	WS-FA	Schelling, Mayer, Irion, Scheer, HOLZ-HER	189444 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	G3	Schelling, Mayer, Irion, Scheer, HOLZ-HER	189439 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	189450 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	189455 s
430	4,4	3.2	80	72	4/19/120 + 8/8,4/130	WS-FA	Selco WN	189465 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	189460 s
430	4,4	3.2	80	72	2/8,3/130	TR-F-FA	S.M.A., hogggers	189451 s
430	4,4	3.2	80	72	2/8,3/130	G6	S.M.A., hogggers	189456 s
430	4,4	3.2	80	72	2/8,3/130	WS-FA	S.M.A., hogggers	189466 s
430	4,4	3.2	80	72	2/8,3/130	G3	S.M.A., hogggers	189461 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	TR-F-FA	Giben Prismatic 2 old	189452 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	G6	Giben Prismatic 2 old	189457 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	WS-FA	Giben Prismatic 2 old	189467 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	G3	Giben Prismatic 2 old	189462 s
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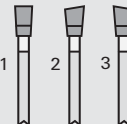
Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident.No.
430	4,4	3.2	60	72	1/11/85	TR-F-FA	Anthon	189453 s
430	4,4	3.2	60	72	1/11/85	G6	Anthon	189458 s
430	4,4	3.2	60	72	1/11/85	WS-FA	Anthon	189468 s
430	4,4	3.2	60	72	1/11/85	G3	Anthon	189463 s
430	4,4	3.2	30	72		TR-F-FA		189454 s
430	4,4	3.2	30	72		G6		189459 s
430	4,4	3.2	30	72		WS-FA		189469 s
430	4,4	3.2	30	72		G3		189464 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	TR-F-FA	S.M.A., Irion	189475 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	G6	S.M.A., Irion	189478 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	WS-FA	S.M.A., Irion	189484 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	G3	S.M.A., Irion	189481 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani ELITE	189476 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani ELITE	189479 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	WS-FA	Gabbiani ELITE	189485 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani ELITE	189482 s
450	4,4	3.2	30	72		TR-F-FA	Irion, Schelling	189477 #
450	4,4	3.2	30	72		G6	Irion, Schelling	189480 s
450	4,4	3.2	30	72		WS-FA	Irion, Schelling	189486 s
450	4,4	3.2	30	72		G3	Irion, Schelling	189483 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	189490 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	189492 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	WS-FA	Selco WN	189496 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	189494 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	TR-F-FA	Holzma	189491 #
450	4,8	3.5	60	72	2/14/125 + 2/19/120	G6	Holzma	189493 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	WS-FA	Holzma	189497 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	G3	Holzma	189495 s
460	4,4	3.2	30	72	2/13/94	TR-F-FA	Schelling FL, FH6	189500 s
460	4,4	3.2	30	72	2/13/94	G6	Schelling FL, FH6	189502 s
460	4,4	3.2	30	72	2/13/94	WS-FA	Schelling FL, FH6	189506 s
460	4,4	3.2	30	72	2/13/94	G3	Schelling FL, FH6	189504 s
460	4,4	3.2	75	72	4/15/105	TR-F-FA	Giben Prismatic 3	189501 s
460	4,4	3.2	75	72	4/15/105	G6	Giben Prismatic 3	189503 s
460	4,4	3.2	75	72	4/15/105	WS-FA	Giben Prismatic 3	189507 s
460	4,4	3.2	75	72	4/15/105	G3	Giben Prismatic 3	189505 s
480	4,8	3.5	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	189510 s
480	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	189513 s
480	4,8	3.5	80	72	4/19/120 + 2/8,4/130	WS-FA	Selco WN	189519 s
480	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	189516 s
480	4,8	3.5	60	72	2/19/120	TR-F-FA	Holzma	189511 s
480	4,8	3.5	60	72	2/19/120	G6	Holzma	189514 s
480	4,8	3.5	60	72	2/19/120	WS-FA	Holzma	189520 s
480	4,8	3.5	60	72	2/19/120	G3	Holzma	189517 s
480	4,8	3.5	30	72		TR-F-FA	Schelling FL from 211,145	189512 s
480	4,8	3.5	30	72		G6	Schelling FL from 211,145	189515 s
480	4,8	3.5	30	72		WS-FA	Schelling FL from 211,145	189521 s
480	4,8	3.5	30	72		G3	Schelling FL from 211,145	189518 s
500	4,8	3.5	60	72	2/11/115	TR-F-FA	Holzma 22	189569 s
500	4,8	3.5	60	72	2/11/115	G3	Holzma 22	189586 s
600	5,8	4.0	60	72	2/11/115+2/19/120	TR-F-FA	Holzma 42, 33	189570 s
600	5,8	4	60	72	2/11/115+2/19/120	G3	Holzma 42, 33	189587 s
[mm]	[mm]	[mm]	[mm]					

2043..

Panel Sizing Saw Blades DP - nn-System

Product	Drawing	  polycrystalline diamond [DP]
		

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> panel sizing saws for sizing cuts in raw and plastic-laminated panels 	<ul style="list-style-type: none"> special NoNoise gullet geometry diamond cutting edges with polished design LEUCODIA tipping quality 	<ul style="list-style-type: none"> especially low noise level noise reduction by approx. 6 db(A) when idling for each application case the correct tooth form short delivery times interesting scaled prices 	<ul style="list-style-type: none"> all flat and alternate bevel teeth with protection chamfer further dimensions and tooth forms on request

 <p>TR-F-FA Single and book cuts, focus on universality</p>	 <p>G6 Improved edge live compared to TR-F-FA, reduced motor power</p>	 <p>G3 Reduced cutting pressure for veneered boards, plywood boards and honeycomb panels</p>
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Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
350	4,4	3.2	75	72		TR-F-FA	Homag Sawtech, Holzma 250	192319 s
350	4,4	3.2	75	72		G6	Homag Sawtech, Holzma 250	192320 s
350	4,4	3.2	75	72		G3	Homag Sawtech, Holzma 250	192321 s
350	4,4	3.2	60	72	2/14/100	TR-F-FA	Holzma 72, HPP350	192322 s
350	4,4	3.2	60	72	2/14/100	G6	Holzma 72, HPP350	192323 s
350	4,4	3.2	60	72	2/14/100	G3	Holzma 72, HPP350	192324 s
350	4,4	3.2	50	72	8/12,5/80	TR-F-FA	Giben Smart	192325 s
350	4,4	3.2	50	72	8/12,5/80	G6	Giben Smart	192326 s
350	4,4	3.2	50	72	8/12,5/80	G3	Giben Smart	192327 s
350	4,4	3.2	30	72	2/10/60	TR-F-FA	SCM, Panhans, Mayer, Schelling, Scheer	192328
350	4,4	3.2	30	72	2/10/60	G6	SCM, Panhans, Mayer, Schelling, Scheer	192329 s
350	4,4	3.2	30	72	2/10/60	G3	SCM, Panhans, Mayer, Schelling, Scheer	192330 s
350	4,25	3.2	30	72	2/10/60	TR-F-FA	Scheer	192331 s
350	4,25	3.2	30	72	2/10/60	G6	Scheer	192332 s
350	4,25	3.2	30	72	2/10/60	G3	Scheer	192333 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco EB 90	192334 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G6	Selco EB 90	192335 s
355	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G3	Selco EB 90	192336 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani PRIMA, SCM ALPHA	192337 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani PRIMA, SCM ALPHA	192338 s
355	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani PRIMA, SCM ALPHA	192339 s
355	4,4	3.2	75	72	4/15/105	TR-F-FA	Giben	192340 s
355	4,4	3.2	75	72	4/15/105	G6	Giben	192341 s
355	4,4	3.2	75	72	4/15/105	G3	Giben	192342 s
380	4,8	3.5	60	72	2/14/100 + 2/14/125	TR-F-FA	Holzma	192343
380	4,8	3.5	60	72	2/14/100 + 2/14/125	G6	Holzma	192344 s
380	4,8	3.5	60	72	2/14/100 + 2/14/125	G3	Holzma	192345 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	TR-F-FA	Selco WN / EB	192346 s
[mm]	[mm]	[mm]	[mm]					

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G6	Selco WN / EB	192347 s
400	4,4	3.2	80	72	2/7/110 + 4/19/120 + 2/8,4/130	G3	Selco WN / EB	192348 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA		192349 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6		192350 s
400	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3		192351 s
400	4,4	3.2	75	72	4/15/105	TR-F-FA	Giben, Homag CH08+12	192352 s
400	4,4	3.2	75	72	4/15/105	G6	Giben, Homag CH08+12	192353 s
400	4,4	3.2	75	72	4/15/105	G3	Giben, Homag CH08+12	192354 s
400	4,4	3.2	60	72		TR-F-FA	Anthon	192355 s
400	4,4	3.2	60	72		G6	Anthon	192356 s
400	4,4	3.2	60	72		G3	Anthon	192357 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	TR-F-FA	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192358 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	G6	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192359 s
400	4,4	3.2	30	72	2/7/42 + 2/10/60	G3	Schelling, Mayer, Irion, Scheer, HOLZ-HER	192360 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	192361 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	192362 s
430	4,4	3.2	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	192363 s
430	4,4	3.2	80	72	2/8,3/130	TR-F-FA	S.M.A., hoggers	192364 s
430	4,4	3.2	80	72	2/8,3/130	G6	S.M.A., hoggers	192365 s
430	4,4	3.2	80	72	2/8,3/130	G3	S.M.A., hoggers	192366 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	TR-F-FA	Giben Prismatic 2 old	192367 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	G6	Giben Prismatic 2 old	192368 s
430	4,4	3.2	75	72	4/15/105 + 2/7/110	G3	Giben Prismatic 2 old	192369 s
430	4,4	3.2	60	72	1/11/85	TR-F-FA	Anthon	192370 s
430	4,4	3.2	60	72	1/11/85	G6	Anthon	192371 s
430	4,4	3.2	60	72	1/11/85	G3	Anthon	192372 s
430	4,4	3.2	30	72		TR-F-FA		192373 s
430	4,4	3.2	30	72		G6		192374 s
430	4,4	3.2	30	72		G3		192375 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	TR-F-FA	S.M.A., Irion	192376 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	G6	S.M.A., Irion	192377 s
450	4,4	3.2	80	72	2/7/110 + 2/8,3/130	G3	S.M.A., Irion	192378 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	TR-F-FA	Gabbiani ELITE	192379 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G6	Gabbiani ELITE	192380 s
450	4,4	3.2	80	72	4/8,5/100 + 2/14/110 + 2/7/110	G3	Gabbiani ELITE	192381 s
450	4,4	3.2	30	72		TR-F-FA	Irion, Schelling	192382 s
450	4,4	3.2	30	72		G6	Irion, Schelling	192383 s
450	4,4	3.2	30	72		G3	Irion, Schelling	192384 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	TR-F-FA	Selco WN	192385 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G6	Selco WN	192386 s
450	4,8	3.5	80	72	4/19/120 + 2/8,4/130	G3	Selco WN	192387 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	TR-F-FA	Holzma	192388 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	G6	Holzma	192389 s
450	4,8	3.5	60	72	2/14/125 + 2/19/120	G3	Holzma	192390 s
[mm]	[mm]	[mm]	[mm]					

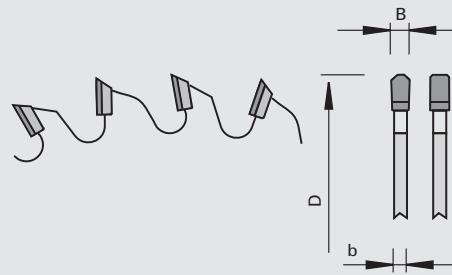
202380

Panel Sizing Saw Blades DP „TR-F-FA“ pos.-neg.

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

panel sizing saws
for sizing cuts in MDF and hard materials (e.g. Cfk, Gfk....)

Design

asymmetric chip evacuation gap geometry
resharpening area 3,5 mm
tooth configuration: triple chip / flat with chamfer "TR-FA" with alternating hook angle positive - negative

Advantages

optimized chip removal
low cutting pressures
noise-reduction thanks to laser ornaments
improved cutting quality thanks to optimized entrance and exit angle

Notes

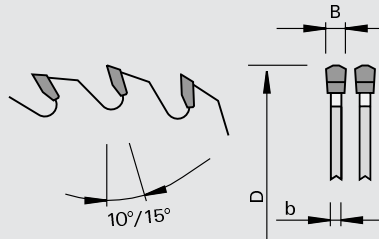
Ø D	B	b	Ø d	Z	NL	Ident-No.
350	4,4	3.2	30	63		189562 s
350	4,4	3.2	60	63	2/14/100	189563 s
380	4,8	3.5	60	70	2/14/100+2/14/125	189564 s
400	4,4	3.2	30	70		189565 s
430	4,4	3.2	30	70		189566 s
450	4,8	3.5	60	70	2/14/125+2/19/120	189567 s
450	4,4	3.2	30	70		189568 s
[mm]	[mm]	[mm]	[mm]			

104371

Panel Sizing Saw Blades HW - FinishCut Plus „TR-TR“ - LowNoise

Product

Drawing



tungsten carbide [HW]



Machine / Application

panel sizing saws
for finish cuts in veneered, foiled or melamine-laminated panels, in single sheets or in stacks up to 100 mm cutting height

Design

- | vibration and noise damping ornaments
- | additional expansion slots
- | up to ØD=370, 10 degree hook angle
- | from ØD=380, 15 degree hook angle
- | tooth configuration: triple chip / triple chip "TR-TR"
- | cutting material: HW HL Board 03 plus

Advantages

- | for highest performance demands
- | impressive cutting quality thanks to exact and precise cuts without chippings
- | reduced cutting pressure and power consumption thanks to optimized cutting geometry
- | extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- | clearly increased edge life thanks to improved HW grade

Notes

- | projection: min 20 - 25 mm
max 40 mm

Ø D	B	b	Ø d	Z	NL		Ident-No.
300	4,4	3.0	65	60	2/8,4/110	Selco EB 70	192140
305	4,4	2.8	30	60	2/7/42 + 2/9/46 + 2/10/60	Mayer, Panhans	192143
350	4,4	3.2	30	72	2/7/42 + 2/9/46 + 2/10/60	SCM, Panhans, Mayer, Schelling, HOLZ-HER	192146
350	4,4	3.2	60	72	2/14/100	Holzma 72, HPP 350	192148
350	4,4	3.2	75	72		Homag Sawtech, Holzma 250	192149
370	4,4	3.2	30	72		Schelling FM from 202180	192154
380	4,4	3.2	60	72	2/14/100 + 2/14/125	Holzma	192156
380	4,8	3.5	60	72	2/14/100 + 2/14/125	Holzma	192157 \$
400	4,4	3.2	30	72	2/7/42 + 2/10/60	Scheer, HOLZ-HER	192159
420	4,8	3.5	60	72	2/10/80 + 2/14/125	Holzma type 92	192163
430	4,4	3.2	75	72	4/15/105 + 2/7/110	Giben Prismatic 2 old	192164
450	4,4	3.2	30	72		Irion, Schelling	192167
450	4,8	3.5	60	72	2/19/120 + 2/14/125	Holzma	192172 \$
460	4,4	3.2	30	72	2/13/94	Schelling FL, FH6	192174
520	4,8	3.5	60	72	2/11/115 + 2/19/120	Holzma 23 / 550	192179
[mm]	[mm]	[mm]	[mm]				

2053..

Scoring Saw Blades DP - flexible & quick

Product



Drawing

LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

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

Design




| diamond cutting edges with polished design
| LEUCODIA tipping quality

Advantages

| for each application case the correct tooth form
| short delivery times
| interesting scaled prices

Notes

| application with feed

 KO-F Universal use in melamine and laminated panels	 KO-WS Veneered panels, reduced motor power	 KO-HR Perfect Cutting quality in all different panel materials
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Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
160	4,4 - 5,2	3,2	45	30	3/11/70	KO-F	Giben Prismatic	189345 s
160	4,4 - 5,2	3,2	45	30	3/11/70	KO-WS	Giben Prismatic	189341 s
160	4,4 - 5,2	3,2	45	30	3/11/70	KO-HR	Giben Prismatic	189343 s
160	4,4 - 5,2	3,2	55	30	3/6,5/66	KO-F	Gabbiani	189346 s
160	4,4 - 5,2	3,2	55	30	3/6,5/66	KO-WS	Gabbiani	189342 s
160	4,4 - 5,2	3,2	55	30	3/6,5/66	KO-HR	Gabbiani	189344 s
180	4,4 - 5,2	3,2	20	30		KO-F	Schelling, Anthon	189351 s
180	4,4 - 5,2	3,2	20	30		KO-WS	Schelling, Anthon	189355 s
180	4,4 - 5,2	3,2	20	30		KO-HR	Schelling, Anthon	189347 s
180	4,4 - 5,2	3,2	30	30	2/10/60	KO-F	Panhans	189352 s
180	4,4 - 5,2	3,2	30	30	2/10/60	KO-WS	Panhans	189356 s
180	4,4 - 5,2	3,2	30	30	2/10/60	KO-HR	Panhans	189348 s
180	4,4 - 5,2	3,2	45	30		KO-F		189353
180	4,4 - 5,2	3,2	45	30		KO-WS		189357 s
180	4,4 - 5,2	3,2	45	30		KO-HR		189349
180	4,4 - 5,2	3,2	50	30	3/13/80	KO-F	Giben Smart	189354 s
180	4,4 - 5,2	3,2	50	30	3/13/80	KO-WS	Giben Smart	189358 s
180	4,4 - 5,2	3,2	50	30	3/13/80	KO-HR	Giben Smart	189350 s
180	4,8 - 5,6	3,5	45	30		KO-F	Holzma	189360
180	4,8 - 5,6	3,5	45	30		KO-WS	Holzma	189361 s
180	4,8 - 5,6	3,5	45	30		KO-HR	Holzma	189359
200	4,4 - 5,2	3,2	30	30	2/10/60	KO-F	Panhans	189366 s
200	4,4 - 5,2	3,2	30	30	2/10/60	KO-WS	Panhans	189370 s
200	4,4 - 5,2	3,2	30	30	2/10/60	KO-HR	Panhans	189362 s
200	4,4 - 5,2	3,2	65	30	2/8,4/100 + 2/8,4/110	KO-F	Selco	189367
200	4,4 - 5,2	3,2	65	30	2/8,4/100 + 2/8,4/110	KO-WS	Selco	189371 s
200	4,4 - 5,2	3,2	65	30	2/8,4/100 + 2/8,4/110	KO-HR	Selco	189363 s
200	4,4 - 5,2	3,2	20	30	2/11/66	KO-F		189368 s
200	4,4 - 5,2	3,2	20	30	2/11/66	KO-WS		189372 s
200	4,4 - 5,2	3,2	20	30	2/11/66	KO-HR		189364 s
200	4,4 - 5,2	3,2	50	30	3/13/80	KO-F	Giben Smart	189369 s
200	4,4 - 5,2	3,2	50	30	3/13/80	KO-WS	Giben Smart	189373 s
200	4,4 - 5,2	3,2	50	30	3/13/80	KO-HR	Giben Smart	189365 s
200	4,8 - 5,6	3,5	45	30		KO-F	Holzma	189376
200	4,8 - 5,6	3,5	45	30		KO-WS	Holzma	189378 s
200	4,8 - 5,6	3,5	45	30		KO-HR	Holzma	189374 s
[mm]	[mm]	[mm]	[mm]					

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-F	Selco	189377 s
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-WS	Selco	189379 s
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-HR	Selco	189375 s
[mm]	[mm]	[mm]	[mm]					

2053..

Scoring Saw Blades DP - nn-System

Product



Drawing

polycrystalline diamond [DP]



Machine / Application

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

Design

| special NoNoise gullet geometry
| diamond cutting edges with polished design
| LEUCODIA tipping quality

Advantages

| especially low noise level
| noise reduction by approx. 6 db(A) when idling
| for each application case the correct tooth form
| short delivery times
| interesting scaled prices

Notes

| application with feed

**KO-F**

Universal use in melamine and laminated panels

**KO-WS**

Veneered panels, reduced motor power

**KO-HR**

Perfect Cutting quality in all different panel materials

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
160	4,4 - 5,2	3.2	45	30	3/11/70	KO-F	Giben Prismatic	192280 s
160	4,4 - 5,2	3.2	45	30	3/11/70	KO-WS	Giben Prismatic	192281 s
160	4,4 - 5,2	3.2	45	30	3/11/70	KO-HR	Giben Prismatic	192282 s
160	4,4 - 5,2	3.2	55	30	3/6,5/66	KO-F	Gabbiani	192283 s
160	4,4 - 5,2	3.2	55	30	3/6,5/66	KO-WS	Gabbiani	192284 s
160	4,4 - 5,2	3.2	55	30	3/6,5/66	KO-HR	Gabbiani	192285 s
180	4,4 - 5,2	3.2	20	30		KO-F	Schelling, Anthon	192286 s
180	4,4 - 5,2	3.2	20	30		KO-WS	Schelling, Anthon	192287 s
180	4,4 - 5,2	3.2	20	30		KO-HR	Schelling, Anthon	192288 s
180	4,4 - 5,2	3.2	30	30	2/10/60	KO-F	Panhans	192289 s
180	4,4 - 5,2	3.2	30	30	2/10/60	KO-WS	Panhans	192290 s
180	4,4 - 5,2	3.2	30	30	2/10/60	KO-HR	Panhans	192291 s
180	4,4 - 5,2	3.2	45	30		KO-F		192292
180	4,4 - 5,2	3.2	45	30		KO-WS		192293 s
180	4,4 - 5,2	3.2	45	30		KO-HR		192294
180	4,4 - 5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	192295 s
180	4,4 - 5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	192296 s
180	4,4 - 5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	192297 s
180	4,8 - 5,6	3.5	45	30		KO-F	Holzma	192298
180	4,8 - 5,6	3.5	45	30		KO-WS	Holzma	192299 s
180	4,8 - 5,6	3.5	45	30		KO-HR	Holzma	192300
200	4,4 - 5,2	3.2	30	30	2/10/60	KO-F	Panhans	192301 s
200	4,4 - 5,2	3.2	30	30	2/10/60	KO-WS	Panhans	192302 s
200	4,4 - 5,2	3.2	30	30	2/10/60	KO-HR	Panhans	192303 s
200	4,4 - 5,2	3.2	65	30	2/8,4/100 + 2/8,4/110	KO-F	Selco	192304 s
200	4,4 - 5,2	3.2	65	30	2/8,4/100 + 2/8,4/110	KO-WS	Selco	192305 s
[mm]	[mm]	[mm]	[mm]					

Ø D	B	b	Ø d	Z	NL	Tooth geometry		Ident-No.
200	4,4 - 5,2	3.2	65	30	2/8,4/100 + 2/8,4/110	KO-HR	Selco	192306 s
200	4,4 - 5,2	3.2	20	30	2/11/66	KO-F		192307 s
200	4,4 - 5,2	3.2	20	30	2/11/66	KO-WS		192308 s
200	4,4 - 5,2	3.2	20	30	2/11/66	KO-HR		192309 s
200	4,4 - 5,2	3.2	50	30	3/13/80	KO-F	Giben Smart	192310 s
200	4,4 - 5,2	3.2	50	30	3/13/80	KO-WS	Giben Smart	192311 s
200	4,4 - 5,2	3.2	50	30	3/13/80	KO-HR	Giben Smart	192312 s
200	4,8 - 5,6	3.5	45	30		KO-F	Holzma	192313 s
200	4,8 - 5,6	3.5	45	30		KO-WS	Holzma	192314 s
200	4,8 - 5,6	3.5	45	30		KO-HR	Holzma	192315 s
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-F	Selco	192316 s
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-WS	Selco	192317 s
200	4,8 - 5,6	3.5	65	30	2/8,4/110	KO-HR	Selco	192318 s
[mm]	[mm]	[mm]	[mm]					

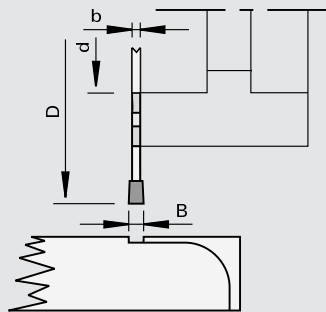
205010

Scoring Saw Blades DP for inlay profiles „F“

Product



Drawing



polycrystalline diamond [DP]

Machine / Application

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

Design

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

Advantages

Notes

l application with feed

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,0	3.0	34	8	4/5,3/42	168473
75	3,2	2.2	22	10		168464 s
[mm]	[mm]	[mm]	[mm]			

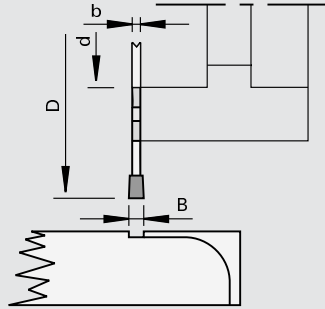
205080

Scoring Saw Blades DP for inlay profiles „KO-F“

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

Notes

| application with feed

Machine / Application

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

Design

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

Advantages

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

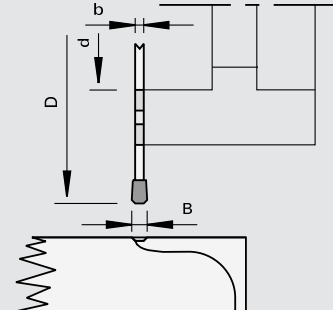
205080

Scoring Saw Blades DP for inlay profiles „F-FA“

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

Notes

| for Homag flange
| application with feed

Machine / Application

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

Design

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

Advantages

Ø D	B	b	Ø d	Z	NL	Ident-No.
70	4,3	3,0	34	8	4/5,3/42	168474 s
[mm]	[mm]	[mm]	[mm]			

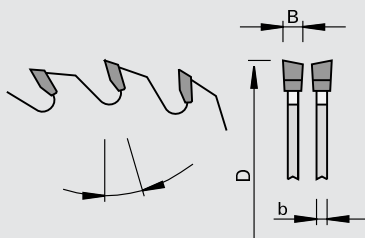
105320

Scoring Saw Blades HW „WS“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

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

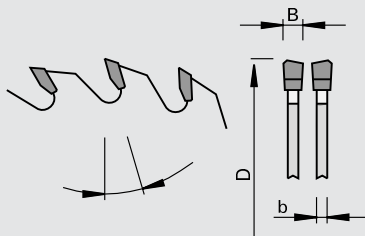
105320

Scoring Saw Blades HW „WS-FA“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

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

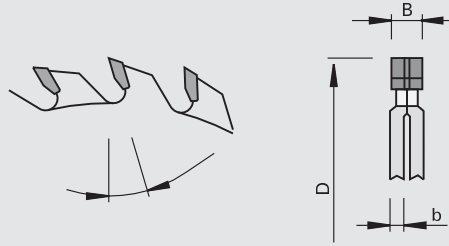
105318

Scoring Saw Blades HW - adjustable „F“

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

- | universally applicable

Notes

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

Ø D	B	b	Ø d	Z	NL	Hook angle		Ident-No.
80	2,8 - 3,6	2,2	20	2x6	2/4/34	10	Striebig	X 9201253
80	2,8 - 3,6	2,2	20	2x10	2/3,8/42	12	Striebig	189707
120	2,8 - 3,6	2,2	20	2x12	2/3,8/42	12	SCM	189307 \$
120	2,8 - 3,6	2,2	22	2x12	2/3,8/42	12	Altendorf, Martin	189310 \$
125	2,8 - 3,6	2,2	20	2x12	2/3,8/42	12	HOLZ-HER, SCM	189708
[mm]	[mm]	[mm]	[mm]			[°]		

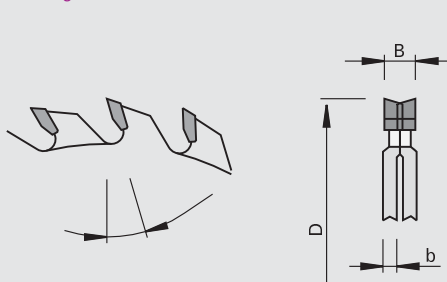
105325 / 105328

Scoring Saw Blades HW - adjustable „ES“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
100	2,8 - 3,6	2.2	20	2x10		12	Schelling	105328	188525 \$
100	2,8 - 3,6	2.2	22	2x10		12	Altendorf, Martin, Panhans, Striebig	105328	169892
120	2,8 - 3,6	2.2	20	2x12		12	SCM	105328	188528 \$
120	2,8 - 3,6	2.2	22	2x12	2/3,1/42	12	Altendorf, Martin	105328	169883 \$
120	2,8 - 3,8	2.2	22	2x12	2/3,8/42 + 4/4,6/55 + 4/4,6/39	12	Martin NC-adjustment	105328	181678
120	2,8 - 3,8	2.2	50	2x12	4/6,2/62	12	Altendorf adjustment unit Rapido	105328	188398 \$
125	4,0 - 4,8	1.6	45	2x20		12	Giben, Mayer	105325	188531
140	2,8 - 3,8	2.0	36	2x12	2/6,2/51 + 3/ 4,2/55 + 3/9/55	12	Martin T75 PreX	105328	189990
145	2,8 - 3,8	3.0	50	2x12		8	Panhans QuickStep	105328	191956
180	3,0 - 3,8	2.2	30	2x18		8	Koelle	105328	188543
160	2,8 - 3,8	2.2	30	2x16		8	Bäuerle	105328	188539
300	4,2 - 4,7	1.8	50	2x32	3/15/80	12	Giben Prismatic + Starmatic	105325	188561
340	4,4 - 5,6	2.5	45	2x24		15	Holzma	105325	188562
[mm]	[mm]	[mm]	[mm]			[°]			
Ø D	B	b	Ø d	Z	NL	Hook angle		Class-No.	Ident-No.
120	2,8 - 3,7	2.2	20	2x22	2/3,2/42	10	SCM	105328	189892
120	2,8 - 3,7	2.2	22	2x22	2/3,2/42	10	Altendorf, Martin	105328	189893
120	2,8 - 3,7	2.2	50	2x22	4/6,2/62	10	Altendorf-Verstelleinheit Rapido	105328	189894
180	3,0 - 3,8	2.2	50	2x18	4/6,2/62	12	Altendorf 2	105318	189895 s
[mm]	[mm]	[mm]	[mm]			[°]			

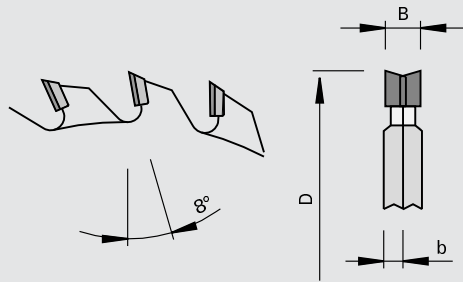
205088

Scoring Saw Blades DP - adjustable „ES“

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

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

Design

- tooth configuration: top bevel "ES"

Advantages

Notes

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

Ø D	B	b	Ø d	Z	NL		Ident-No.
80	2,8 - 3,6	2.2	20	2x6	2/4/34	Striebig	X 9201163
120	2,8 - 3,8	2.2	22	2x12	2/3,8/42	Altendorf, Martin	189101
120	2,8 - 3,6	2.0	50	2x12	3/5,5/63 + 3/9/63	for LEUCO adjustment unit	189652 s
120	2,8 - 3,8	2.2	50	2x12	4/6,2/62	Altendorf adjustment unit	189104
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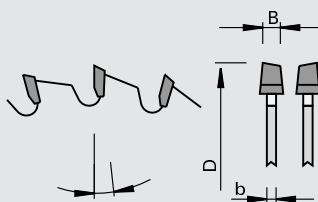
105390

Scoring Saw Blades HW „KO-WS“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- tooth configuration: conical / alternate top bevel "KO-WS"
- cutting material: HW *HL Board 06 and HL Board 03

Advantages

- low motor output thanks to tooth configuration "KO-WS"
- cutting material HL Board 03 optimized tooth geometry
- for longer edge lives compared to HL Board 06
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- HL Board 06 version: 1 mm scoring depth = 0.17 mm cutting width
- HL Board 03 version: 1 mm scoring depth = 0.21 mm cutting width
- optimum scoring depth 1.0 - 2.0 mm
- for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
100	3,2 - 4,0	2.2	20	20		8	Schelling 191960
120	3,1 - 3,9	2.2	20	24		8	Lasari 191961
120	3,1 - 3,9	2.2	22	24		8	Altendorf 191962
125	4,45 - 5,25	3.2	20	20		0	Panhans 191963
125	4,45 - 5,25	3.2	22	20		0	Martin 191964
125	4,45 - 5,25	3.2	45	20		0	Giben, Homag CH03 191965
125	3,0 - 3,8	2.2	20	24		8	191966
125	3,2 - 4,0	2.8	20	24		8	SCM, SICAR, Panhans 191967
125	4,45 - 5,25	3.2	45	24		8	Homag Espana 191968
150	4,45 - 5,25	3.2	30	24		8	Irion, Mayer 191969
150	4,45 - 5,25	3.2	45	24		8	Homag CH06,08,10,12 191970
150	4,45 - 5,25	3.2	45	28		8	Homag Espana 191971
160	4,45 - 5,25	3.2	45	28	3/11/70	8	Giben Prismatic 191972
160	4,45 - 5,25	3.2	55	36	3/6,5/66	8	Gabbiani 191973
180	4,45 - 5,25	3.2	20	30		8	Schelling, Anthon 191974
180	5,8 - 6,6	4.0	20	30		8	Anthon * 188548
180	4,45 - 5,25	3.2	30	30	2/10/60	8	Panhans 191975
180	5,2 - 6,0	3.5	55	30		0	Giben * 188547
180	4,45 - 5,25	3.2	45	36		8	Holzma 191976 \$
180	4,85 - 5,65	3.5	45	36		8	Holzma type 11 191977 \$
180	4,45 - 5,25	3.2	50	44	3/13/80	10	Giben Smart 191978
200	4,35 - 5,15	6.0	20	24	2/11/66	8	Schelling 191979
200	5,0 - 5,8	3.5	20	34	2/11/66	8	Schelling * 188557
200	4,85 - 5,65	3.5	20	34	2/11/66	8	Schelling FH 8 191980 €
200	4,45 - 5,25	3.5	20	36	2/11/66	8	Schelling 191981 \$
200	4,45 - 5,25	3.2	30	36	2/10/60	8	S.M.A., Panhans, Scheer 191982
200	4,85 - 5,65	3.5	45	36		8	Holzma 191983 \$
200	5,9 - 6,6	4.0	45	36		8	Holzma * 188556
200	4,45 - 5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco 191984 \$
200	4,85 - 5,65	3.5	65	36	2/9/110	8	Selco WN / EB 191985
200	4,4 - 5,2	3.2	50	42	3/13/80	8	Giben Smart 191986
215	4,45 - 5,25	3.2	50	42	3/15/80 + 2/7/80	8	Giben Prismatic + Starmatic 191987
280	4,85 - 5,65	3.5	45	72		8	Holzma 191988
[mm]	[mm]	[mm]	[mm]			[°]	

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.	
300	4,45 - 5,25	3.2	30	48	2/11/73	8	Schelling FX-H 430	191989
300	4,45 - 5,25	3.2	50	48	3/15/80	8	Giben Prismatic	191990
300	4,45 - 5,25	3.2	65	48	2/8,4/100 + 2/8,4/110	8	Selco EB	191991
[mm]	[mm]	[mm]	[mm]			[°]		

Suitable for Panel Sizing Saw Blades UniCut G5

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.	
180	4,05 - 4,85	3.2	20	36		0	Schelling, Anton	191992 s
180	4,05 - 4,85	3.2	30	36	2/10/60	0	Panhans	191993
180	4,05 - 4,85	3.2	45	36		0	Holzma	191994
180	4,05 - 4,85	3.2	50	36	3/13/80	0	Giben Smart	191995 &
200	4,05 - 4,85	3.2	20	36	2/11/66	0	Schelling	191996
200	4,05 - 4,85	3.2	30	36	2/10/60	0	S.M.A., Panhans, Scheer	191997 &
200	4,05 - 4,85	3.2	45	36		0	Holzma	191998
200	4,05 - 4,85	3.2	50	36	3/13/80	0	Giben Smart	191999 &
200	4,05 - 4,85	3.2	65	36	2/8,4/100 + 2/8,4/110	0	Selco	192000
[mm]	[mm]	[mm]	[mm]			[°]		

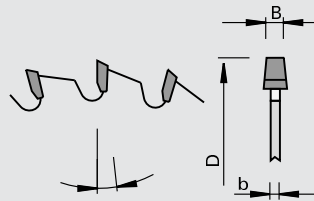
105390

Scoring Saw Blades HW „KO-F“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- | tooth configuration: conical-flat "KO-F"
- | cutting material: HW *HL Board 06 and HL Board 03

Advantages

- | quick adjustment
- | universally applicable
- | cutting material HL Board 03 optimized tooth geometry
- | for longer edge lives compared to HL Board 06
- | optimum cutting quality thanks to improved runout accuracy
- | reduction of the scoring depth

Notes

- | height adjustable to kerf of main saw blade
- | HL Board 06 version: 1 mm scoring depth = 0.17 mm cutting width
- | HL Board 03 version: 1 mm scoring depth = 0.21 mm cutting width
- | optimum scoring depth 1.0 - 2.0 mm
- | for main/scoring saw combinations see specifications (Technical Appendix)

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
125	3,1 - 3,9	2.2	20	24		8	SCM, SICAR, Panhans 192001
180	6,7 - 7,5	4.4	20	30		8	Anthon * 189235
180	4,45 - 5,25	3.2	45	36		8	Holzma 192002
180	4,85 - 5,65	3.5	45	36		8	Holzma type 11 192003
200	6,7 - 7,5	4.5	20	34	2/11/66	8	Schelling * 189236
200	4,45 - 5,25	3.5	20	36	2/11/66	8	Schelling 192004
200	4,55 - 5,35	3.0	45	36		8	Homag Sawtech 192005
200	4,85 - 5,65	3.5	45	36		8	Holzma 192006
200	4,45 - 5,25	3.2	65	36	2/9/100 + 2/9/110	8	Selco 192007
200	3,2 - 4,0	2.2	30	60		15	Scheer 192008
220	6,7 - 7,5	4.4	20	36		8	Schelling FS-H / AS-H * 189237
250	4,45 - 5,25	3.5	30	42	2/10/60	8	Panhans, HOLZ-HER 192009
[mm]	[mm]	[mm]	[mm]			[°]	

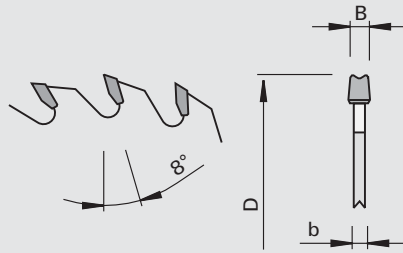
105390

Scoring Saw Blades HW „KO-HR“

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- cutting material: HW HL Board 03
- tooth configuration: conical hollow back "KO-HR"

Advantages

- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
160	4,45-5,25	3.2	45	28	3/11/70	Giben Prismatic	192130
180	4,45-5,25	3.2	30	30	2/10/60	Panhans	192131
180	4,85-5,65	3.5	45	36		Holzma Typ 11	192132
200	4,45-5,25	3.2	20	36	2/11/66	Schelling	192133
200	4,45-5,25	3.2	30	36	2/10/60	S.M.A., Panhans, Scheer	192134
200	4,85-5,65	3.5	45	36		Holzma	192135
200	4,45-5,25	3.2	65	36	2/9/100 + 2/9/110	Selco	192136
200	4,85-5,65	3.5	65	36	2/9/110	Selco WN/EB	192137
[mm]	[mm]	[mm]	[mm]				

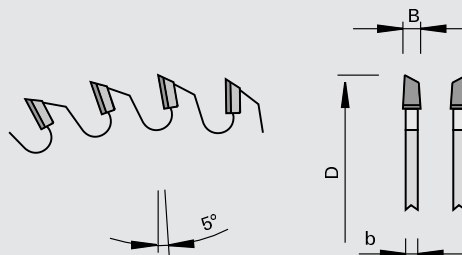
205091

Scoring Saw Blades DP „KO-WS“

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

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

Design

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

Advantages

Notes

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

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

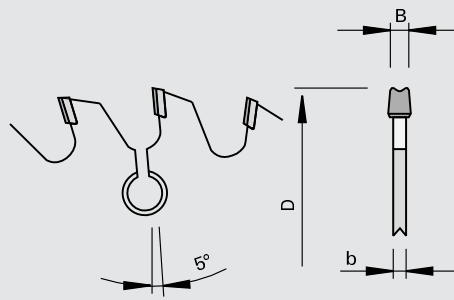
205082

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

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

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

Design

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

Advantages

- | long edge lives
- | excellent cutting quality

Notes

- | application with feed

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

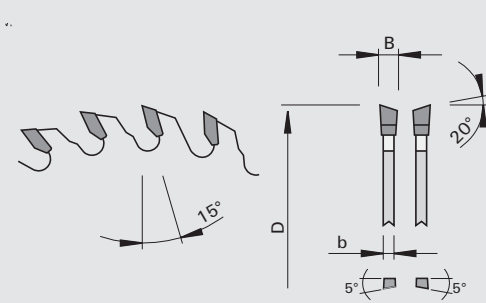
101320

Double Clipping Saw Blades HW with cooling slots "WSA"

Product



Drawing



LEUCO
topLine

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
350	4,0	2,6	30	54	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189788
400	4,4	3,0	30	60	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189789
450	4,4	3,0	30	72	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189790
500	4,8	3,2	30	72	2/10/80	189792
500	4,8	3,2	30	108	2/10/80 + 2/15/63	189794
550	4,8	3,2	30	72	2/10/80	189795
600	5,4	4,0	30	72	2/10/80 + 2/15/63	189796 s
630	5,4	4,0	40	72	2/10/60	189797
650	5,6	4,0	30	96	2/10/80 + 2/15/63	189798
650	5,6	4,0	30	54	2/10/80 + 2/15/63	189799 s
720	6,2	4,4	30	48	2/8,5/90	Hundegger 189800 s
720	6,2	4,4	30	72	2/8,5/90	Hundegger 189801
735	6,2	4,4	30	48	2/8,5/90	Hundegger 189802 s
735	6,2	4,4	30	72	2/8,5/90	Hundegger 189803
760	6,2	4,4	30	48	2/14/400 + 4/8,5/90	Hundegger 189804 s
760	6,2	4,4	30	72	2/14/400 + 4/8,5/90	Hundegger 189805 s
760	6,2	4,4	30	96	2/14/400 + 4/8,5/90	Hundegger 189806
800	6,2	4,4	30	48		Paul 189807 s
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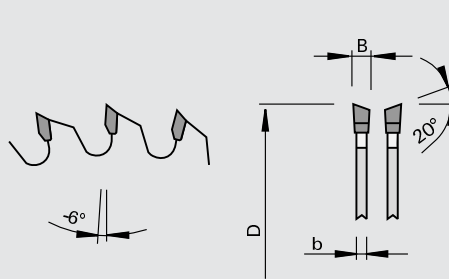
101322

Chop Saw Blades HW „WS“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

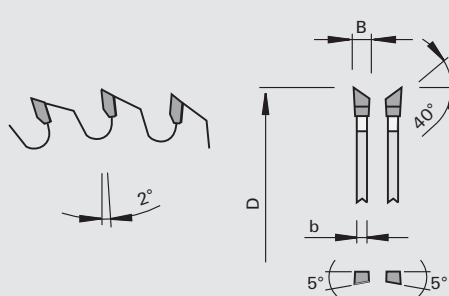
101322

Chop Saw Blades HW for wood optimization "WSA"

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

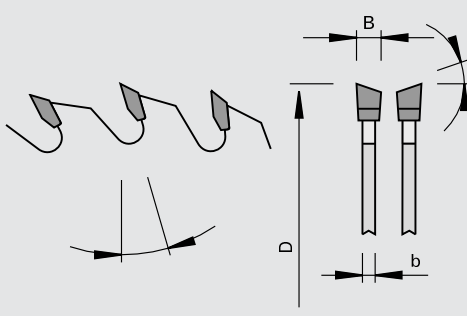
106320

Clipping Saw Blades HW for edge trimming „WS“ - without countersink

Product



Drawing



LEUCO
topLine

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

∅ D	B	b	∅ d	Z	NL	Hook angle	Corner∟	Shear∟		Ident-No.
90	3,0	2,0	30	20		8	10	0	Reich	188955
100	2,4	1,6	22	12		15	10	5	HOLZ-HER	188008
100	2,4	1,6	22	20	2/4/30	-8	10	5	EBM	188181
100	3,6	2,2	32	20		8	30	5	Wilmsmeyer	169986
100	2,6	1,6	32	30		10	15	5	Brandt	188009
110	3,6	2,5	22	20		8	30	5	Reich	169987
110	3,6	2,5	32	20		8	30	5	Homag	169988
115	3,2	2,2	56	30	3/7,1/68 + 3/7,1/68	15	15	0	Biesse Akron 400	189632 s
120	3,2	2,2	32	20		10	10	5	Homag	188000
125	2,4	1,6	32	24		15	30	0	Brandt	192189
140	3,2	2,2	16	36		10	15	5	Ott	189326
140	3,2	2,2	22	36		10	15	5	HOLZ-HER	188880
150	3,2	2,2	22	48		10	10	5	IMA	188002
160	3,2	2,2	20	48	2/5/32	10	10	5	HOLZ-HER	188006
160	3,5	2,5	22	36		-5	15	5	IMA	188662
160	3,2	2,2	22	48		-8	10	5	IMA	188007
160	3,2	2,2	30	24	2/7/42	15	10	5	HOLZ-HER	188005
160	3,2	2,2	40	30	4/5,5/52	-8	20	10	HOLZ-HER	189628
170	3,2	2,2	30	36	4/5,5/52	10	20	0	Homag	189063
180	3,5	2,5	22	42		-6	15	5	IMA	189996
200	3,2	2,2	30	64	4/6,6/60 + 2/6,2/42	10	15	0	IMA	188626
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]		

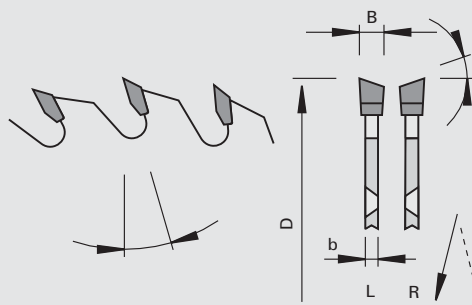
106320

Clipping Saw Blades HW for edge trimming „WS“ - with countersink

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

l Ident-No. 188682
NL=4/5,5/52 have no countersink
l Ident-No. 189259
NL=2/10/60 have no countersink
l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠	Shear∠		Ident-No.
110	3,2	2,5	40	20	4/5,5/52	10	45	5	Homag	L 188290
110	3,2	2,5	40	20	4/5,5/52	10	45	5	Homag	R 188289
110	3,2	2,2	40	30	4/6/52	10	45	0	Homag BAZ	R 188663
120	3,6	2,8	40	24	2x4/6/52	8	30	0	Homag	N 189751 \$
120	3,2	2,5	40	36	2x4/5,5/52	10	45	5	Homag	N 188590
120	3,6	2,8	40	36	2x4/6/52	12	20	0	Homag	N 189220 #
125	2,4	1,6	40	24	2x4/5,8/60	15	30	0	Brandt	N 189710
125	2,4	1,6	30	36	2x4/6,5/48	10	30	0	Homag BAZ	N 188927
140	3,2	2,2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	L 189549 &
140	3,2	2,2	30	36	4/8,6/46	10	15	5	Biesse Akron 600/800	R 189548 &
150	3,2	2,2	30	48	4/6/48 + 4/5,5/52	10	15	0	Homag BAZ	R 188682
180	3,2	2,2	30	54	4/6/52	10	30	5	Homag BAZ	L 188291
240	3,5	2,2	30	54	8/6,1/52	10	20	0	Homag BAZ	L 189253
240	3,5	2,2	40	54	8/6,1/52	10	20	0	Homag BAZ Flex 5, Weeke	L 189254 &
350	3,6	2,5	30	16	2/10/60 + 8/6/90 20	10	0	0	Homag BAZ	R 189259
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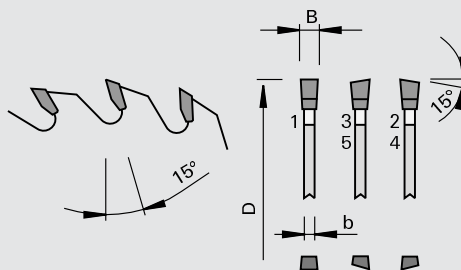
102348

Chop Saw Blades HW "G5"

Product



Drawing



LEUCO
G5 system

LEUCO
DUR

tungsten carbide [HW]

LOW
VIBRATION

Machine / Application

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

Design

- l tooth configuration: G5
- l cutting material: HW HL Board 03 plus

Advantages

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

Notes

- l pay attention to nmax!!!

Ø D	B	b	Ø d	Z	NL		Ident-No.
180	3,0	2.2	30	60	4/6/52	Homag, Weeke	192091
200	3,0	2.2	30	65	8/6/52	Homag	192092 &
200	3,0	2.2	30	65	2/6,2/42 + 4/6,6/60	IMA	192093 &
220	3,0	2.2	40	70	8/6/52	Homag, Weeke	192094 &
240	3,0	2.2	30	75	8/6/52	Homag	192095 &
240	3,0	2.2	40	75	8/6/52	Homag, Weeke	192096
240	3,0	2.2	30	75	2/6,2/42 + 4/6,6/60	IMA	192097 &
280	3,0	2.2	30	85	8/5,5/52	Homag	192098 &
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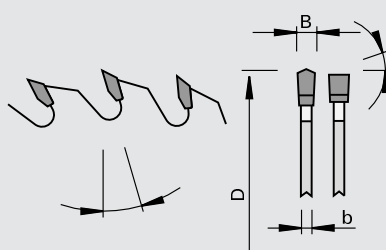
106370

Clipping Saw Blades HW for edge trimming „DA-F“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

- l without shear angle
- l positive hook angle
- l tooth configuration: inverted v-flat "DA-F"
- l cutting material: HW HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner		Ident-No.
110	1,7	1.2	40	30	4/6/52	10	45	Homag BAZ	188858
[mm]	[mm]	[mm]	[mm]			[°]	[°]		

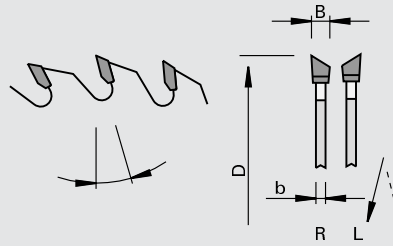
106350

Clipping Saw Blades HW for edge trimming „ES“ - without countersink

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner↙	Shear↙		Ident-No. [L]	Ident-No. [R]
100	3,2	2,2	32	20		-6	30	5	Homag	169991	169992
100	3,0	2,2	32	20		8	30	5	Wilmsmeyer	169981	169984
100	2,6	2,0	32	30		-10	15	0	Brandt	181617	181616
100	2,6	1,6	32	30		10	10	0	Brandt	188593	188594
150	3,5	2,2	22	30		-6	15	5	IMA	169966 #	169967 #
150	3,5	2,2	30	30		12	15	5	SCM-IDM	169962 #	169963 #
150	3,5	2,2	30	44	4/5,5/52	-12	45	10	Homag Powerline	188855	188854
160	3,6	2,5	40	18		8	30	0	HOLZ-HER	189041	189042
170	3,5	2,2	30	48	4/5,5/52	-12	45	10	Homag Powerline	181584	181583
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

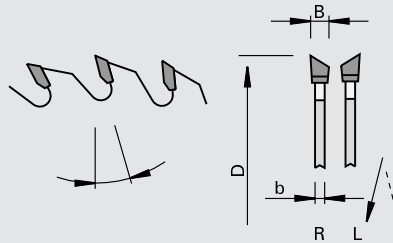
106350

Clipping Saw Blades HW for edge trimming „ES“ - with countersink

Product



Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

| sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠	Shear∠		Ident-No. [L]	Ident-No. [R]
110	3,2	2,5	40	20	4/6/52	-6	45	5	Homag	188277	188278
120	3,2	2,5	40	20	4/6/52	-6	45	5	Homag	188010	188011
130	3,6	2,8	30	20+4	4/7,4/46	10	30	0	Biesse	189545 s	189544 s
140	3,6	2,8	30	20+4	4/7,4/46	-20	30	0	Biesse	189547 s	189546 s
150	3,8	2,5	35	24+6	4/6/50	10	15	0	SCM-Stefani	189328	189327
[mm]	[mm]	[mm]	[mm]			[°]	[°]	[°]			

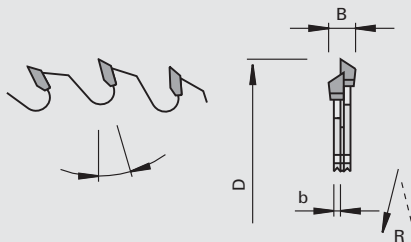
106354

Clipping Saw Blades HW for edge trimming - adjustable „ES“

Product



Drawing



LEUCO
topline_{HW}

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

- | LEUCODUR HW
- | sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Shear∠		Ident-No. [L]	Ident-No. [R]
100	5,8	2.2	32	2x20		8	5		169980	169983
125	6,2	2.0	30	2x20	2/3,1/42	10	0	SCM-Stefani	189329	189332
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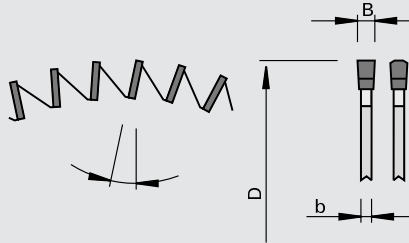
102370

NF-Chop Saw Blades HW „TR-F“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

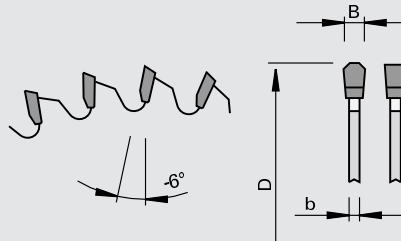
108672

NF-Circular Saw Blades HW - negative hook angle „TR-F“

Product



Drawing



LEUCO
highlight

LEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

l noise-reduction thanks to laser ornaments

Notes

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

Ø D	B	b	Ø d	Z	NL		Ident-No.
330	3,2	2.5	30	96		ELU, Haffner	189856
330	3,2	2.5	32	96		ELU	189857 &
350	3,8	3.2	40	84	4/12/64 + 2/9/55	Eisele LMS II, LMS II - P V, VA - L, Graule, Ulmia, Weidmann	189858
350	3,2	2.5	30	90	2/10/60	DeWALT, Haffner, Pfeiffer	189859
350	3,2	2.5	30	96	2/10/60		189860
350	3,2	2.5	30	108	2/9/55 + 2/10/60 + 4/12/64		189861 \$
350	3,2	2.5	40	108	4/12/64 + 2/9/55	Eisele LMS II, LMS II - PV, VA - L, Graule, Ulmia, Weidmann	189862 &
[mm]	[mm]	[mm]	[mm]				

108372

NF-Circular Saw Blades HW - negative hook angle „TR-F“

Product	Drawing	

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> chop and miter saws for clipping and mitre cuts in aluminum and plastic profiles 	<ul style="list-style-type: none"> negative hook angle tooth configuration: triple chip / flat "TR-F" cutting material: HW HL Board 06 	<ul style="list-style-type: none"> noise-reduction thanks to laser ornaments 	

Ø D	B	b	Ø d	Z	NL		Ident-No.
400	3,8	3.2	30	96	2/12/64 + 4/15/80	DeWALT, Haffner	189863
400	3,8	3.2	50	96	4/15/80	Kaltenbach TL 400	189864 &
420	4,0	3.2	30	96		Rapid, ELU	189865
450	3,8	3.2	30	96	4/12/64 + 2/12/80	DeWALT, Haffner	189866
500	4,0	3.4	30	120	2/10/70	Pfeiffer, Rapid	189867
[mm]	[mm]	[mm]	[mm]				

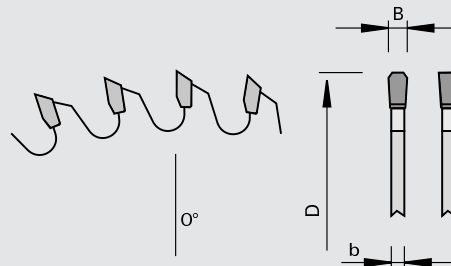
108370

NF-Chop Saw Blades HW - neutral hook angle „TR-F“

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	NL		Ident-No.
380	3,6	3.0	32	90		Elumatec	189111
420	3,8	3.2	30	102	2/10/70	Rapid, Elumatec	189074
500	4,0	3.4	30	114	2/10/70	Rapid, Elumatec	189075
500	4,0	3.4	32	114	2/12/64	Eisele LMS SCA	189076
550	4,4	3.8	30	126	2/10/70	Elumatec, Kaltenbach, Rapid	189113
[mm]	[mm]	[mm]	[mm]				

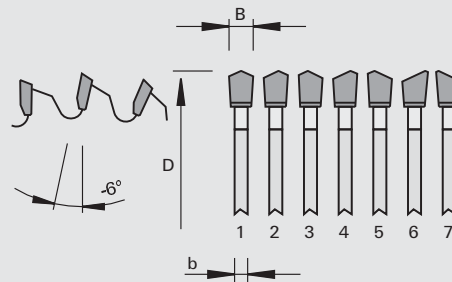
108352

NF-Chop Saw Blades HW- profiles „G7“

Product



Drawing



tungsten carbide [HW]



Machine / Application

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

Design

- | negative hook angle
- | tooth configuration: "G7"
- | cutting material: HW HL Board 06

Advantages

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

Notes

- | tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL	Ident-No.
350	3,2	2.5	30	112	2/9/55 + 2/12/64 + 4/12/64	192275
350	3,5	2.8	30	98	2/10/60	DeWALT, Haffner, Pfeiffer, Rotox 192274
350	3,8	3.2	40	84	4/12/64 + 2/9/55	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann 192273
400	3,8	3.2	30	98	2/12/64 + 4/15/80	DeWALT, Haffner 192276
420	4,0	3.2	30	98		Rapid, ELU 192277
450	3,8	3.2	30	112	4/12/64 + 2/12/80	DeWALT, Haffner 192278
500	4,0	3.4	30	126	2/10/70	Pfeiffer, Rapid 192279
550	4,0	3.4	30	133	2/12/64 + 4/15/80	Pfeiffer, Rapid 192392
[mm]	[mm]	[mm]	[mm]			

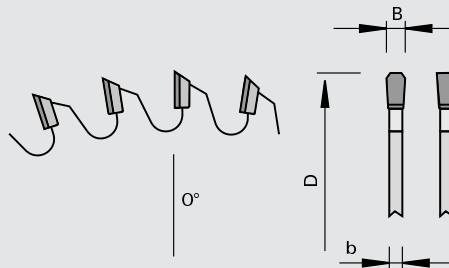
208170

DIAREX NF-Chop Saw Blades HW DP - Profile „TR-F“

Product



Drawing



polycrystalline diamond [DP]



Machine / Application

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

Design

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

Advantages

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

Notes

l tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
275	3,4	2.8	32	60	4/9/50	Wagner 1994	189868 s
285	3,4	2.8	32	60	4/9/50	Wagner	189869 s
380	3,6	3.0	32	84	4/9/50	Elumatec	189870 s
400	3,8	3.2	40	90	2/12/80	Eisele VA-L 350 NC1	189871 s
500	4,0	3.4	30	108	2/10/70	Elumatec	189872 s
550	4,2	3.6	30	120		Elumatec MGS	189873 s
[mm]	[mm]	[mm]	[mm]				

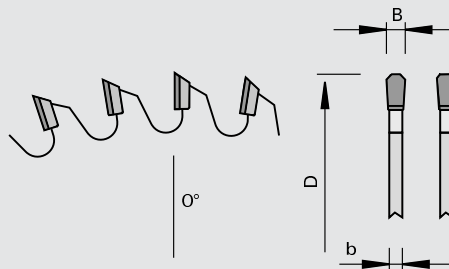
208180

DIAREX NF-Chop Saw Blades HW DP - Solid „TR-F-FA“

Product



Drawing



polycrystalline diamond [DP]



Machine / Application

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

Design

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

Advantages

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

Notes

l tight workpiece clamping required

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

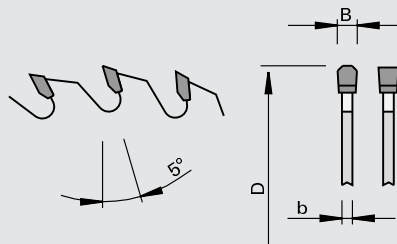
108671

NF-Chop Saw Blades HW - positive hook angle „TR-F“

Product



Drawing



LEUCO
Highline

LEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

noise-reduction thanks to laser ornaments

Notes

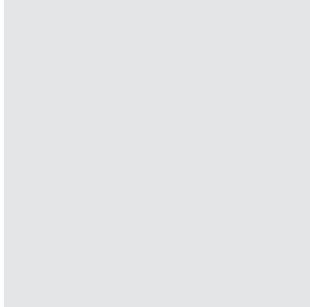
tight workpiece clamping required

Ø D	B	b	Ø d	Z	NL		Ident-No.
250	3,2	2.5	30	80	2/7/42	Haffner, ELU, Makita	189877
300	3,2	2.5	30	72	2/7/42 + 2/10/60	Fezer, Rapid	189878
300	3,2	2.5	30	96	2/7/42 + 2/10/60	Fezer, Rapid	189879
300	3,2	2.5	32	96			189880 &
350	3,2	2.5	30	108	2/10/60	Haffner, Rapid, Pfeffer	189881
[mm]	[mm]	[mm]	[mm]				

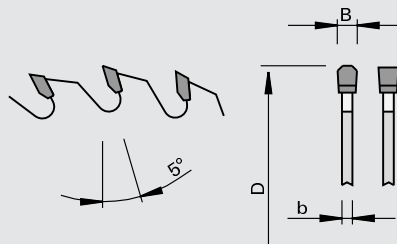
108371

NF-Chop Saw Blades HW - positive hook angle „TR-F“

Product



Drawing



LEUCO
Topline

LEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

noise-reduction thanks to laser ornaments

Notes

tight workpiece clamping required

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

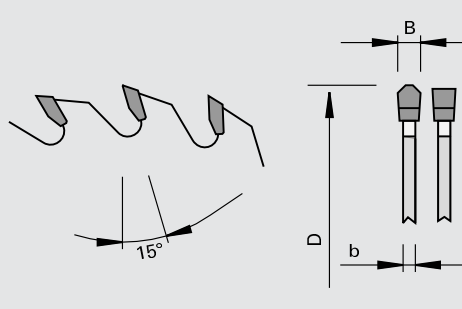
108373

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

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

LOW
noise

Machine / Application

| horizontal panel sizing saws
| for dividing cuts in aluminum
block materials

Design

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

Advantages

| noise-reduction thanks to laser
ornaments

Notes

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

Ø D	B	b	Ø d	Z	NL	H		Ident-No.
450	4,5	3,2	40	60	2/13/114	-100	Schelling	189887 s
450	4,8	3,5	60	60	2/14/125 + 2/19/120	-100	Schelling	189891 s
620	5,5	4,2	40	60	2/13/114	110-160	Schelling	189888 s
680	5,8	4,5	40	60	2/13/114	-200	Schelling	189889 s
720	6,0	4,8	40	60	2/13/114	150-220	Schelling	189890 s
[mm]	[mm]	[mm]	[mm]			[mm]		

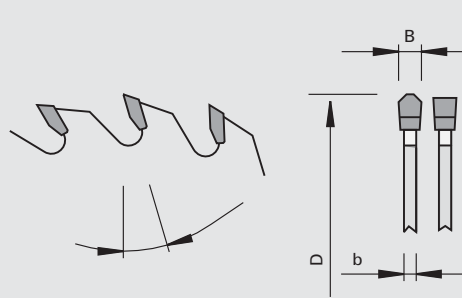
108271

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

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

LOW
vibration

Machine / Application

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

Design

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

Advantages

less vibration and noise thanks to laser ornaments

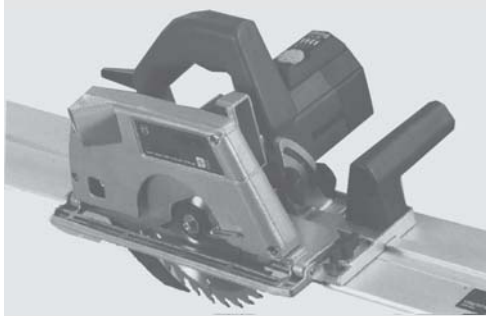
Notes

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

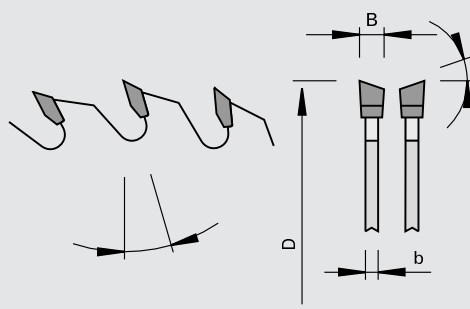
107520

Portable Saw Blades HW „WS“

Product



Drawing



LEUCO
euroline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
100	2,4	1,4	12	30		10	50110001
100	2,4	1,4	22	30		10	50110003
105	2,4	1,4	22	30		10	50110006
120	1,8	1,3	20	24		15	50104061
125	2,4	1,6	20	20	2/5,5/30	15	50110011
125	2,4	1,6	20	36	2/6/32,5	10	50110012
130	2,4	1,6	20	20	2/6/32,5	15	50110017
130	2,4	1,6	20	36	2/6/32,5	10	50110018
140	2,4	1,6	20	12	2/6/32,5	20	50110242
140	2,4	1,6	20	20	2/6/32,5	15	50110028
140	2,4	1,6	20	36	2/6/32,5	10	50110029
150	2,6	1,6	20	12	2/6/32,5	20	50110243
150	2,6	1,6	20	24	2/6/32,5	15	50110039
150	2,6	1,6	20	36	2/6/32,5	15	50110040
150	2,6	1,6	20	48	2/6/32,5	10	50110041
150	2,6	1,6	30	24	2/7/42	15	50110042
160	2,6	1,6	16	24	2/6/32,5	15	50110051
160	2,6	1,6	16	48	2/6/32,5	10	50110053
160	2,2	1,6	20	12	2/6/32,5	20	50110244
160	2,2	1,6	20	24	2/6/32,5	15	50110054
160	2,2	1,6	20	36	2/6/32,5	15	50110055
160	2,2	1,6	20	48	2/6/32,5	10	50110056
160	2,6	1,6	30	24	2/7/42	15	50110057
160	2,6	1,6	30	36	2/7/42	15	50110058
160	2,6	1,6	30	48	2/7/42	10	50110059
165	2,6	1,6	20	24	2/6/32,5	15	50110060
165	2,6	1,6	20	36	2/6/32,5	15	50110061
165	2,6	1,6	20	48	2/6/32,5	10	50110062
165	2,6	1,6	30	24	2/7/42	15	50110130
170	2,6	1,6	30	24	2/7/42	20	50110069
170	2,6	1,6	30	36	2/7/42	15	50110070
170	2,6	1,6	30	48	2/7/42	10	50110071
180	2,6	1,6	16	24	2/6/32,5	15	50110081
180	2,6	1,6	16	48	2/6/32,5	10	50110183
180	2,6	1,6	20	14	2/6/32,5	20	50110247
180	2,6	1,6	20	24	2/6/32,5	20	50110075
180	2,6	1,6	20	40	2/6/32,5	15	50110076
180	2,6	1,6	30	14	2/7/42	20	50110248
180	2,6	1,6	30	24	2/7/42	20	50110078
180	2,6	1,6	30	40	2/7/42	15	50110079
180	2,6	1,6	30	54	2/7/42	10	50110080
190	2,6	1,6	16	24	2/6/32,5	15	50110153
[mm]	[mm]	[mm]	[mm]			[°]	

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

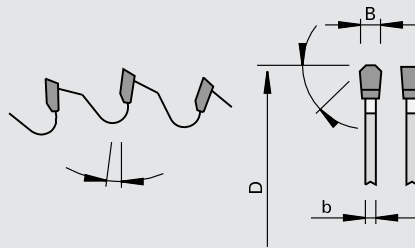
Ø D	B	b	Ø d	Z	NL	Hook angle	Ident-No.
270	3,2	2.2	30	24	2/7/42 + 2/9,5/46,5 + 2/10/60	20	58110176
270	3,2	2.2	30	60	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110182
280	3,2	2.2	30	48	2/7/42 + 2/9,5/46,5 + 2/10/60	10	58110136
[mm]	[mm]	[mm]	[mm]			[°]	

108472

Portable Saw Blades HW „WS“

Product

Drawing



LEUCO
proline

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

- portable saws
- for ripping and cross cuts in wood-based panels, NF-metals and solid woods

Design

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

Advantages



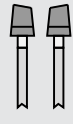

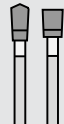

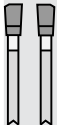


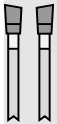
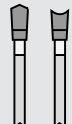


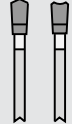



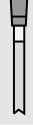
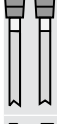

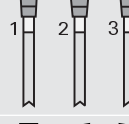
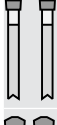

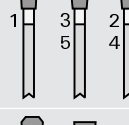


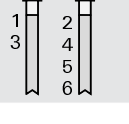
Notes

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

Tooth configuration

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

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

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

Number of teeth

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

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

Cutting speed (standard values)

HW Saw Blades

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

DP Saw Blades

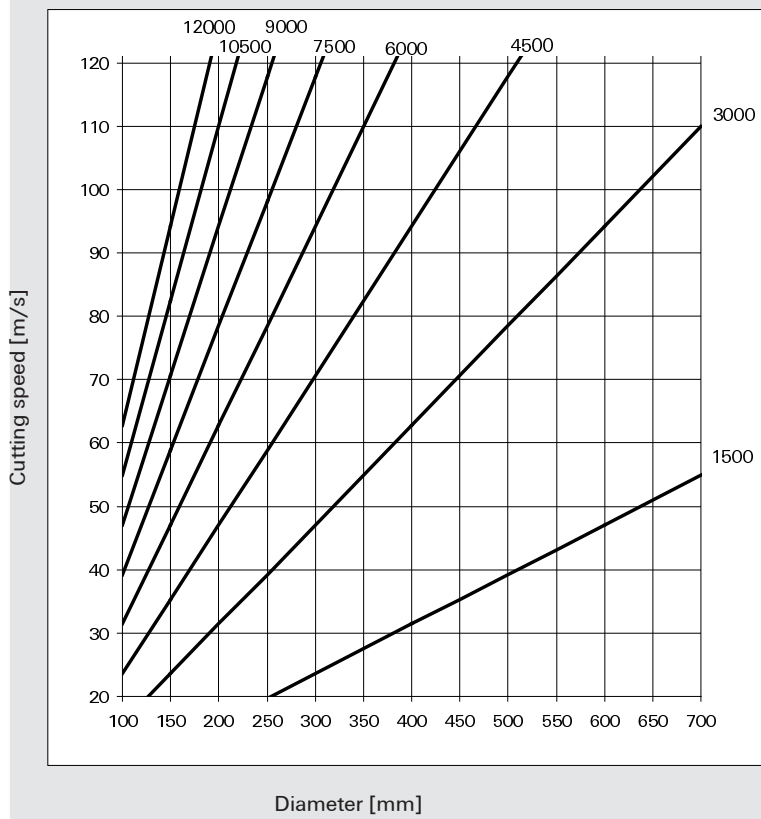
Workpiece material	Cutting speed vc [m/s]
CFRP, GRP	40 - 60
Thermosets (Pertinax®, Restitex®, etc.)	50 - 80
Polymer bound boards (Corian®, Varicor®)	60 - 90
Pressed laminated woods	40 - 60
Laminated particle boards and MDF boards	50 - 80
Foil-coated particle boards and MDF boards	64 - 100
Veneered particle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

Feed rate per tooth

HW Saw Blades

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

Determination of RPM [min-1]



Order / Inquiry for Special Tools: Circular Saw Blades

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

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

Machine

Make: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Flange diameter [mm]: _____

Motor output [kW]: _____

Type of machine:

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

Mode of application:

Against feed:

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

With feed:

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

Workpiece

Description: _____

Cut height [mm]: _____

Type of cut:

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

Cutting quality:

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

For solid wood:

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

For wood-based panels:

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

Tool

Cutting diameter D [mm]: _____

Cutting width B [mm]: _____

Saw plate thickness b [mm]: _____

Bore diameter d [mm]: _____

Countersinks and recesses

No. of countersinks: _____

Bore diameter db [mm]: _____

Countersink diameter ds [mm]: _____

Position angle α [°]: _____

Boring circle diameter Dt [mm]: _____

No. of recesses:

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

Pin holes:

No.	Ø NL	Ø TK
_____	_____	_____

Countersinks (per drawing):

Cut-outs for hoppers (per drawing):

No. of teeth [pcs.]: _____

Rakers:

Tooth configuration:

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

With relieved tool body:

Hub location (per drawing):

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

Hub diameter D1 [mm]: _____

Hub width b1 [mm]: _____

Sense of rotation:

Right	<input type="radio"/>	Left	<input type="radio"/>
-------	-----------------------	------	-----------------------

Application:

Single	<input type="radio"/>	Set	<input type="radio"/>
--------	-----------------------	-----	-----------------------

Check if applicable

Order / Inquiry for Special Tools: Circular Saw Blades

Name: _____ City and Date: _____

Product line

Topline

Proline

Euroline (only portable saw blades)

Cutting material

Carbide

Diamond

ST

HS

Please indicate additional dimension and markings in the schematic drawing.

Tool body

3 Double keyway

6 Pin hole

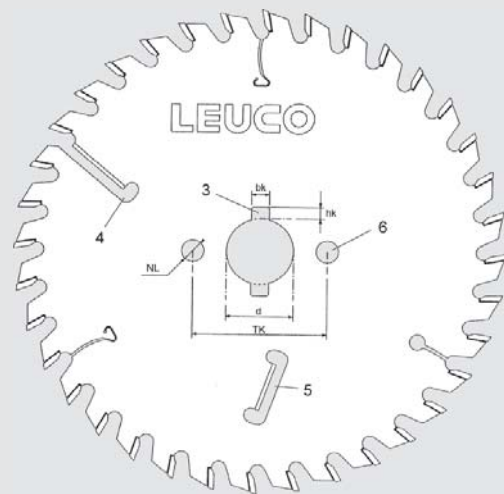
d

bk Width of keyway

hk Height of keyway

TK Reference diameter

NL Pin hole diameter



Additional tool body elements:

4 Raker with carbide cutting edge enclosed

5 Raker with carbide cutting edge open

Countersink and cut-out for hoggers

1 Countersink for countersunk flat headed screw

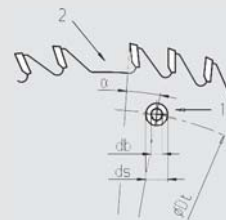
2 Cut-out for hoggers

db Bore diameter

ds Countersink diameter

α Position angle

Dt Boring circle diameter



Tool body

D Cutting diameter

b Saw plate thickness

d Bore

D1 Hub diameter

b1 Hub width

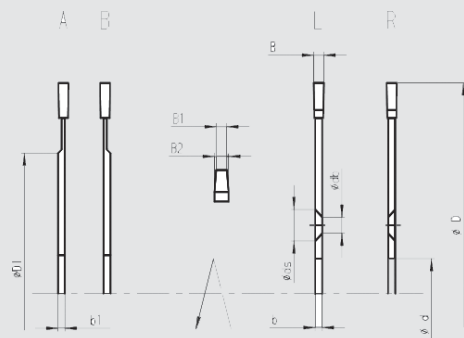
B1 Cutting width

B2 Cutting width

A/B Hub location

db Bore diameter

ds Countersink diameter



Sense of rotation

L Left

R Right

Checklist for NF customers

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

Machine data

Make: _____

Model: _____

Year of manufacture: _____

Driving power [kW]: _____

RPM [min-1]: Min _____ Max _____

Type of feed: MAN MEC

Cutting speed vc [m/min] max: _____

Type of machine:

Panel sizing saw: panel height [mm]: _____

Chop saw: Saw Blade From top _____

 From bottom _____

 Other _____

Workpiece

Workpiece material: _____

Workpiece material No.: _____

Workpiece clamping: _____

Workpiece form: _____

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

Dimension: _____

For profiles, wall thickness [mm]: _____

Application data

Feed rate vf [m/min]: _____

Cooling (spraying, dry, etc.): _____

Cutting speed vc [m/min]: _____

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

Saw Blade in current application

Make: _____

Diameter [mm]: _____

Bore [mm]: _____

Cutting height [mm]: _____

No. of teeth [pcs.]: _____

Hook angle [°]: _____

Cutting material: _____

Flange diameter [mm]: _____

Pin holes: _____

Saw plate thickness b [mm]: _____

Tooth configuration: _____

Uneven pitch: Yes No

Low-noise design: Yes No

Requirements with regards to cutting quality

Cutting time [sec]: _____

Surface quality: _____

Tool life (no. of cuts): _____

Misc.: _____

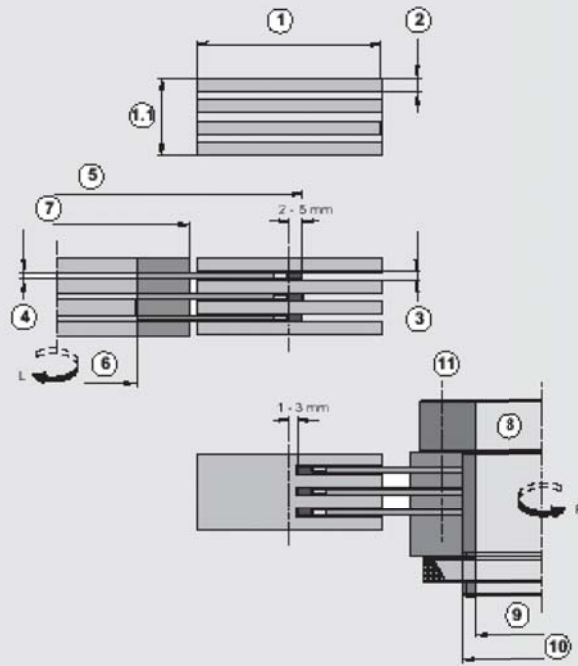
Notes

503-01.0106

Thin-Kerf Saw Blades on splitting machines

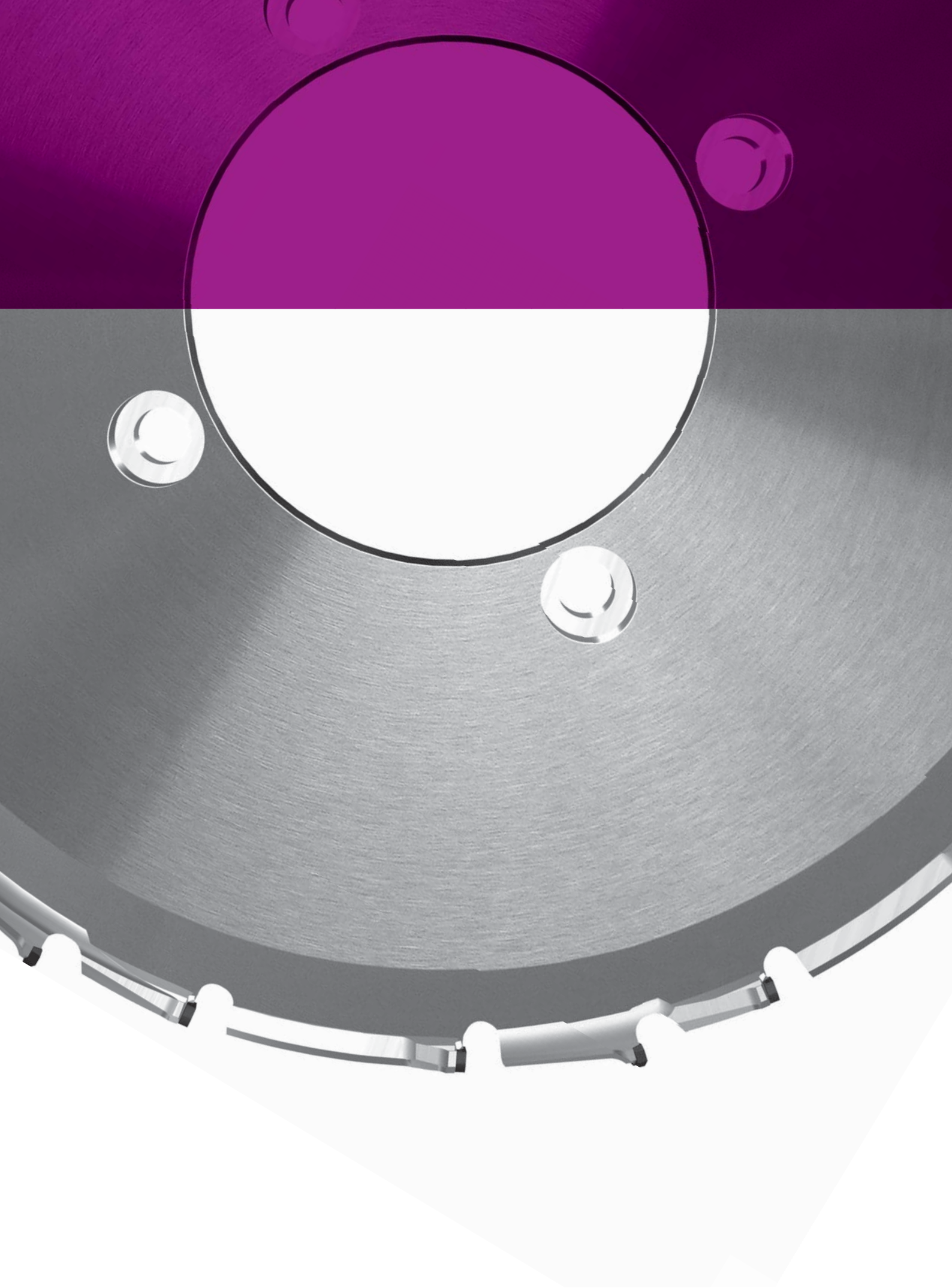
Customer-no.: _____
 Company: _____
 Plant: _____
 Street: _____
 Zip / City: _____
 Country: _____

Contact partner: _____
 Function: _____
 Phone: _____
 Fax: _____
 E-mail: _____

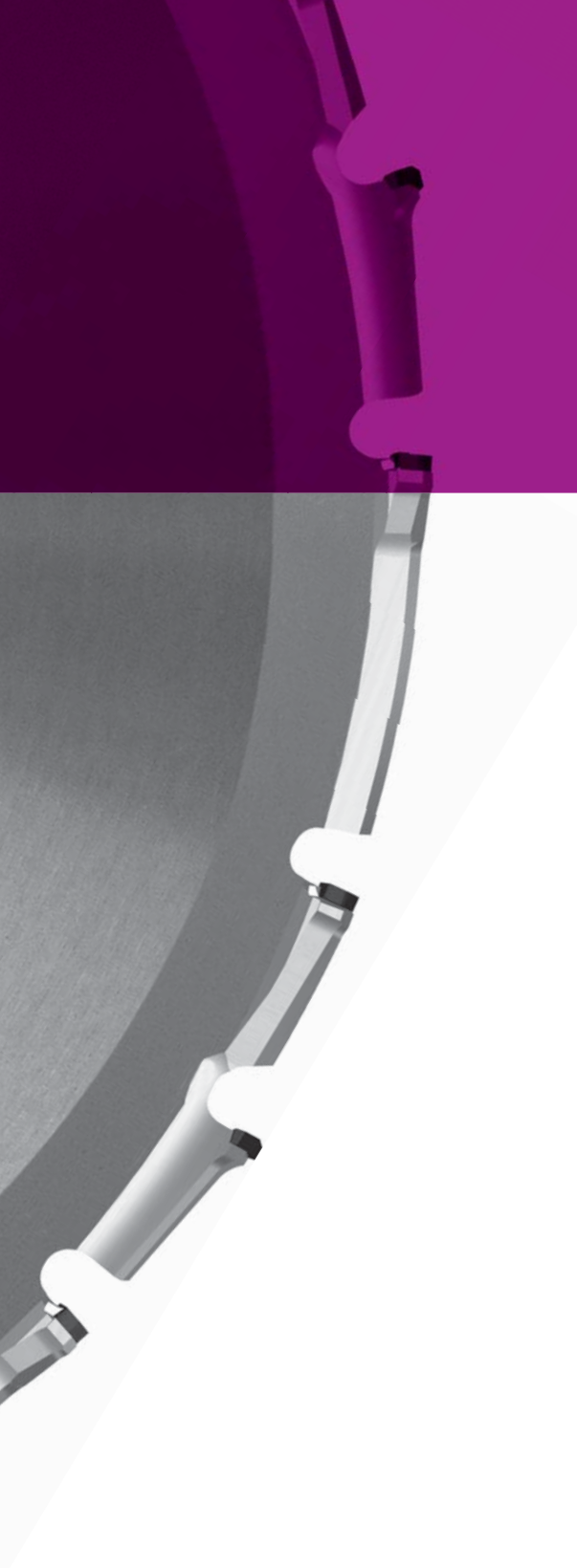


1.1 Wood type:	Humidity [%]:	No. of saw blades per spindle [pcs.]:
OSlat dimension: thickness	Length [mm]:	Edge saw blade: Yes <input type="radio"/> No <input type="radio"/>
1 Lamella width [mm]:		Current dimension:
2 Lamella thickness [mm]:		Saw Blades in current application (dimension):
3 Cutting width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

508-01.1006



Hoggers



Product	Page
PowerTec Hoggers	2-1
UniTec Hoggers	2-3
CompactTec Hoggers	2-7
Segment Hoggers	2-13
Folding Segment Hoggers	2-35
Saw Blade Hoggers	2-39
Accessories for Hoggers	2-44
Technical Information	2-55

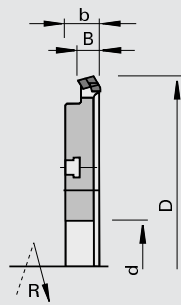
215052

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

Product



Drawing



LEUCO
powertec III

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

l n max = 7,200 min-1
l resharpening area 4 mm
l division of cut into low-noise hogger tooth and finish-cut tooth for optimum quality with closed cutting edges on one wing

Advantages

l also for high feed-speeds
l improved chip evacuation integrated into the tool
l high cutting quality for veneered panels due to division of cut
l extremely long edge lives thanks to optimized tooth form
l low vibration

Notes

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

Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	14,5	23	60	16+8+4	28	S-System Ø 160	183451	183450
250	14,5	23	60	20+10+5	45	S-System Ø 160	183453	183452
250	14,5	23	60	28+14+7	60	S-System Ø 160	183455 s	183454 s
250	14,5	23	60	36+18+9	80	S-System Ø 160	183457 s	183456 s
250	14,5	23	80	16+8+4	28	S-System Ø 192	183461 s	183460 s
250	14,5	23	80	20+10+5	45	S-System Ø 192	183463 s	183462 s
250	14,5	23	80	28+14+7	60	S-System Ø 192	183465 s	183464 s
250	14,5	23	80	36+18+9	80	S-System Ø 192	183467 s	183466 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

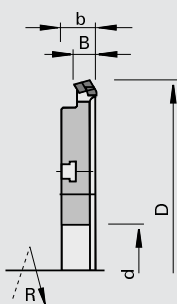
215352

PowerTec III topline Hoggers CM DP for LEUCO S-System Ø 160 mm and Ø 192 mm (DZ)

Product



Drawing

LEUCO
toplineLEUCO
powertec III

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

- reinforced DP cutting edges to avoid large circumference chippings
- full number of teeth also for the peripheral cutting edge and hogger tooth
- division of cut into low-noise hogger tooth and finish-cut tooth for optimum quality with closed cutting edges on one wing
- $n_{max} = 7,200 \text{ min}^{-1}$
- resharpening area 4 mm

Advantages

- also for high feed-speeds
- improved chip evacuation integrated into the tool
- high cutting quality due to division of cut
- improved cutting quality especially when exiting the edge when cutting across the grain and low-quality cores
- extremely long edge lives thanks to optimized tooth form
- low vibration

Notes

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

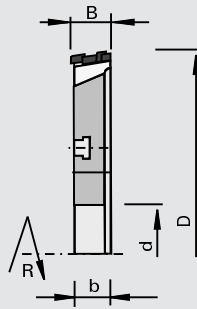
Ø D	B	b	Ø d	Z	Feed DZ		Ident-No. [L]	Ident-No. [R]
250	9,5	23	60	16+16	30	S-System Ø 160	184617 s	184616 s
250	9,5	23	60	20+20	45	S-System Ø 160	184619	184618
250	9,5	23	60	28+28	60	S-System Ø 160	184621	184620
250	9,5	23	60	36+36	80	S-System Ø 160	184623 s	184622 s
250	14,5	23	60	16+16+4	30	S-System Ø 160	184601 s	184600 s
250	14,5	23	60	20+20+5	45	S-System Ø 160	184603	184602
250	14,5	23	60	28+28+7	60	S-System Ø 160	184605	184604
250	14,5	23	60	36+36+9	80	S-System Ø 160	184607 s	184606 s
250	9,5	23	80	16+16	30	S-System Ø 192	184625 s	184624 s
250	9,5	23	80	20+20	45	S-System Ø 192	184627	184626
250	9,5	23	80	28+28	60	S-System Ø 192	184629	184628
250	9,5	23	80	36+36	80	S-System Ø 192	184631 s	184630 s
250	14,5	23	80	16+16+4	30	S-System Ø 192	184609 s	184608 s
250	14,5	23	80	20+20+5	45	S-System Ø 192	184611	184610
250	14,5	23	80	28+28+7	60	S-System Ø 192	184613	184612
250	14,5	23	80	36+36+9	80	S-System Ø 192	184615 s	184614 s
[mm]	[mm]	[mm]	[mm]		[m/min]			

215044

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

Product

Drawing



LEUCO
unitec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

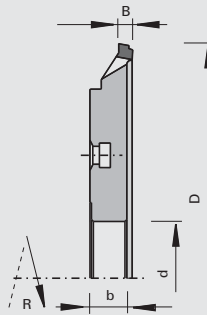
Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	8	23	60	24+12	30	182115 s	182114 s
250	8	23	60	36+18	45	182031 s	182030 s
250	8	23	60	48+24	60	182033 s	182032 s
250	8	23	60	54+27	70	182035 s	182034 s
250	16	23	60	36+18+6	45	182037 s	182036 s
250	16	23	60	48+24+6	60	182039 s	182038 s
250	16	23	60	54+27+9	70	182041 s	182040 s
250	24	23	60	36+18+6+6	45	182048 s	182042 s
250	24	23	60	48+24+6+6	60	182045 s	182044 s
250	24	23	60	54+27+9+9	70	182047 s	182046 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

215044

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

Product

Drawing



LEUCO
unitec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	10	23	60	24+12	28	183471 s	183470 s
250	10	23	60	36+18	40	183473 s	183472 s
250	10	23	60	48+24	50	183475 s	183474 s
250	10	23	60	60+30	75	183477 s	183476 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

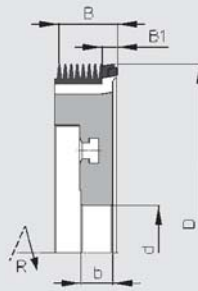
215044

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

Product



Drawing



LEUCO
unitec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	B1	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	34	8	23	60	36+18	45	182645 s	182644 s
250	34	8	23	60	48+24	60	182647 s	182646 s
[mm]	[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts

Class-No.

Ident-No.

HS insert

332921

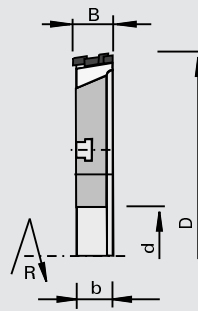
50570980

215044

UniTec Hogsers CM DP for LEUCO S-System Ø 192 mm (RZ/DZ)

Product

Drawing



LEUCO
unitec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

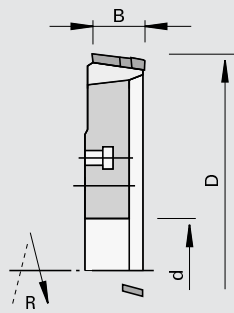
215082

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

Product



Drawing



LEUCO
CompactTec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	10	20	60	30+5+5	30	182537 s	182536 s
250	10	20	60	36+6+6	35	182539 s	182538 s
250	10	20	60	48+6+6	50	182541 s	182540 s
250	10	20	60	56+8+8	65	182543 s	182542 s
250	10	20	60	72+8+8	80	182545 s	182544 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

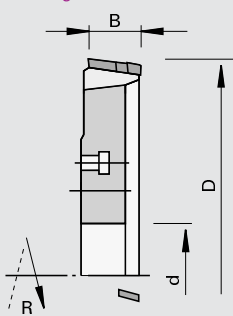
215082

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

Product



Drawing



LEUCO
compacttec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	10	20	80	30+5+5	30	182547 s	182546 s
250	10	20	80	36+6+6	35	182549 s	182548 s
250	10	20	80	48+6+6	50	182551 s	182550 s
250	10	20	80	56+8+8	65	182553 s	182552 s
250	10	20	80	72+8+8	80	182555 s	182554 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

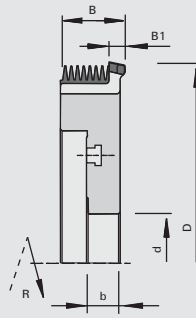
215084

CompactTec N veneer Hoggers CM DP for LEUCO S-System Ø 160 mm (RZ/DZ)

Product



Drawing



LEUCO
compacttec

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	B1	b	Ø d	Z	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	36	10	23	60	36+6+6	35	182649 s	182648 s
250	36	10	23	60	48+6+6	50	182651 s	182650 s
[mm]	[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts

	Class-No.	Ident-No.
HS insert	332921	50570980

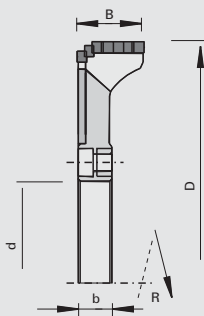
215089

Compact Hogger DP - for dividing laminate boards

Product



Drawing



LEUCO
compacttec

polycrystalline diamond [DP]

MEC

Machine / Application

- | panel sizing saws
- | laminate flooring

Design

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

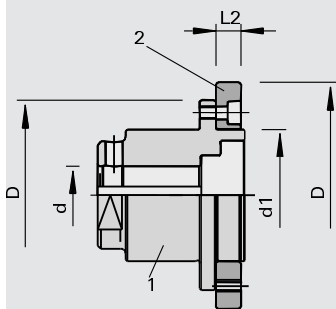
Advantages

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

Notes

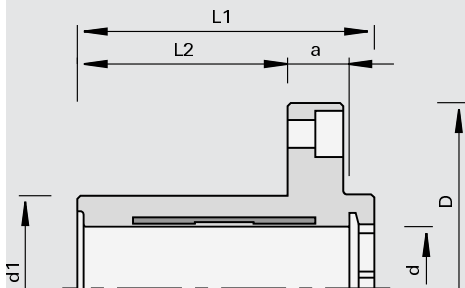
- | application against feed for cutting along and across the grain
- | sense of rotation according to DIN-EN 50144

Hogger on special flange 35 DKN 189750



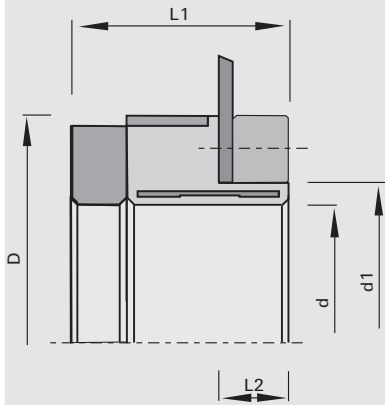
Ø D	B	Ø d	DKN	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	35	10x4	48+24+12+12	2x4/8/130	189737 s	189738 s
260	25	35	10x4	48+24+12+12	2x4/8/130	189739 s	189740 s
260	36	35	10x4	48+24+12+12	2x4/8/130	189741 s	189742 s
260	18	35	10x4	36+18+9+9	2x4/8/130	189743 s	189744 s
260	25	35	10x4	36+18+9+9	2x4/8/130	189745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

Hogger on hydro bushing 172678 with special flange 189749



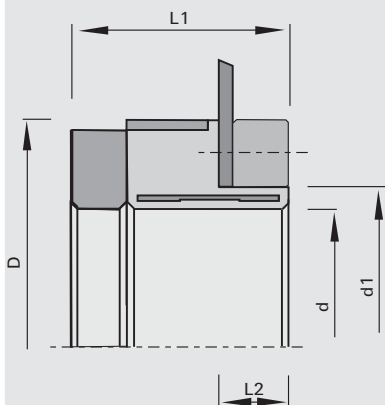
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	40	48+24+12+12	2x4/8/130	189752 s	189753 s
260	25	40	48+24+12+12	2x4/8/130	189754 s	189755 s
260	36	40	48+24+12+12	2x4/8/130	189756 s	189757 s
260	18	40	36+18+9+9	2x4/8/130	189758 s	189759 s
260	25	40	36+18+9+9	2x4/8/130	189760 s	189761 s
260	36	40	36+18+9+9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

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



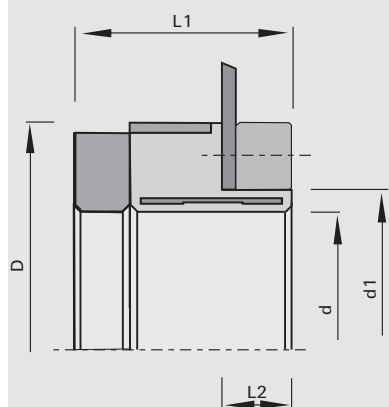
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189809 s	189810 s
260	25	100	48+24+12+12	2x4/8/130	189811 s	189812 s
260	36	100	48+24+12+12	2x4/8/130	189813 s	189814 s
260	18	100	36+18+9+9	2x4/8/130	189815 s	189816 s
260	25	100	36+18+9+9	2x4/8/130	189817 s	189818 s
260	36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

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



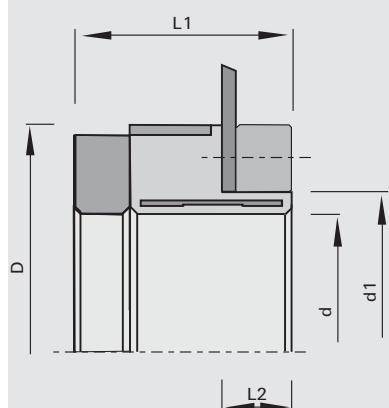
Ø D	B	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
260	18	100	48+24+12+12	2x4/8/130	189821 s	189822 s
260	25	100	48+24+12+12	2x4/8/130	189823 s	189824 s
260	36	100	48+24+12+12	2x4/8/130	189825 s	189826 s
260	18	100	36+18+9+9	2x4/8/130	189827 s	189828 s
260	25	100	36+18+9+9	2x4/8/130	189829 s	189830 s
260	36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

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



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

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



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

Attachment Sleeves and Flanges	Dimension	Class-No.	Ident-No.
Hydro Clamping Bushing	$\emptyset 120 \times 96 \times \emptyset 60 / 40$	933030	172678
attachment flange for hydro clamping bushing	$\emptyset 147 \times 69,4 \times \emptyset 110 / 60$	997300	189749s
attachment bushing	$\emptyset 145 \times 89,4 \times \emptyset 110 / 35$ DKN	997300	189750s
Hydro Clamping Bushing	$\emptyset 145 \times 65,5 \times \emptyset 110 / 100$	933030	183829
Hydro Clamping Bushing	$\emptyset 150 \times 49,5 \times \emptyset 110 / 100$	933030	183821s
	[mm]		

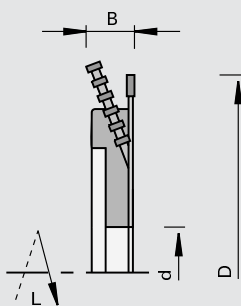
115122

Segment Hoggers HW - Circular Cut „WS“

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	60	48	6 x 8	004813 &	004885 &
300	40	60	48	6 x 10	004819 &	004891 &
300	30	80	48	6 x 8	004816 &	004888 &
300	40	80	48	6 x 10	004822 &	004894 &
300	30	60	60	6 x 8	053174 &	053210 &
300	40	60	60	6 x 10	053180 &	053216 &
300	30	80	60	6 x 8	053177 &	053213 &
300	40	80	60	6 x 10	053183 &	053219 &
300	30	60	72	6 x 8	005437 s	005509 s
300	40	60	72	6 x 10	005443 s	005515 s
300	30	80	72	6 x 8	005440 s	005512 s
300	40	80	72	6 x 10	005446 s	005518 s
300	30	60	96	6 x 8	005581 &	005653 &
300	40	60	96	6 x 10	005587 &	005659 &
300	30	80	96	6 x 8	005584 &	005656 &
300	40	80	96	6 x 10	005590 &	005662 &
305	30	60	48	6 x 8	172935 &	172939 &
305	40	60	48	6 x 10	172936 &	172940 &
305	30	80	48	6 x 8	172937 &	172941 &
305	40	80	48	6 x 10	172938 &	172942 &
355	40	40	54	6 x 10		006466 &
355	30	60	54	6 x 8	004427 &	004501 &
355	40	60	54	6 x 10	004433 &	004507 &
355	30	80	54	6 x 8	004430 &	004504 &
355	40	80	54	6 x 10	004436 &	004510 &
355	40	40	72	6 x 10		006470 &
355	30	60	72	6 x 8	004283 &	004355 &
355	40	60	72	6 x 10	004289 &	004361 &
355	30	80	72	6 x 8	004286 &	004358 &
355	40	80	72	6 x 10	004292 &	004364 &
430	40	80	72	6 x 10	004293 s	004365 s
350	30	60	54	6 x 8	004886 &	004814 &
350	40	60	54	6 x 10	004892 &	004820 &
350	30	80	54	6 x 8	004889 &	004817 &
350	40	80	54	6 x 10	004895 &	004823 &
350	30	60	72	6 x 8	053211 &	053175 &
350	40	60	72	6 x 10	053217 &	053181 &
350	30	80	72	6 x 8	053214 &	053178 &
350	40	80	72	6 x 10	053220 &	053184 &
350	30	60	84	6 x 8	005510 &	005438 &
350	40	60	84	6 x 10	005516 &	005444 &

[mm] [mm] [mm]

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
350	30	80	84	6 x 8	005513 &	005441 &
350	40	80	84	6 x 10	005519 &	005447 &
350	30	60	108	6 x 8	005654 &	005582 &
350	40	60	108	6 x 10	005660 &	005588 &
350	30	80	108	6 x 8	005657 &	005585 &
350	40	80	108	6 x 10	005663 &	005591 &
[mm]	[mm]	[mm]				

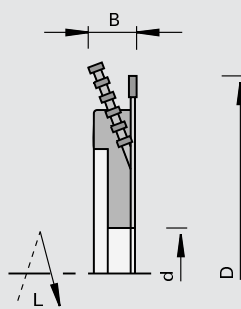
115122

Segment Hoggers HW - Stepped Cut „WS“

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
300	30	60	48	6 x 8	004831 &	004903 &
300	40	60	48	6 x 10	004837 &	004909 &
300	30	80	48	6 x 8	004834 &	004906 &
300	40	80	48	6 x 10	004840 &	004912 &
300	30	60	60	6 x 8	053192 &	053228 &
300	40	60	60	6 x 10	053198 &	053234 &
300	30	80	60	6 x 8	053195 &	053231 &
300	40	80	60	6 x 10	053201 &	053237 &
300	30	60	72	6 x 8	005455 s	005527 s
300	40	60	72	6 x 10	005461 s	005533 s
300	30	80	72	6 x 8	005458 s	005530 s
300	40	80	72	6 x 10	005464 s	005536 s
300	30	60	96	6 x 8	005599 &	005671 &
300	40	60	96	6 x 10	005605 &	005677 &
300	30	80	96	6 x 8	005602 &	005674 &
300	40	80	96	6 x 10	005608 &	005680 &
350	30	60	54	6 x 8	004832 &	004904 &
350	40	60	54	6 x 10	004838 &	004910 &
350	30	80	54	6 x 8	004835 &	004907 &
350	40	80	54	6 x 10	004841 &	004913 &
350	30	60	72	6 x 8	053193 s	053229 s
350	40	60	72	6 x 10	053199 &	053235 &
350	30	80	72	6 x 8	053196 &	053232 &
350	40	80	72	6 x 10	053202 &	053238 &
350	30	60	84	6 x 8	005456 &	005528 &
350	40	60	84	6 x 10	005462 &	005534 &
350	30	80	84	6 x 8	005459 &	005531 &
350	40	80	84	6 x 10	005465 &	005537 &
350	30	60	108	6 x 8	005600 &	005672 &
350	40	60	108	6 x 10	005606 &	005678 &
350	30	80	108	6 x 8	005603 &	005675 &
[mm]	[mm]	[mm]				

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
350	40	80	108	6 x 10	005609 &	005681 &
305	30	60	48	6 x 8	172947 &	172947 &
305	40	60	48	6 x 10	172948 &	172948 &
305	30	80	48	6 x 8	172945 &	172949 &
305	40	80	48	6 x 10	172950 &	172950 &
355	40	40	54	6 x 10	006465 &	006467 &
355	30	60	54	6 x 8	004445 &	004519 &
355	40	60	54	6 x 10	004451 &	004525 &
355	30	80	54	6 x 8	004448 &	004522 &
355	40	80	54	6 x 10	004454 &	004528 &
355	40	40	72	6 x 10	006469 &	006471 &
355	30	60	72	6 x 8	004301 &	004373 &
355	40	60	72	6 x 10	004307 &	004379 &
355	30	80	72	6 x 8	004304 &	004376 &
355	40	80	72	6 x 10	004310 &	004382 &
430	40	80	72	6 x 10	004311 s	004383 s
[mm]	[mm]	[mm]				

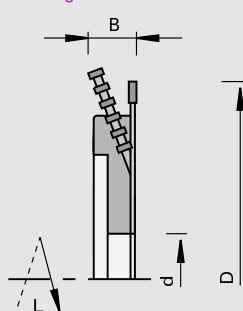
115147

Segment Hoggers HW - Circular Cut „TR-F“

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
305	30	60	60	6 x 8	172951 &	172955 &
305	40	60	60	6 x 10	172952 &	172956 &
305	30	80	60	6 x 8	172953 &	172957 &
305	40	80	60	6 x 10	172954 &	172958 &
355	40	40	72	6 x 10	006460 &	006462 &
355	30	60	72	6 x 8	004573 &	004645 &
355	40	60	72	6 x 10	004579 &	004651 &
355	30	80	72	6 x 8	004576 &	004648 &
355	40	80	72	6 x 10	004582 &	004654 &
[mm]	[mm]	[mm]				

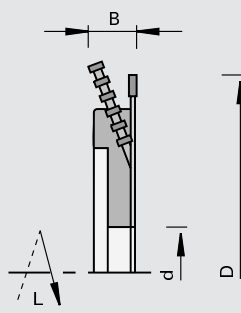
115247

Segment Hoggers HW - Stepped Cut „TR-F“

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
305	30	60	60	6 x 8	172959 &	172963 &
305	40	60	60	6 x 10	172960 &	172964 &
305	30	80	60	6 x 8	172961 &	172965 &
305	40	80	60	6 x 10	172962 &	172966 &
355	40	40	72	6 x 10	006461 &	006463 &
355	30	60	72	6 x 8	004591 &	004663 &
355	40	60	72	6 x 10	004597 &	004669 &
355	30	80	72	6 x 8	004594 &	004666 &
355	40	80	72	6 x 10	004600 &	004672 &
[mm]	[mm]	[mm]				

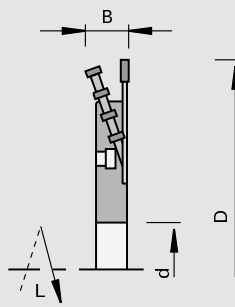
115521

Segment Hoggers HW for LEUCO S-System Ø 192 mm - Circular Cut „F“ (RZ/DZ)

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
250	18	80	48	6 x 4	160877 &	160879 &
250	18	80	72	6 x 4	160878 &	160880 &
250	36	80	48	12 x 4	164400 &	164401 &
250	36	80	72	12 x 4	164402 &	164403 &
[mm]	[mm]	[mm]				

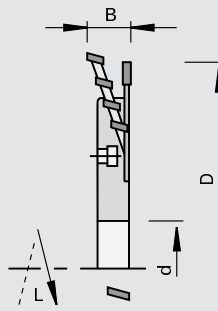
215032

Segment Hoggers DP for LEUCO S-System Ø 192 mm - Circular Cut „ES-FA“ (RZ/DZ)

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

- | application with feed
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | the specified feed rates are based on n = 6,000 min⁻¹
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	18	80	24	15	25	170693 s	170694 s
250	18	80	30	20	32,5	170695 s	170696 s
250	18	80	36	25	40	170697 s	170698 s
250	18	80	42	27,5	45	170699 s	170700 s
250	18	80	48	30	50	170701 s	170702 s
250	18	80	54	35	55	170703 s	170704 s
250	18	80	60	40	60	170705 s	170706 s
250	18	80	66	45	65	170707 s	170708 s
250	18	80	72	50	70	170709 s	170710 s
[mm]	[mm]	[mm]		[m/min]	[m/min]		

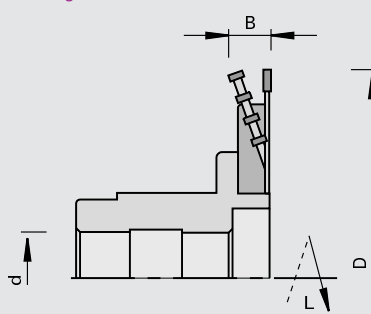
115321

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

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	Ø d	Z	Z segments		Ident-No. [L]	Ident-No. [R]
200	18	35	40	4 x 4	B+G, BIMAG, Hüllhorst	005862 &	005926 s
200	18	35	40	4 x 4	B+G (spindle with flat nut)	005863 &	005927 &
200	18	40	40	4 x 4	B+G	005864 &	005928 &
200	18	40	40	4 x 4	M+S	005865 &	005929 &
200	18	35	40	4 x 4	Danckaert	005867 &	005931 &
200	18	40	40	4 x 4	Gabbiani (spindle with key)	005868 &	005932 &
200	18	30	40	4 x 4	Wadkin, Lehbrink	005869 &	005933 &
200	18	35	40	4 x 4	Kuhlmann	005870 &	005934 &
200	18	35	40	4 x 4	Celaschi	005872 &	005936 &
200	18	35	40	4 x 4		005873 s	005937 s
200	18	30	40	4 x 4	SPA	005874 s	005938 s
200	18	35	40	4 x 4	Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	005876 &	005940 &
200	18	35	60	4 x 4	B+G, Bimag, Hüllhorst	005990 &	006054 &
200	18	35	60	4 x 4	B+G (spindle with flat nut)	005991 &	006055 &
200	18	40	60	4 x 4	B+G	005992 &	006056 &
200	18	40	60	4 x 4	M+S	005993 &	006057 &
200	18	35	60	4 x 4	Danckaert	005995 &	006059 &
200	18	40	60	4 x 4	Gabbiani (spindle with key)	005996 &	006060 &
200	18	30	60	4 x 4	Lehbrink, Wadkin	005997 &	006061 &
200	18	35	60	4 x 4	Kuhlmann	005998 &	006062 &
200	18	35	60	4 x 4	Celaschi	006000 &	006064 &
200	18	35	60	4 x 4		006001 &	006065 &
200	18	30	60	4 x 4	SPA	006002 &	006066 &
200	18	35	60	4 x 4	Homag, Homburg, SCM-IDM, IMA 14 / 16 / 19 / 20	006004 &	006068 &
200	18	35	40	4 x 4	Frommia	052518 &	052514 &
200	18	35	60	4 x 4	Frommia	052526 &	052522 &
250	18	35	72	6 x 4	B+G, Bimag, Hüllhorst	057154 &	057155 &
250	18	35	72	6 x 4	B+G (spindle with flat nut)	057156 &	057157 &
250	18	40	72	6 x 4	B+G	057158 &	057159 &
250	18	35	72	6 x 4	Celaschi	057160 &	057161 &
250	18	35	72	6 x 4	Danckaert	057162 &	057163 &
250	18	40	72	6 x 4	Gabbiani (spindle with key)	057164 &	057165 &
250	18	35	72	6 x 4	Frommia	057166 &	057167 &
250	18	35	72	6 x 4	Homag, Homburg, IMA, Koch	057168 &	057169 &
250	18	35	72	6 x 4	Kuhlmann	057170 &	057171 &
250	18	40	72	6 x 4	M+S	057172 &	057173 &
250	18	30	72	6 x 4	SPA	057174 &	057175 &
250	18	30	72	6 x 4	Lehbrink, Wadkin	057176 &	057177 &
250	18	35	72	6 x 4		057178 &	057179 &
[mm]	[mm]	[mm]					

Ø D	B	Ø d	Z	Z segments		Ident-No. [L]	Ident-No. [R]
200	18	35	40	4 x 4	Raimann	059182 &	059186 &
200	18	35	60	4 x 4	Raimann	059190 &	059194 &
250	18	35	72	6 x 4	Raimann	059198 &	059202 &
200	18	35	40	4 x 4	Festo	059516 &	059520 &
200	18	35	60	4 x 4	Festo	059524 &	059528 &
250	18	35	48	6 x 4	B+G, Hüllhorst, Bimag	162135 &	162139 &
250	18	35	48	6 x 4	B+G (spindle with flat nut)	162143 &	162147 &
250	18	35	48	6 x 4	Celaschi	162159 &	162163 &
250	18	35	48	6 x 4	Danckaert	162167 &	162171 &
250	18	40	48	6 x 4	M+S	162175 &	162179 &
250	18	35	48	6 x 4	Raimann	162183 &	162187 &
250	18	30	48	6 x 4	SPA	162191 &	162195 &
250	18	30	48	6 x 4	Lehbrink, Wadkin	162199 &	162203 &
250	18	35	48	6 x 4		162207 &	162211 &
250	18	40	48	6 x 4	Gabbiani (spindle with key)	162223 &	162227 &
250	18	35	48	6 x 4	Frommia	162231 &	162235 &
250	18	35	48	6 x 4	Homag, SCM-IDM, Homburg, IMA	162239 &	162243 &
250	18	35	48	6 x 4	Kuhlmann	162247 &	162251 &
250	18	35	48	6 x 4	Festo	162255 &	162259 &
250	18	35	72	6 x 4	Festo	162263 &	162267 &
[mm]	[mm]	[mm]					

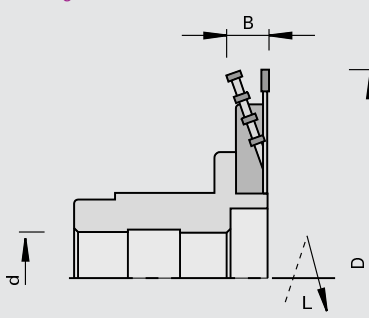
215031

Segment Hoggers DP mounted on Bushing - Circular Cut „ES-FA“ (RZ/DZ)

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

- | resharpenable area 4 mm; sides of teeth can be resharpened
- | saw blade with equal tooth pitch
- | tooth configuration of the saw blade: top bevel with chamfer and shear angle "ES-FA"

Advantages

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

Notes

- | for scoring/hogging (RZ) and double hogging (DZ) process
- | application with feed
- | the specified feed rates are based on n = 6,000 min-1

Ø D	B	Ø d	Z	DKN	Z segments	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
200	18	35	24	10x3,3	4 x 4	15	25	170453 s	170454 s
200	18	35	28	10x3,3	4 x 4	17,5	30	170455 s	170456 s
200	18	35	32	10x3,3	4 x 4	20	32,5	170457 s	170458 s
200	18	35	36	10x3,3	4 x 4	22,5	35	170459 s	170460 s
200	18	35	40	10x3,3	4 x 4	25	40	170461 s	170462 s
200	18	35	44	10x3,3	4 x 4	27,5	45	170463 s	170464 s
200	18	35	48	10x3,3	4 x 4	30	50	170465 s	170466 s
250	18	35	24	10x3,3	6 x 4	15	25	170567 s	170568 s
250	18	35	30	10x3,3	6 x 4	20	32,5	170569 s	170570 s
250	18	35	36	10x3,3	6 x 4	25	40	170571 s	170572 s
250	18	35	42	10x3,3	6 x 4	27,5	45	170573 s	170574 s
250	18	35	48	10x3,3	6 x 4	30	50	170575 s	170576 s
250	18	35	54	10x3,3	6 x 4	35	55	170577 s	170578 s
250	18	35	60	10x3,3	6 x 4	40	60	170579 s	170580 s
250	18	35	66	10x3,3	6 x 4	45	65	170581 s	170582 s
250	18	35	72	10x3,3	6 x 4	50	70	170583 s	170584 s
[mm]	[mm]	[mm]		[mm]		[m/min]	[m/min]		

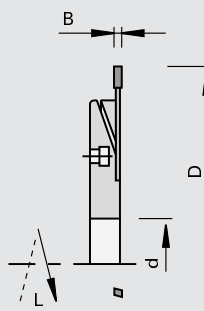
215032

Saw-Blade Hoggers DP for LEUCO S-System Ø 192 mm „ES-FA“ (RZ/DZ)

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- | excellent cutting quality thanks to high concentric and runout accuracy
- | decreased downtimes thanks to extremely long edge lives

Notes

- | for combination with shear angle segments / HW Class-No. 116200 / LEUCODIA Class-No. 216200
- | application with feed
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | the specified feed rates are based on n = 6,000 min⁻¹
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
250	4	80	24	15	25	170675 s	170676 s
250	4	80	30	20	32,5	170677 s	170678 s
250	4	80	36	25	40	170679 s	170680 s
250	4	80	42	27,5	45	170681 s	170682 s
250	4	80	48	30	50	170683 s	170684 s
250	4	80	54	35	55	170685 s	170686 s
250	4	80	60	40	60	170687 s	170688 s
250	4	80	66	45	65	170689 s	170690 s
250	4	80	72	50	70	170691 s	170692 s
[mm]	[mm]	[mm]		[m/min]	[m/min]		

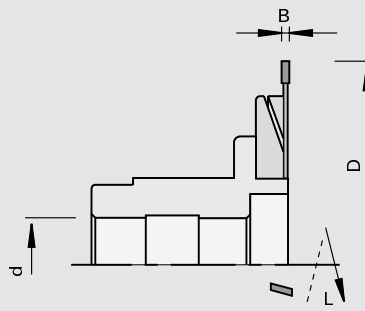
215032

Saw-Blade Hoggers DP mounted on Bushing „ES-FA“ (RZ/DZ)

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- | excellent cutting quality thanks to high concentric and runout accuracy
- | decreased downtimes thanks to extremely long edge lives

Notes

- | for combination with HW and DP shear angle segments
- | application with feed
- | for scoring/hogging (RZ) and double hogging (DZ) process
- | the specified feed rates are based on n = 6,000 min-1
- | sense of rotation see drawing

Ø D	B	Ø d	Z	DKN	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
200	4	35	24	10x3,3	15	25	170439 s	170440 s
200	4	35	28	10x3,3	17,5	30	170441 s	170442 s
200	4	35	32	10x3,3	20	32,5	170443 s	170444 s
200	4	35	36	10x3,3	22,5	35	170445 s	170446 s
200	4	35	40	10x3,3	25	40	170447 s	170448 s
200	4	35	44	10x3,3	27,5	45	170449 s	170450 s
200	4	35	48	10x3,3	30	50	170451 s	170452 s
250	4	35	24	10x3,3	15	25	170549 s	170550 s
250	4	35	30	10x3,3	20	32,5	170551 s	170552 s
250	4	35	36	10x3,3	25	40	170553 s	170554 s
250	4	35	42	10x3,3	27,5	45	170555 s	170556 s
250	4	35	48	10x3,3	30	50	170557 s	170558 s
250	4	35	54	10x3,3	35	55	170559 s	170560 s
250	4	35	60	10x3,3	40	60	170561 s	170562 s
250	4	35	66	10x3,3	45	65	170563 s	170564 s
250	4	35	72	10x3,3	50	70	170565 s	170566 s
[mm]	[mm]	[mm]		[mm]	[m/min]	[m/min]		

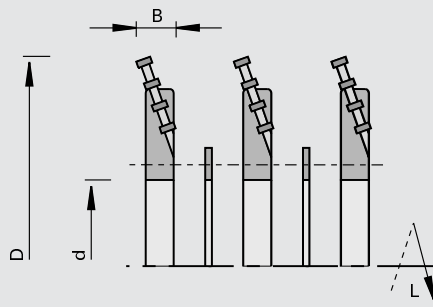
115301

Segment Extensions HW - Circular Cut

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

for hogging of large offal widths and veneer overhang

Design

Advantages




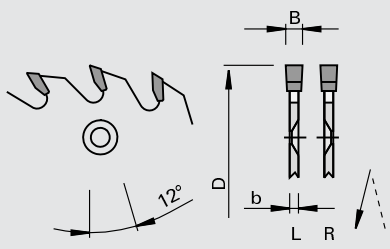
Notes

- extendable to 72 mm
- for subsequent extension of existing folding hoggers \varnothing 200 mm and \varnothing 250 mm
- the extensions consist of a body with installed HW segments, spacer and screws
- sense of rotation see drawing

\varnothing D	B	\varnothing d	Z	Ident-No. [L]	Ident-No. [R]
200	18 - 36	80	4 x 4	006406 ♂	006407 ♂
200	18 - 54	80	8 x 4	006408 ♂	006409 ♂
200	18 - 72	80	12x4	006410 ♂	006411 ♂
200	36 - 54	80	4 x 4	006433 ♂	006434 ♂
200	36 - 72	80	8 x 4	006435 ♂	006436 ♂
200	54 - 72	80	4 x 4	006437 ♂	006438 ♂
250	18 - 36	80	6 x 4	058390 ♂	058391 ♂
250	18 - 54	80	12 x 4	058392 ♂	058393 ♂
250	18 - 72	80	18 x 4	058394 ♂	058395 ♂
250	36 - 54	80	6 x 4	058396 ♂	058397 ♂
250	36 - 72	80	12 x 4	058398 ♂	058399 ♂
250	54 - 72	80	6 x 4	058402 ♂	058403 ♂
[mm]	[mm]	[mm]			

102312

Sizing Saw Blades HW for Segment Hoggers „F“



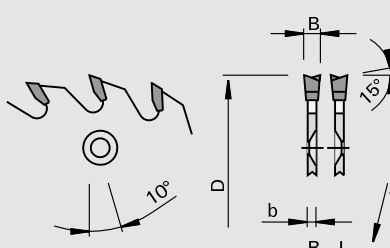
Product	Drawing	  tungsten carbide [HW] <hr/> MEC
		

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> double end tenoners edge trimming machines for sizing cuts in laminated and raw panels 	<ul style="list-style-type: none"> tooth configuration: flat "F" cutting material: HW HL Board 06 		<ul style="list-style-type: none"> bore diameter 100 mm for S-System hogger sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
200	4,0	2.8	80	40	4/6,5/140	188226	188227
200	4,0	2.8	80	60	4/6,5/140	188228 \$	188229
250	4,0	2.8	80	48	6/6,5/200	188230	188231
250	4,0	2.8	100	48	6/6,5/200	188238	188239
250	4,0	2.8	80	72	6/6,5/200	188236	188237
250	4,0	2.8	100	72	6/6,5/200	188240 \$	188241
[mm]	[mm]	[mm]	[mm]				

102320

Circular Saw Blades HW for Segment Hoggers „WS“

Product	Drawing	  tungsten carbide [HW] <hr/> MEC
		

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> double end tenoners edge trimming machines for sizing cuts in raw and laminated panels 	<ul style="list-style-type: none"> tooth configuration: ATB "WS" cutting material: HW HL Board 06 	<ul style="list-style-type: none"> optimum cutting quality and edge life 	<ul style="list-style-type: none"> with pin holes for LEUCO Segment Hoggers sense of rotation acc. to DIN-EN 50144

Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
355	4,4	3.0	80	72	6/5,5/300	189055	189054
[mm]	[mm]	[mm]	[mm]				

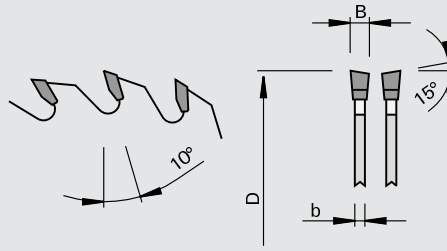
102328

Sizing Saw Blades HW - LowNoise for Segment Hoggers „WS“

Product



Drawing



LEUCO
topLine

LEUCO
DUR

tungsten carbide [HW]



Machine / Application

Design

I tooth configuration: ATB "WS"

Advantages

Notes

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

Ø D	B	b	Ø d	Z	NL	Ident-No.
300	3,2	2.2	60	48		188185 €
300	3,2	2.2	30	48	Combi2	189668
300	3,2	2.2	30	60	Combi2	189669
300	3,2	2.2	30	72	Combi2	192102 \$
300	3,2	2.2	30	96	Combi2	192103 \$
350	3,5	2.5	30	72	Combi2	189671
350	3,5	2.5	30	84	Combi2	192104
350	3,5	2.5	30	108	Combi2	192105
[mm]	[mm]	[mm]	[mm]			

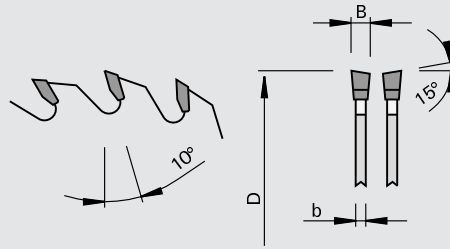
102320

Panel Sizing Saw Blades HW for Segment Hoggers „WS“

Product



Drawing



LEUCO
topline

UNI-CUT

tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

I tooth configuration: ATB "WS"

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

Ø D	B	b	Ø d	Z	Ident-No.
355	4,4	3.0	60	54	188504
355	4,4	3.0	30	72	188506
355 [mm]	4,4 [mm]	3.0 [mm]	60 [mm]	72	188507

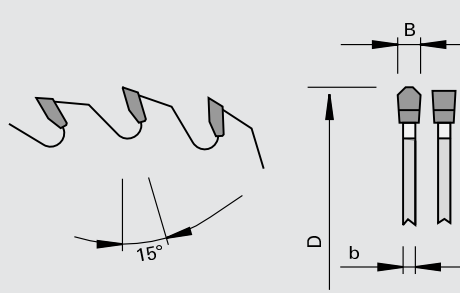
104370

Panel Sizing Saw Blades HW for Segment Hoggers „TR-F“

Product



Drawing

LEUCO
topLine

tungsten carbide [HW]

Machine / Application

Design

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

Advantages

Notes

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

Ø D	B	b	Ø d	Z	Ident-No.
305 [mm]	4,4 [mm]	2,8 [mm]	60 [mm]	60	192028

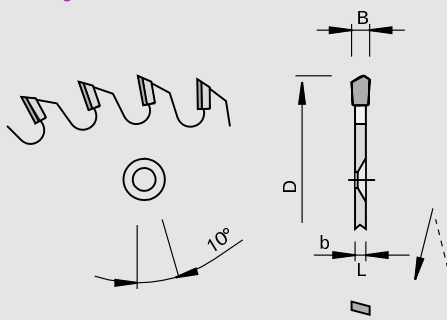
202062

Sizing Saw Blades DP for Segment Hoggers „ES-FA“

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages


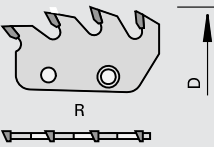
Notes

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

Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
200	4	2.8	80	24	15	25	170397 s	170398 s
200	4	2.8	80	28	17,5	30	170399 s	170400 s
200	4	2.8	80	32	20	32,5	170401 s	170402 s
200	4	2.8	80	36	22,5	35	170403 s	170404 s
200	4	2.8	80	40	25	40	170405 s	170406 s
200	4	2.8	80	44	27,5	45	170407 s	170408 s
200	4	2.8	80	48	30	50	170409 s	170410 s
250	4	2.8	80	24	15	25	170495 s	170496 s
250	4	2.8	80	30	20	32,5	170497 s	170498 s
250	4	2.8	80	36	25	40	170499 s	170500 s
250	4	2.8	80	42	27,5	45	170501 s	170502 s
250	4	2.8	80	48	30	50	170503 s	170504 s
250	4	2.8	80	54	35	55	170505 s	170506 s
250	4	2.8	80	60	40	60	170507 s	170508 s
250	4	2.8	80	66	45	65	170509 s	170510 s
250	4	2.8	80	72	50	70	170511 s	170512 s
250	4	2.8	100	24	15	25	170621 s	170622 s
250	4	2.8	100	30	20	32,5	170623 s	170624 s
250	4	2.8	100	36	25	40	170625	170626
250	4	2.8	100	42	27,5	45	170627 s	170628 s
250	4	2.8	100	48	30	50	170629	170630
250	4	2.8	100	54	35	55	170631 s	170632 s
250	4	2.8	100	60	40	60	170633 s	170634 s
250	4	2.8	100	66	45	65	170635 s	170636 s
250	4	2.8	100	72	50	70	170637 s	170638 s
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		


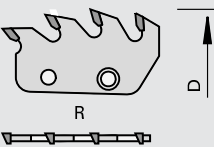
116200

Segments HW for Segment Hoggers - Circular Cut with shear angle

Product		Drawing		 tungsten carbide [HW]	
					
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<ul style="list-style-type: none"> the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle HW-tipped 	<ul style="list-style-type: none"> no end chipping when cutting along the grain 	<ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process 		
Ø D	Z		Ident-No. [L]	Ident-No. [R]	
200/250 [mm]	4	DZ	171395	171396	

116200

Segments HW for Segment Hoggers - Stepped Cut

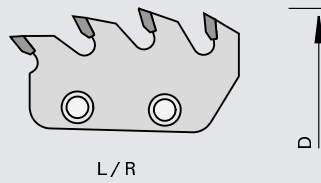
Product		Drawing		 tungsten carbide [HW]	
				MEC	
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<ul style="list-style-type: none"> Ident-No.177376 and 177377: the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle HW-tipped 	<ul style="list-style-type: none"> no end chipping when cutting across the grain 	<ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in HW and DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process 		
Ø D	Z		Ident-No. [L]	Ident-No. [R]	
200/250 [mm]	4	stepped cut	177374	177375	
	4	stepped cut	177376	177377	

116200

Segments HW for Segment Hoggers - Circular Cut

Product

Drawing



tungsten carbide [HW]

Machine / Application

| for complete hogging of the offal in wood-based panels

Design

| HW-tipped
| segments for both left-hand and right-hand use

Advantages

| no end chipping when cutting along the grain

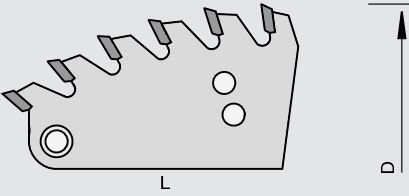

Notes

| for offal widths to 18 mm
| ready-to-use in HW Segment Hoggers Ø 200 mm and Ø 250 mm
| segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm / 6 HW segments for Ø 200 mm
| for scoring/hogging (RZ) and double hogging (DZ) process

Ø D	Z		Ident-No.
200/250	4	RZ	168680
200/250	4	DZ	167118
[mm]			

116100

Segments HW for Segment Hoggers - Stepped Cut

<p>Product</p>	<p>Drawing</p> 	 <p>tungsten carbide [HW]</p> <p>MEC</p>
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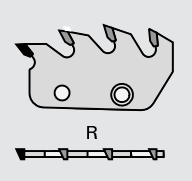

<p>Machine / Application</p> <ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> segments for both left-hand and right-hand use 	<p>Advantages</p> <ul style="list-style-type: none"> no end chipping when cutting along or across the grain thanks to stepped cut configuration 	<p>Notes</p> <ul style="list-style-type: none"> ready-to-use in HW Segment Hoggers Ø 250 mm (old design) / Ø 300 mm - Ø 430 mm segments must be installed in sets; one set consists of 4 HW segments for Ø 250 mm (old design) / 6 HW segments for Ø 300 - 430 mm for scoring/hogging (RZ) and double hogging (DZ) process segments can be used for circular cut and stepped cut configuration
--	---	---	---

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

[mm]

216200

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

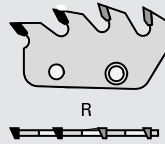
<p>Product</p>		<p>Drawing</p>  <p> LEUCODUR LEUCODIA </p>		 <p>polycrystalline diamond [DP]</p>	
<p>Machine / Application</p> <ul style="list-style-type: none"> for complete hogging of the offal in wood-based panels 	<p>Design</p> <ul style="list-style-type: none"> the first tooth is DP-tipped, the following teeth are HW-tipped the first tooth of the segment features a 10 degree bevel on the side of the tooth with shear angle 	<p>Advantages</p> <ul style="list-style-type: none"> no end chipping when cutting along the grain 	<p>Notes</p> <ul style="list-style-type: none"> for offal widths to 18 mm ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 250 mm for scoring/hogging (RZ) and double hogging (DZ) process 		
<p>Ø D</p>	<p>Z</p>		<p>Ident-No. [L]</p>	<p>Ident-No. [R]</p>	
<p>200/250 [mm]</p>	<p>1+3</p>		<p>172288</p>	<p>172289</p>	

216200

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

Product

Drawing

LEUCO
DIA

polycrystalline diamond [DP]

Machine / Application

for complete hogging of the offal in wood-based panels

Design

the first and second tooth are DP-tipped, the following teeth are HW-tipped
the first tooth of the segment features a 10 degree bevel on the side of the tooth
with shear angle

Advantages

no end chipping when cutting along the grain

Notes

for offal widths to 18 mm
ready-to-use in DP Segment Hoggers Ø 200 mm and Ø 250 mm
segments must be installed in sets; one set consists of 4 DP segments for Ø 250 mm / 6 DP segments for Ø 250 mm
for scoring/hogging (RZ) and double hogging (DZ) process

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

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	for attaching the segments	M8x12,5	995192 180010
Countersunk Flat Headed Screws		M5x12	995122 180007
Spacers		115x1,0x80,5	955520 009255
Head Cap Screws	for attaching the extension (18 and 36 mm)	M8x16	995111 180004
Head Cap Screws	for attaching the extension (54 mm)	M8x30	995111 180005
Head Cap Screws	for attaching the extension (72 mm)	M8x50	995111 180006
Cranked Wrench Keys		SW5 DIN ISO 2936	985730 009674
Screwdrivers	for hoggers	9,0 [mm]	985730 011088

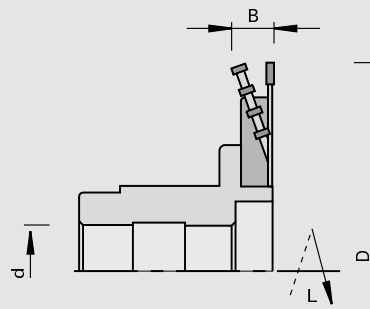
115421

Folding Segment Hoggers HW mounted on Bushing - Circular Cut „F“

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l folding machines
- l for cutting of V grooves and rabbets in laminated and veneered panels

Design

- l tooth configuration of the saw blade: flat "F"
- l RPM $n = 3,000 \text{ min}^{-1}$ and $n = 6,000 \text{ min}^{-1}$ depending on the machine

Advantages

Notes

- l application against feed
- l circular saw blade and segments have the same diameter
- l the opening angle of > 90 degrees must be determined per application
- l sense of rotation see drawing

H	Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
25,0	200	36	30	40	8 x 4 Lehbrink	017385 &	017384 &
12,5	200	18	30	40	4 x 4 Lehbrink	017390 &	017391 &
37,5	200	54	30	40	12 x 4 Lehbrink	017392 &	017393 &
12,5	200	18	35	40	4 x 4 Koch, Lehbrink	051210 &	051207 &
25,0	200	36	35	40	8 x 4 Koch, Lehbrink	051211 &	051208 &
37,5	200	54	35	40	12 x 4 Koch, Lehbrink	051212 &	051209 &
16,0	200	22	30	40	4 x 5 Lehbrink	162010 &	162011 &
16,0	200	22	35	40	4 x 5 Koch, Lehbrink	162012 &	162013 &
16,0	200	22	40	40	4 x 5 M+S	162608 &	162607 &
12,5	250	18	30	48	6 x 4 Lehbrink	164013 &	164014 &
25,0	250	36	30	48	12 x 4 Lehbrink	164015 &	164016 &
37,5	250	54	30	48	18 x 4 Lehbrink	164017 &	164018 &
12,5	250	18	35	48	6 x 4 Koch, Lehbrink	164019 &	164020 &
25,0	250	36	35	48	12 x 4 Koch, Lehbrink	164021 &	164022 &
37,5	250	54	35	48	18 x 4 Koch, Lehbrink	164023 &	164024 &
16,0	250	22	30	48	6 x 5 Lehbrink	164025 &	164026 &
16,0	250	22	35	48	6 x 5 Koch, Lehbrink	164027 &	164028 &
16,0	250	22	40	48	6 x 5 M+S	164029 &	164030 &
[mm]	[mm]	[mm]	[mm]				

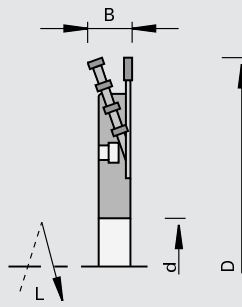
115621

Folding Segment Hoggers HW for LEUCO S-System Ø 192 - Circular Cut „F”

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- for folding systems Homag, Koch, Lehbrink
- for cutting of V grooves and rabbets in laminated and veneered panels

Design

- tooth configuration of the saw blade: flat "F"
- n max = 7,200 min-1

Advantages

Notes

- application against feed
- circular saw blade and segments have the same diameter
- the opening angle of > 90 degrees must be determined per application
- sense of rotation see drawing

H	Ø D	B	Ø d	Z	Z segments	Ident-No. [L]	Ident-No. [R]
12,5	250	18	80	48	6 x 4	161995 &	161996 &
16,0	250	22	80	48	6 x 5	162682 &	162683 &
[mm]	[mm]	[mm]	[mm]				

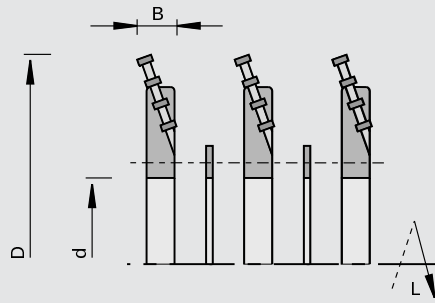
115401

Folding Segment Extensions HW - Circular Cut

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

for cutting of V grooves in thick panels

Design

HW-tipped

Advantages


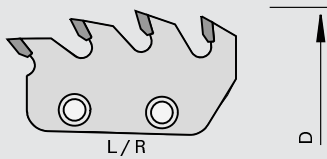
Notes

- | extendable to 54 mm
- | for subsequent extension of existing folding hoggers Ø 200 mm and Ø 250 mm
- | the diameters of existing folding hoggers and folding extensions must match
- | the extension assemblies consist of a body with installed HW segments, spacer and screws
- | sense of rotation see drawing

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
200	18 - 36	80	4 x 4	017395 &	017396 &
200	18 - 54	80	8 x 4	017397 &	017398 &
200	36 - 54	80	4 x 4	017399 &	017400 &
250	18 - 36	80	6 x 4	164007 &	164008 &
250	18 - 54	80	12 x 4	164009 &	164010 &
250	36 - 54	80	6 x 4	164011 &	164012 &
[mm]	[mm]	[mm]			


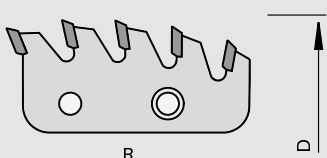
116210

Segments HW for Folding Segment Hogger

Product		Drawing		 tungsten carbide [HW] MEC	
					
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> for complete hogging of the offal during the V-groove cutting process 	<ul style="list-style-type: none"> HW-tipped 		<ul style="list-style-type: none"> ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions circular saw blade and segments must have the same diameter segments can be used for clockwise and counter-clockwise rotation 		
Ø D	Z		Ident-No.		
200	4		168757		
250	4		168760		
[mm]					

116210

Segments HW for Folding Segment Hogger

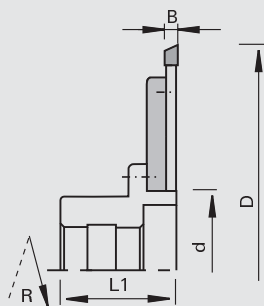
Product		Drawing		 tungsten carbide [HW] MEC	
					
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> for complete hogging of the offal during the V-groove cutting process 	<ul style="list-style-type: none"> HW-tipped 		<ul style="list-style-type: none"> ready-to-use in HW Folding Segment Hoggers Ø 200 mm and Ø 250 mm and for extensions circular saw blade and segments must have the same diameter 		
Ø D	Z		Ident-No. [L]	Ident-No. [R]	
200	5		168759	168758	
250	5		168761	168762	
[mm]					

115775

Saw Hoggers HW for finger jointing lines - Grecon

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

Advantages

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

Notes

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

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8	44	59	80	60	12x3,3	Grecon	182379 &	182378 &
300	8	44	59	80	60	12x3,3	Grecon	182603 &	182604 &
350	10	44	59	80	60+12	12x3,3	Grecon	182609 &	182610 &
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

Spare parts

Dimension

Class-No.

Ident-No. [L]

Ident-No. [R]

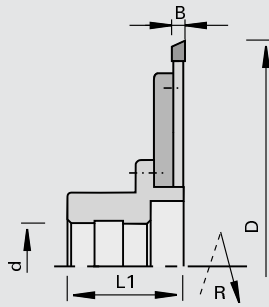
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	189223	189222
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102350	189244	189245
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	189246 #	189247 #
Flanges	Ø210x8,4xØ80	997370		182377
Countersunk Flat Headed Screws	M8x20 DIN 7991-8.8	995121		056378
Countersunk Flat Headed Screws	M5x12 T20	995125		166709
Screwdrivers	T20x100	985730		166092
Bushings for Grecon	Ø113x59x40DKN	997370		189100
Bushings for DIMTER	Ø206x100,3x38 DKN	997370		178294
	[mm]			

115775

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

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

Advantages

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

Notes

l sense of rotation acc. to DIN-EN 50144

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	8	44	59	40	60	12x3,3	Grecon	182599 ♂	182600 ♂
300	8	44	59	40	60	12x3,3	Grecon	182605 ♂	182606 ♂
350	10	44	59	40	60+12	12x3,3	Grecon	182611 ♂	182612 ♂
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

Spare parts

Dimension

Class-No.

Ident-No. [L]

Ident-No. [R]

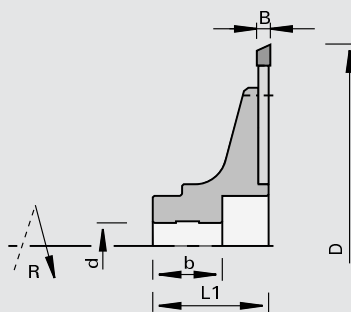
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102350	189033	189032
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	189223	189222
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102350	189244	189245
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	189246 #	189247 #
Flanges	Ø210x8,4xØ80	997370		182377
Countersunk Flat Headed Screws	M8x20 DIN 7991-8.8	995121		056378
Countersunk Flat Headed Screws	M5x12 T20	995125		166709
Screwdrivers	T20x100	985730		166092
Bushings for Grecon	Ø113x59x40DKN	997370		189100
Bushings for Grecon-Combipact	Ø250x8x40 [mm]	997370		178783

115775

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

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

Advantages

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

Notes

- l sense of rotation acc. to DIN-EN 50144

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

Spare parts

Dimension

Class-No.

Ident-No. [L]

Ident-No. [R]

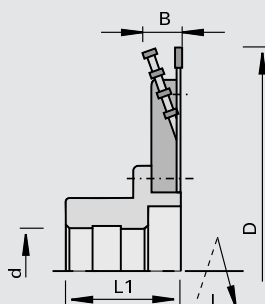
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102350	189223	189222
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102350	189244	189245
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102350	189246 #	189247 #
Countersunk Flat Headed Screws	M5x12 T20	995125		166709
Screwdrivers	T20x100	985730		166092
Bushings for DIMTER	Ø206x100,3x38 DKN [mm]	997370		178294

115775

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

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

Advantages

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

Notes

- l sense of rotation see drawing

Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	16,3	44	59	40	48+(6x4)	12x3,3	Grecon	189097 &	189096 &
[mm]	[mm]	[mm]	[mm]	[mm]			[mm]		

Spare parts	Dimension	Class-No.	Ident-No. [L]	Ident-No. [R]
Hogger Saw Blade	Ø250x4,0/2,8xØ120 Z48	102312	189092	189093
HW segments	Ø250 Z=4	116200	189094	189094
Bushings for Grecon	Ø113x59x40DKN	997370		189100
Countersunk Flat Headed Screws	M6x10	995190		699437
Countersunk Flat Headed Screws	M5x10 DIN EN ISO 2009	995122		055881
Head Cap Screws	M8x16 DIN912	995111		001891
Screwdrivers	SW4x100	985730		166091
Screwdrivers	8	985730		053874
	[mm]			

105320

Scoring Saw Blades HW „WS“ - for finger joint machines

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

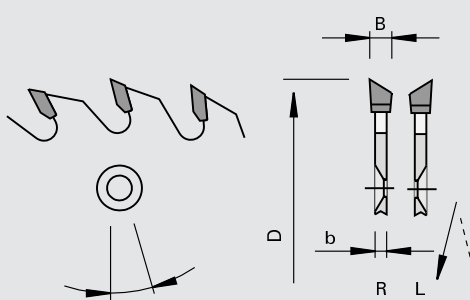
105350

Scoring Saw Blades HW „ES“ - for finger joint machines

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

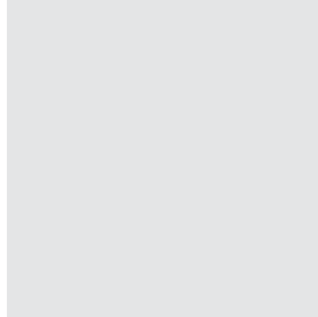
- l along and across the grain, from above and below
- l sense of rotation see drawing

Ø D	B	b	Ø d	Z	NL	Hook angle	Corner∠		Ident-No. [L]	Ident-No. [R]
200	5,1	3,5	75	48	6/7/95	10	25	Grecon-Combipact	188947	188948
200	4,7	3,4	75	64	6/6,6/95	10	30	Grecon HS 120	189034	189035
200	6,0	4,0	75	48	6/6,5/95	10	5	Grecon	189540	
[mm]	[mm]	[mm]	[mm]			[°]	[°]			

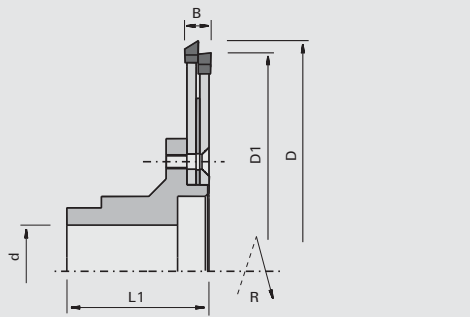
105355

Scoring Saw Blade Set HW „ES“ - for finger joint machines

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

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

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

Spare parts

Dimension

Class-No.

Ident-No.

Scoring Saw Blades	Ø200x6,0/4,0xØ75 Z48	105350	189537
Scoring Saw Blades	Ø190x6,0/4,0xØ75 Z48	105350	189538
Bushings for Grecon	Ø115x61xØ40DKN	997370	189543
Spacers	Ø150x1,5xØ75	955520	189542
Countersunk Flat Headed Screws	M6x20 DIN 7991-8.8	995121	183114
Screwdrivers	SW4x100	985730	166091
	[mm]		

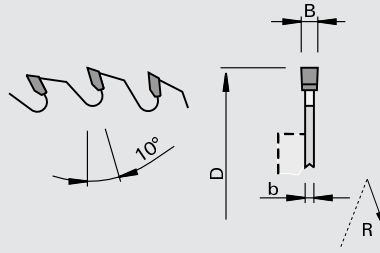
105311

Scoring Saw Blades HW „F“ - for hoggers and flange

Product



Drawing



LEUCO
topLine

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

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

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

Complete sets with flange

Ø D

Z

Class-No.

Ident-No. [L]

Ident-No. [R]

180	36	Homag, Brandt, IMA	105011	160656 &	160655 &
180	48	Homag, Brandt, IMA	105011	161274 &	161273 &
180	54	Homag, Brandt, IMA	105011	161272 &	161271 &
[mm]					

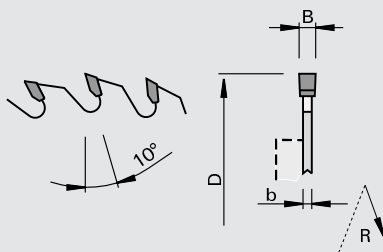
105311

Scoring Saw Blades HW „F“ - for hogsers and flange 160849

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

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

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

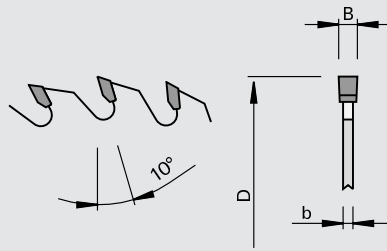
105311

Scoring Saw Blades HW „F“ - for hoggers

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

l application with feed

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

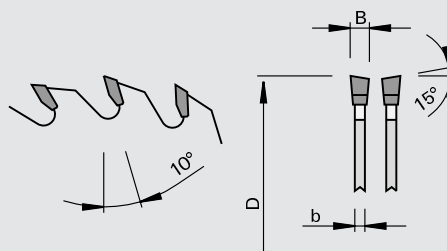
105320

Scoring Saw Blades HW „WS“ - for hoggers

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

l application with feed

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

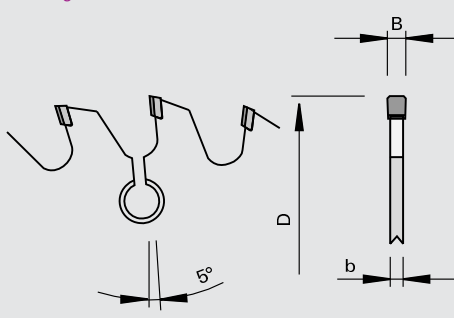
205241

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

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

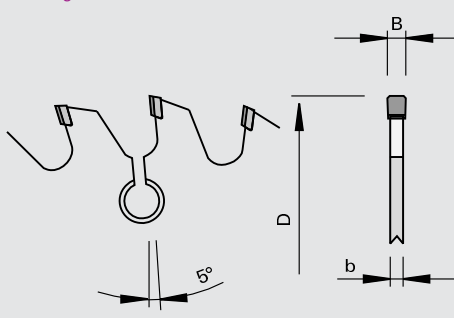
205241

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

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

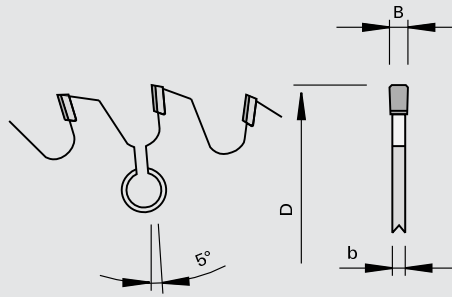
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	24	6/6,5/90	20	173714
180	3,2	2.2	65	32	6/6,5/90	30	173722
[mm]	[mm]	[mm]	[mm]			[m/min]	

205041

Scoring Saw Blades DP „F-FA“ - for hoggers

Product

Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- | long edge lives

Notes

- | application with feed
- | the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No.
150	3,2	2.2	55	28	25	169322 s
180	3,2	2.2	30	48	50	169338 s
180	3,2	2.2	30	44	45	169335 s
180	3,2	2.2	30	40	40	169332 s
180	3,2	2.2	30	36	35	169329 s
180	3,2	2.2	30	32	30	169327 s
180	3,2	2.2	30	28	25	169326 s
180	3,2	2.2	30	24	20	169325 s
150	3,2	2.2	55	32	30	169323 s
150	3,2	2.2	55	24	20	169321 s
200	3,2	2.2	30	24	20	169341 s
150	3,2	2.2	60	36	35	170173 s
150	3,2	2.2	55	36	35	169324 s
150	3,2	2.2	60	28	25	170171 s
150	3,2	2.2	60	32	30	170172 s
200	3,2	2.2	30	28	25	169343 s
150	3,2	2.2	60	24	20	170170 s
200	3,2	2.2	30	48	50	169353 s
200	3,2	2.2	30	44	45	169351 s
200	3,2	2.2	30	40	40	169349 s
200	3,2	2.2	30	36	35	169347 s
200	3,2	2.2	30	32	30	169345 s
[mm]	[mm]	[mm]	[mm]		[m/min]	

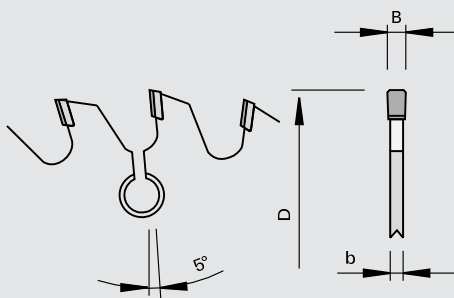
205041

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

Product



Drawing



LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- | long edge lives

Notes

- | application with feed
- | the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$
- | for flange Ident-No. 160849 for LEUCO S-System

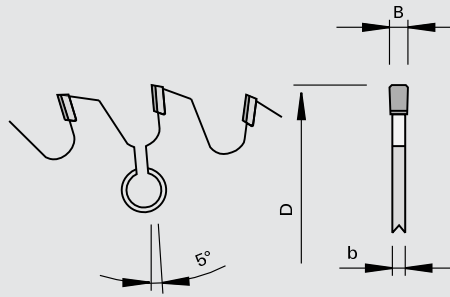
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	50	24	3/22/80	20	168905 s
180	3,2	2.2	50	28	3/22/80	25	168907 s
180	3,2	2.2	50	32	3/22/80	30	168909 s
180	3,2	2.2	50	36	3/22/80	35	169330 s
180	3,2	2.2	50	40	3/22/80	40	169333 s
180	3,2	2.2	50	44	3/22/80	45	169336 s
180	3,2	2.2	50	48	3/22/80	50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

205041

Scoring Saw Blades DP „F-FA“ - for hoggers and flange 006480

Product

Drawing



LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- | long edge lives

Notes

- | application with feed
- | the specified feed rates are based on $n = 6,000 \text{ min}^{-1}$
- | for flange Ident-No. 006480 for Homag, Brandt, IMA for LEUCO S-System

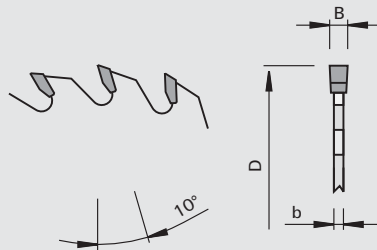
Ø D	B	b	Ø d	Z	NL	Recommended feed	Ident-No.
180	3,2	2.2	65	24	6/5,5/90	20	168906
180	3,2	2.2	65	28	6/5,5/90	25	168908 s
180	3,2	2.2	65	32	6/6,5/90	30	169328 s
180	3,2	2.2	65	36	6/5,5/90	35	169331 s
180	3,2	2.2	65	40	6/6,5/90	40	169334 s
180	3,2	2.2	65	44	6/5,5/90	45	169337 s
180	3,2	2.2	65	48	6/6,5/90	50	169340 s
[mm]	[mm]	[mm]	[mm]			[m/min]	

102312

Sizing Saw Blades HW „F“ - for hoggers

Product

Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

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

Design

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


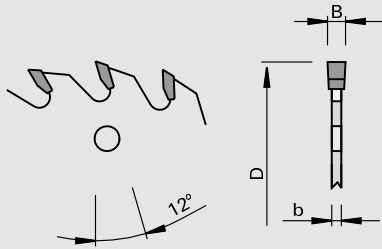


Advantages

Notes

Ø D	B	b	Ø d	Z	Tooth geometry	Ident-No.
250	4,0	2.8	80	54	flat without cut out	188248
250	4,0	2.8	80	78	flat without cut out	188249
255	4,0	2.8	60	60	flat without cut out	188251
255	4,0	2.8	80	60	flat without cut out	188253 &
[mm]	[mm]	[mm]	[mm]			

102312


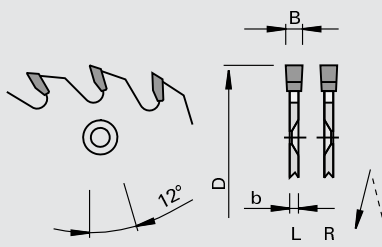


Sizing Saw Blades HW „F“ - for high-tech hoggers

Product 	Drawing 	  tungsten carbide [HW] MEC
---	---	--

Machine / Application	Design	Advantages	Notes				
<ul style="list-style-type: none"> double end tenoners for sizing cuts in raw and laminated panels 	<ul style="list-style-type: none"> tooth configuration: flat "F" cutting material: HW HL Board 06 						
Ø D	B	b	Ø d	Z	NL	Tooth geometry	Ident-No.
250	4,0	2,8	100	72	6/6,5/172	flat with 6 cut out	188245
[mm]	[mm]	[mm]	[mm]				

102312

Sizing Saw Blades HW for TwinTec Hoggers „F“

Product 	Drawing 	  tungsten carbide [HW] MEC
---	---	--

Machine / Application	Design	Advantages	Notes				
<ul style="list-style-type: none"> double end tenoners edge trimming machines for sizing cuts in laminated and raw panels 	<ul style="list-style-type: none"> tooth configuration: flat "F" cutting material: HW HL Board 06 		sense of rotation see drawing				
Ø D	B	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
220	4,0	2,8	80	48	6/6/154	169820	169819
220	4,0	2,8	80	60	6/6/154	169818	169817
[mm]	[mm]	[mm]	[mm]				

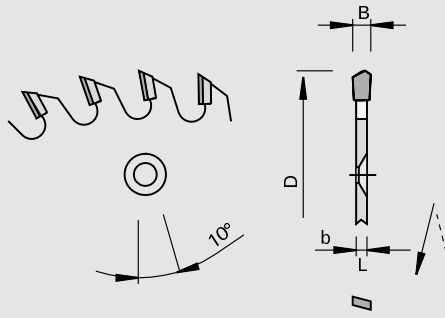
202062

Circular Saw Blades DP for TwinTec Hoggers „ES-FA“

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

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

Advantages

- decreased downtimes thanks to long edge lives

Notes

- application with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- for combination with LEUCO TwinTec hoggers
- the specified feed rates are based on n = 6,000 min-1
- sense of rotation see drawing

Ø D	B	b	Ø d	Z	Feed RZ	Feed DZ	Ident-No. [L]	Ident-No. [R]
220	4	2.8	80	24	15	25	171353 s	171354 s
220	4	2.8	80	30	20	32,5	171355 s	171356 s
220	4	2.8	80	36	25	40	171357	171358
220	4	2.8	80	42	27,5	45	171359 s	171360 s
220	4	2.8	80	48	30	50	171361 s	171362 s
220	4	2.8	80	54	35	55	171363 s	171364 s
220	4	2.8	80	60	40	60	171365	171366 s
[mm]	[mm]	[mm]	[mm]		[m/min]	[m/min]		

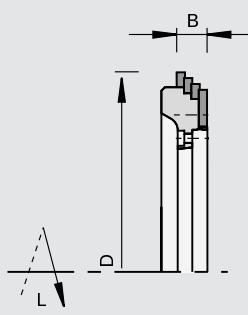
115205

Hogger Rings HW for TwinTec Hoggers

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- for chip-free sizing during the cross-cutting process

Design

- hogger teeth positioned in a stepped cut configuration
- segments Z= 1 solid tungsten carbide with shear angle

Advantages

Notes

- sense of rotation see drawing

Ø D	B	Z	Ident-No. [L]	Ident-No. [R]
239	18,4	4x6	172304 s	172303 s
[mm]	[mm]			

Spare parts



Dimension

Class-No.



Ident-No.

Screwdrivers	T20x100	985730	166092
Head Cap Screws	M5x12 T20 [mm]	995115	171237

150501 segments VHW for TwinTec hogger

Product		Drawing		 Solid Tungsten Carbide			
							
Machine / Application		Design		Advantages		Notes	
for use in TwinTec Hogger Ring		Z = 1 VHW with shear angle				one set consists of 6 segments completely tipped for circular cut: 12 segments / stepped cut: 24 segments	
						Ident-No. [L]	Ident-No. [R]
						171232	171233
Spare parts		Dimension		Class-No.		Ident-No.	
Countersunk Flat Headed Screws		M5x13,5 T20		995125		171238	
Screwdrivers		T20x100 [mm]		985730		166092	

232921 Segments for TwinTec Hogger DP-tipped

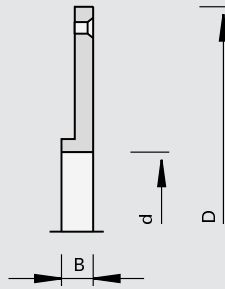
Product		Drawing		 polycrystalline diamond [DP]			
							
Machine / Application		Design		Advantages		Notes	
for use in TwinTec Hogger Ring		Z = 1 DP-tipped with shear angle				one set consists of 6 segments completely tipped for circular cut: 12 segments / stepped cut: 24 segments	
						Ident-No. [L]	Ident-No. [R]
						171234	171235
Spare parts		Dimension		Class-No.		Ident-No.	
Countersunk Flat Headed Screws		M5x13,5 T20		995125		171238	
Screwdrivers		T20x100 [mm]		985730		166092	

997300

Hogger Flanges for TwinTec Hoggers

Product

Drawing



Machine / Application

Design

Advantages

Notes

for attaching the hogger saw blades

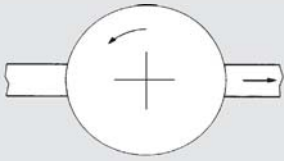
during the double hogging process the saw is attached to the flange by screws
included in delivery: flange, countersunk screws M5x16 mm

Ø D	B	Ø d	Ident-No.
170	12	60	171367 s
[mm]	[mm]	[mm]	

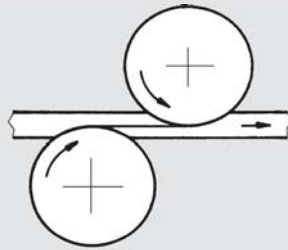
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for attaching the saw blade without flange	M5x10 T20	995125	171236
Countersunk Flat Headed Screws for attaching the flange	M5x16 T20	995125	164839
Screwdrivers	T20x100	985730	166092
	[mm]		

Application example

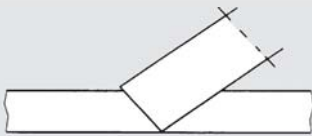
Hogging



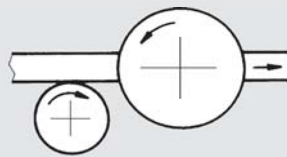
Double hogging



Folding Hogging



Scoring / Hogging



Order / Inquiry for Special Tools: Hoggers

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

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

Machine

Make: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Flange diameter [mm]: _____

Motor output (hogger motor) [kW]: _____

Cutting diameter D [mm] _____

Hogging width [mm]: _____

No. of teeth [pcs.]: _____

Circular Saw Blade
No. x no. of segment teeth

Sense of rotation Right Left

Mode of application:

Hogger: Against feed:

With feed:

Mode of application: Hogging

Scoring / Hogging

Double hogging

Interface

Bushing: _____

Double keyway	Width	Height
Keyway	Width	Height

Workpiece

Description: _____

Material thickness [mm]: _____

Hogging width [mm]: _____

Cutting quality: Rough hogging

Finish hogging

Folding

Circular cut

Stepped cut

Direction of cut: With grain

(Solid wood) Across grain

Yes No

Hydro Bushing: _____

Hydro-S-System: _____

S-System: _____

Other: _____

Cutting material

Circular Saw Blade	Carbide	<input type="radio"/>
	Diamond	<input type="radio"/>
Segments:	Carbide	<input type="radio"/>
	Diamond	<input type="radio"/>

Check if applicable

Coating

Description: _____

Further Information _____

Tool drawing: _____

Tool

Compact Hoggers

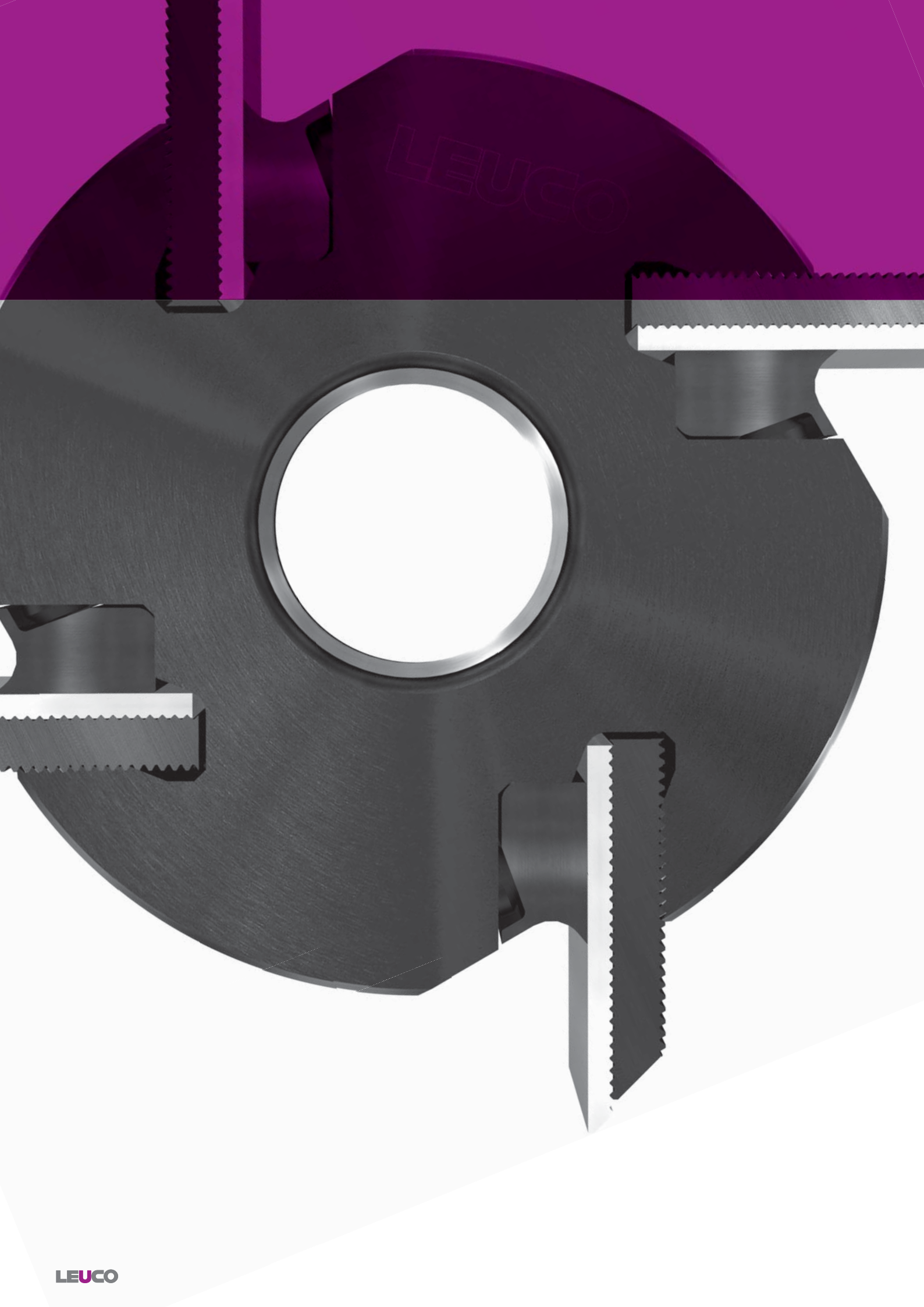
Segment Hoggers

TwinTec Hoggers

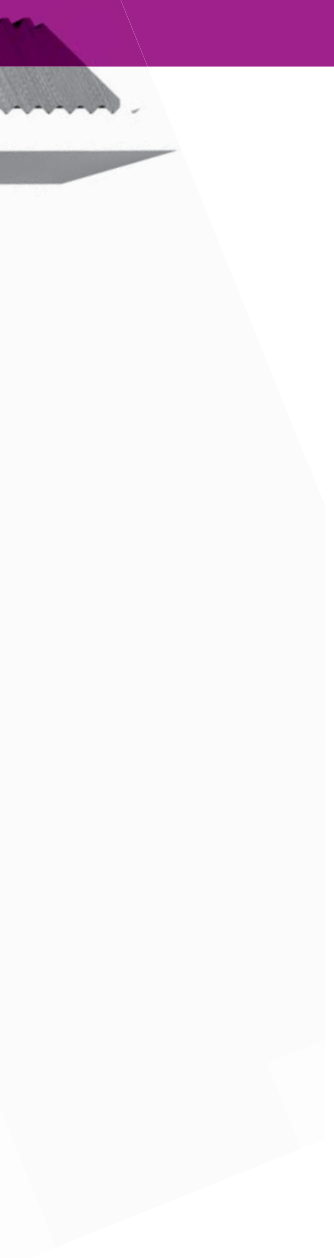
Radius hogger

Other:

517-01.0708



Cutters with Bore



Product	Page
Edge trimming	3-1
Postforming	3-55
Grooving	3-60
Jointing/Rabbeting/Chamfering/Rounding	3-73
Profiling	3-91
Groove bed	3-101
Planing	3-103
Jointing	3-117
Technical Information	3-129

122110

Edge Jointing Cutters two-part version - IMA (BIMA)

Product		Drawing								
<p>Machine / Application</p> <ul style="list-style-type: none"> edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135 for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<p>Design</p> <ul style="list-style-type: none"> cutting edges parallel to cutter axis two part version countersunk on both sides n max = 18,000 min-1 			<p>Advantages</p>		<p>Notes</p> <ul style="list-style-type: none"> sense of rotation see drawing 			
<p>Ø D</p> <p>70</p> <p>[mm]</p>	<p>B</p> <p>6</p> <p>[mm]</p>	<p>b</p> <p>6</p> <p>[mm]</p>	<p>Ø d</p> <p>30</p> <p>[mm]</p>	<p>Z</p> <p>6</p>	<p>IMA (BIMA)</p>	<p>Ident-No. [L]</p> <p>716658 s</p>	<p>Ident-No. [R]</p> <p>716657 s</p>			

122110

Edge Jointing Cutters HW

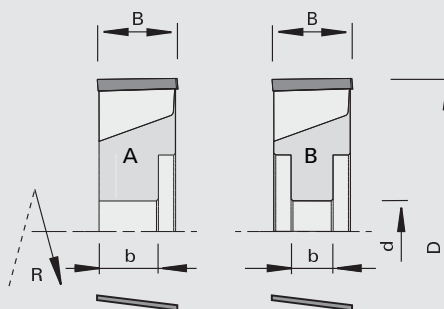
Product		Drawing								
<p>Machine / Application</p> <ul style="list-style-type: none"> edge banding machines for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<p>Design</p> <ul style="list-style-type: none"> with shear angle n max = 18,000 min-1 			<p>Advantages</p>		<p>Notes</p> <ul style="list-style-type: none"> sense of rotation according to DIN-EN 50144 			
<p>Ø D</p> <p>70</p> <p>100</p> <p>[mm]</p>	<p>B</p> <p>25</p> <p>25</p> <p>[mm]</p>	<p>b</p> <p>10.5</p> <p>15</p> <p>[mm]</p>	<p>Ø d</p> <p>16</p> <p>30</p> <p>[mm]</p>	<p>Z</p> <p>4</p> <p>4</p>	<p>DKN</p> <p>5x2,3</p> <p>[mm]</p>	<p>Shear<</p> <p>10</p> <p>15</p> <p>[°]</p>	<p>Homag</p>	<p>Ident-No. [L]</p> <p>180796</p> <p>160647 s</p>	<p>Ident-No. [R]</p> <p>180795</p> <p>160109 s</p>	

122112

Edge Jointing Cutters HW - SCM-Stefani

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
SCM-Stefani with ED-System
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle
n max = 18,000 min⁻¹

Advantages

Notes

sense of rotation according to
DIN-EN 50144

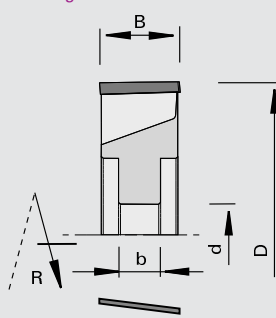
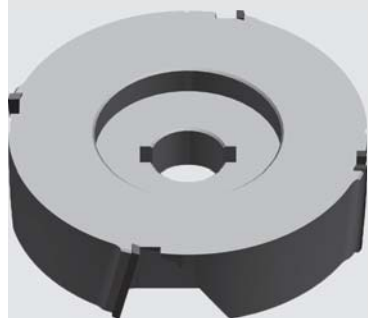
Ø D	B	b	Ø d	Z	DKN	Shear∠	Type		Ident-No. [L]	Ident-No. [R]
70	10	14.5	16	4	5x2,3	12	A	SCM-Stefani-RSK	182987 s	182988 s
70	20	14.5	16	4	5x2,3	12	A	SCM-Stefani-RSK	182985	182986
75	20	10.5	16	4	5x2,3	12	A	SCM-Stefani-RSP	182989 s	182990 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				
Ø D	B	b	Ø d	Z	DKN	Shear∠	Type		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	B	SCM-Stefani-RSP	182991	182992
80	20	11	16	4	5x2,3	12	B	SCM-Stefani-R	182617	182618
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

222210

DIAMAX Edge Jointing Cutters DP - SCM-Stefani

Product

Drawing

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
SCM-Stefani with ED-System
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

with shear angle
reduced resharpenable area
n max = 23,800 min⁻¹

Advantages

Notes

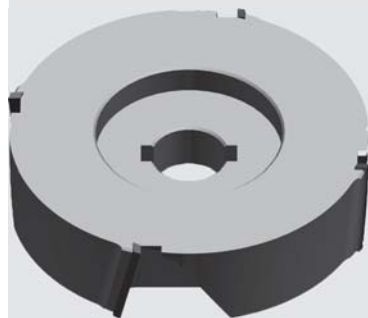
sense of rotation according to
DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear∠	Type		Ident-No. [L]	Ident-No. [R]
80	20	11	16	4	5x2,3	12	SCM-Stefani		182976 s	182975 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]				

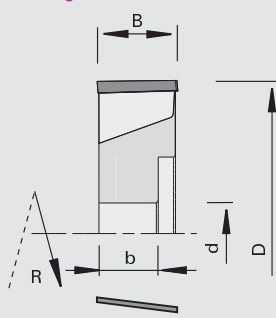
222510

DIAMAX Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines SCM Stefani with ED-System
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

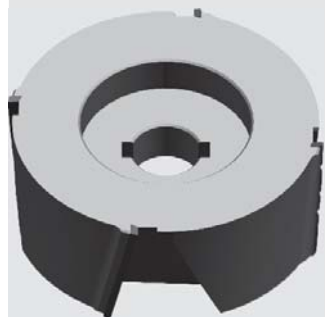
sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear<		Ident-No. [L]	Ident-No. [R]
70	10	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182979 s	182980 s
70	20	14.5	16	4	5x2,3	12	SCM-Stefani-RSK	182977 s	182978 s
75	20	10.5	16	4	5x2,3	12	SCM-Stefani-RSP	182981 s	182982 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

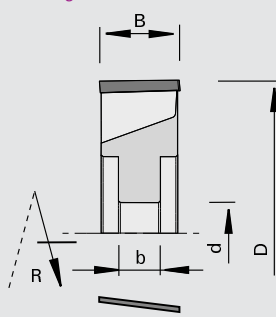
222510

Edge Jointing Cutters CM DP - SCM-Stefani

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines SCM Stefani with ED-System
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear<		Ident-No. [L]	Ident-No. [R]
75	30	11	16	4	5x2,3	12	SCM-Stefani-RSP	182983 s	182984 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

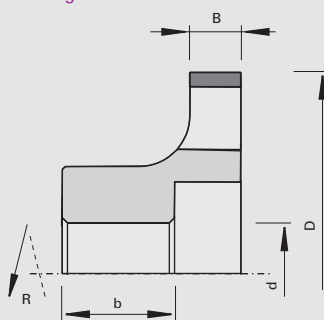
222510

DIAMAX Edge Jointing Cutters DP - Biesse

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Biesse RS 10
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

polished face and high-finish clearance angle
reduced resharpening area
 $n_{max} = 23,800 \text{ min}^{-1}$

Advantages

optimum cutting quality

Notes

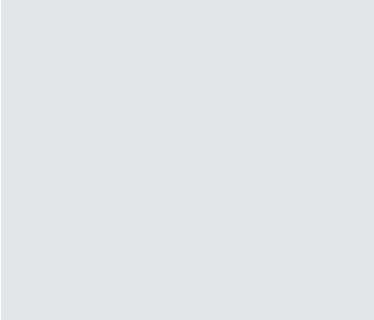
sense of rotation according to DIN-EN 50144

$\varnothing D$	B	b	$\varnothing d$	Z	DKN	Ident-No. [L]	Ident-No. [R]
80	10	35	20	6	6x2,8	183717 s	183718 s
[mm]	[mm]	[mm]	[mm]		[mm]		

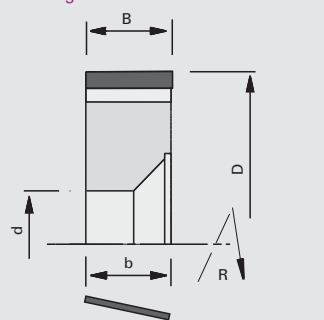
122110

Edge Jointing Cutters CM HW - HOLZ-HER

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines HOLZ-HER
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle

Advantages

optimized chip removal thanks to ChipMeister version
less chips remain inside of the machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

sense of rotation according to DIN-EN 50144

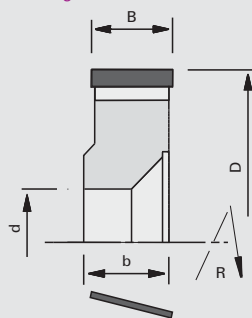
$\varnothing D$	B	b	$\varnothing d$	Z	DKN	Shear \angle	n_{max}	Ident-No. [L]	Ident-No. [R]	
50	18	17	20	2	5x2,2	10	24000	HOLZ-HER-1828	183113 s	183112 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min ⁻¹]			

122110

Edge Jointing Cutter CM HW- HOLZ-HER 1828 - AirStream-System

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1828
for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
AirStream-System
ChipMeister

Advantages

improved chip removal thanks to ChipMeister version and AirStream-System
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
low noise level

Notes

sense of rotation according to DIN-EN 50144

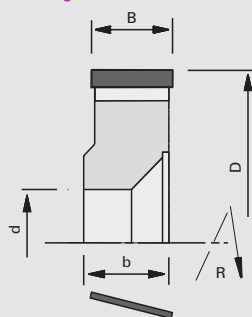
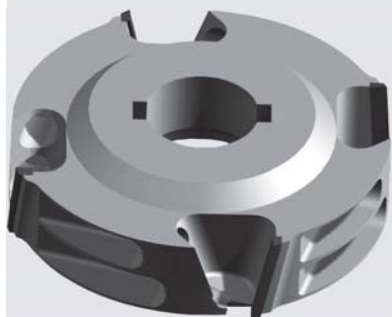
Ø D	B	b	Ø d	Z	DKN	Shear∠	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,3	10	18000	HOLZ-HER-1828	184747	184746
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

222810

Edge Jointing Cutter CM DP - HOLZ-HER 1826 - AirStream-System

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1826
for for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
Air-Stream-System
ChipMeister
n max = 18,000 min-1

Advantages

improved chip removal thanks to ChipMeister version and AirStream-System
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
low noise level

Notes

sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Shear∠	nmax		Ident-No. [L]	Ident-No. [R]
70	18	19	20	4	5x2,2	12	18000	HOLZ-HER 1826	184749 s	184748 s
70	19	20	20	4	5x2,2	12	18000	HOLZ-HER 1826	184751 s	184750 s
[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]			

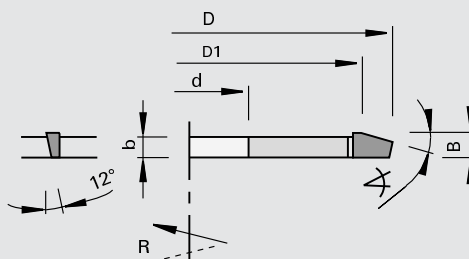
122115

Edge Jointing Cutters HW - Brandt

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

edge banding machines
for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
n = 8,100 - 13,800 min-1

Advantages

Notes

sense of rotation according to DIN-EN 50144

Chamfer	∅ D1	∅ D	B	b	∅ d	Z	Shear		Ident-No. [L]	Ident-No. [R]
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]			
15	60	66	4	3	16	6	12	Brandt	819482 s	819481 s
16		96	5,8	5	40	12	12	Brandt	164658 s	164657 s

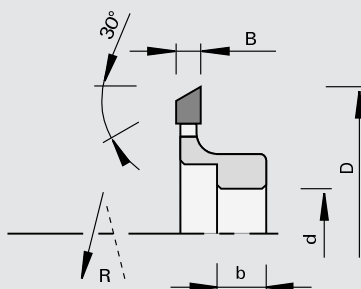
122100

Edge Jointing Cutters HW - IMA

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

cutting edges parallel to cutter axis
n max = 18,000 min-1

Advantages

Notes

sense of rotation see drawing

∅ D	B	b	∅ d	Z	DKN		Ident-No. [L]	Ident-No. [R]
[mm]	[mm]	[mm]	[mm]		[mm]			
73	6	12	20	12	6x3,5	IMA	171240	171239

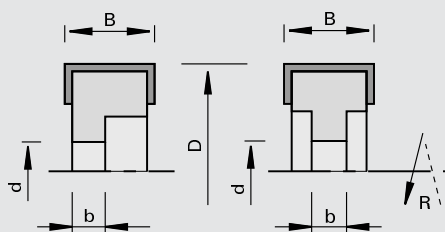
120100

Edge Jointing Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min⁻¹

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
50	12	10	16	4	5x2,3	Sudhoff, EBM, Ney		167258
50	12	10	16	2	5x2,3	Homag, Homburg		164066
50	15	10	16	4	5x2,3	EBM		179139
50	15	10	16	2	5x2,3	IMA, Raimann		164067
61	12	10	16	3	5x2,3	Homag		167899 s
61	20	11	16	3	5x2,3	Homag		167900 s
70	12	10	16	6	5x2,3	Brandt, Homag		164073
70	12	10	16	4	5x2,3	Brandt, Homag		164068
70	20	11	16	2	5x2,3	Reich		182077 s
70	20	11	16	4	5x2,3	Homag, Homburg, Biesse Akron 400 RS 502		164071
70	20	20	16	4	5x2,3	Ott		164069
70	20	12.5	20	6	2/6x3,5	IMA, SCM-IDM	164134 s	164080 s
70	20	12.5	20	4	6x3,5	Brandt, Homag	164133 s	164079 s
70	20	11	20	4	6x3,5	HOLZ-HER		164070 s
80	40	25	30	4	8x3,3	HOLZ-HER		164072
[mm]	[mm]	[mm]	[mm]		[mm]			

Turnover Knives

	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	15	12	1.5	150515	003081
	20	12	1.5	150515	003082
	40	12	1.5	150515	164078
	[mm]	[mm]	[mm]		

Spare parts

	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=10	164066, 164067, 164068, 164073, 167258, 167899, 179139	925300	164526
Clamping Bars	B=18	164069, 164070, 164071, 164079, 164080, 164133, 164134, 167900, 182077	925300	164076
Clamping Bars	B=39	164072	925300	164077
Set Screws	M6x10 DIN EN ISO 4028	164066, 164067, 164068, 164073, 167258, 167899, 179139	995161	180002
Set Screws	M6x12 DIN EN ISO 4028	164069, 164070, 164071, 164072, 164079, 164080, 164133, 164134, 167900, 182077	995161	180214
Screwdrivers	SW3x100		985730	166090
Cranked Wrench Keys	SW3 DIN ISO 2936 [mm]		985730	009672

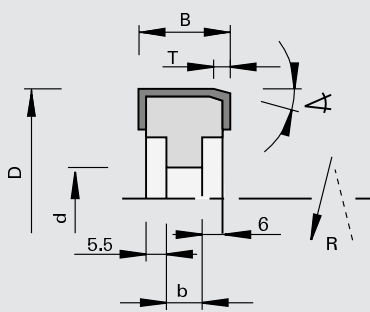
120100

Edge Jointing Cutterheads HW - HOLZ-HER

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
HOLZ-HER
for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

cutting edges parallel to cutter
axis
cutting material: HW HL Board
06
n max = 18,000 min-1

Advantages

Notes

sense of rotation according to
DIN-EN 50144

Chamfer \sphericalangle	$\varnothing D$	B	b	$\varnothing d$	T	Z		Ident-No. [L]	Ident-No. [R]
15 [°]	70 [mm]	29,5 [mm]	17 [mm]	20 [mm]	5 [mm]	4	HOLZ-HER	164462	164463

Turnover Knives	B	H	S	Class-No.	Ident-No.
for counter-clockwise rotation	29,5	12	1.5	150515	160618
for clockwise rotation	29,5	12	1.5	150515	160118
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=30	925300	164185
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100 [mm]	985730	166090

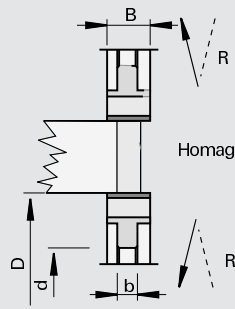
120101

Edge Jointing Cutterheads HW - Homag

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN		Ident-No.
70	14,3	10	16	4	5x2,3	Homag	170247
70	20	10	16	4	5x2,3	Homag	168510 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	14,3	14,3	2,5	150518	170248
	20	14,3	2,5	150518	168509
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersink Screws	M5x10,8 T15	995125	180840
Screwdrivers	T15x100	985730	180470
	[mm]		

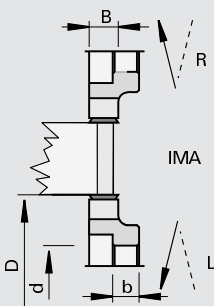
120101

Edge Jointing Cutterheads HW - IMA

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70 [mm]	14,3 [mm]	13 [mm]	20 [mm]	4	6x3,5 [mm]	IMA	172717 s 172718 s

Turnover Knives

B

H

S

Class-No.

Ident-No.

14,3

14,3

2,5

150518

170248

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Countersink Screws

M5x10,8 T15

995125

180840

Screwdrivers

T15x100

985730

180470

[mm]

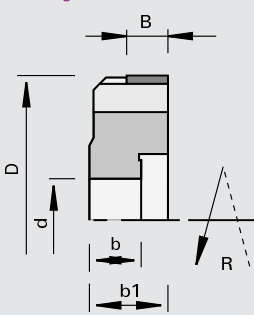
222510

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, SCM-IDM, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l polished face and high-finish clearance angle
l reduced resharpenable area
l straight cutter axis
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	b1	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70 [mm]	10 [mm]	12,5 [mm]	19 [mm]	20 [mm]	4	6x3,5 [mm]	175787 s	175786 s
70 [mm]	10 [mm]	12,5 [mm]	19 [mm]	20 [mm]	6	6x3,5 [mm]	175789 s	175788 s

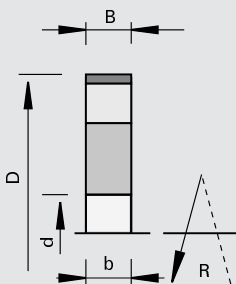
222510

DIAMAX Edge Jointing Cutters DP - Brandt, Homag, Biesse

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Biesse Akron 400 RS 502
- for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

- polished face and high-finish clearance angle
- reduced resharpening area 2.0 mm
- straight cutter axis
- n max = 24,000 min⁻¹

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

Ø D	B	b	Ø d	Z	DKN	Ident-No.
70	10	10	16	4	5x2,3	175779
70	10	10	16	6	5x2,3	175780
[mm]	[mm]	[mm]	[mm]		[mm]	

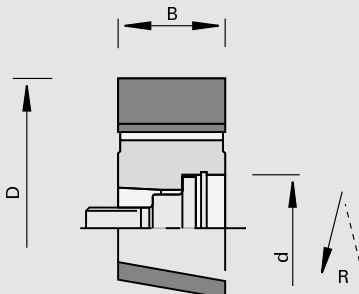
122110

Edge Jointing Cutters HW HSK 25R - Homag, IMA

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- edge banding machines
- Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min⁻¹

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	25	HSK 25R	4	177590 #	177589 #
70	35	HSK 25R	4	178035 s	178034 s
[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

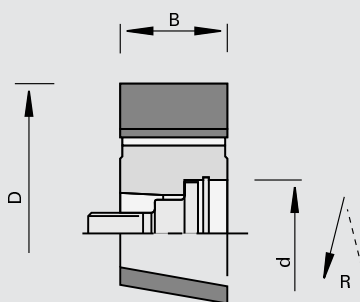
122110

Edge Jointing Cutters CM HW HSK 25R - Homag

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- edge banding machines
Homag
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- $n \text{ max} = 24,000 \text{ min}^{-1}$

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- sense of rotation according to DIN-EN 50144

$\emptyset D$	B	$\emptyset d$	Z	Ident-No. [L]	Ident-No. [R]
70 [mm]	25 [mm]	HSK 25R [mm]	4	180765	180766

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

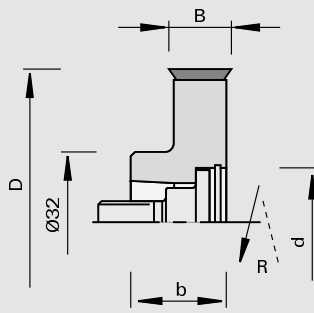
120101

Edge Jointing Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- edge banding machines Homag, IMA
- for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis, with 4 cutting edges
- cutting material: HW HL Solid 15
- n max = 18,000 min-1

Advantages

- excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	14,3	23	HSK 25R	4	177592	177591
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
	14,3	14,3	2,5	150518	170248
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersink Screws	M5x10,8 T15	995125	180840
Screwdrivers	T15x100	985730	180470
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

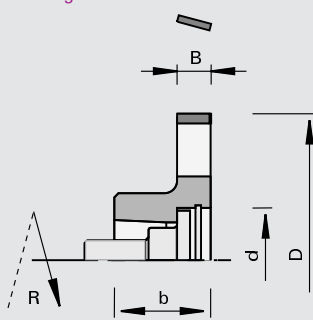
222510

DIAMAX-Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag, IMA
for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

polished face and high-finish clearance angle
with shear angle
n max = 24,000 min⁻¹

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing
low purchase price thanks to large-scale manufacturing

Notes

not resharpenable because constant (zero) diameter must be maintained
sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	8	23	HSK 25R	4	177651	177652
70	15	23	HSK 25R	4	177653	177654
70	8	23	HSK 25R	6	180492	180493
70	15	23	HSK 25R	6	180494 s	180495 s
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

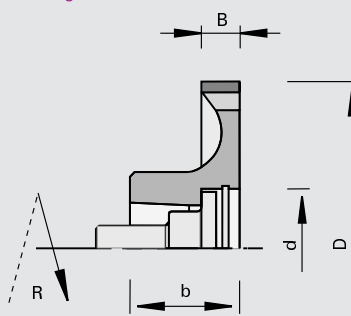
222812

Edge Jointing Cutters DP HSK 25R - Homag, IMA

Product



Drawing



LEUCO
topline

LEUCO
iQsystem

polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines Homag, aggregate FF and finish milling, IMA
- | for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

- | polished face and high-finish clearance angle
- | with shear angle

Advantages

- | highest concentricity
- | optimized chip removal thanks to internal chip evacuation
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | noise reduced
- | low purchase price thanks to large-scale manufacturing

Notes

- | Z = 4 for feed rate 20 - 30 m/min
- | Z = 6 for feed rate 30 - 45 m/min
- | Z = 8 for feed rate 45 - 60 m/min
- | machines must be equipped with i-system
- | constant basic dimensions
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	8,5	22.2	HSK 25R	4	180648	180649
70	8,5	22.2	HSK 25R	6	180650 s	180651 s
70	8,5	22.2	HSK 25R	8	180652 s	180653 s
70	15	23	HSK 25R	4	180934 s	180935 s
70	15	23	HSK 25R	6	180936 s	180937 s
70	8	23	HSK 25R	4	181176	181177
70	8	23	HSK 25R	6	181178	181179
70	8	23	HSK 25R	8	181180 s	181181 s
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

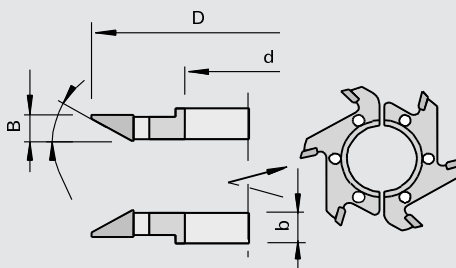
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

122110

Edge Chamfering Cutters HW two-part version - IMA (BIMA)

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135

for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle

two part version

n max = 18,000 min-1

Advantages

Notes

sense of rotation see drawing

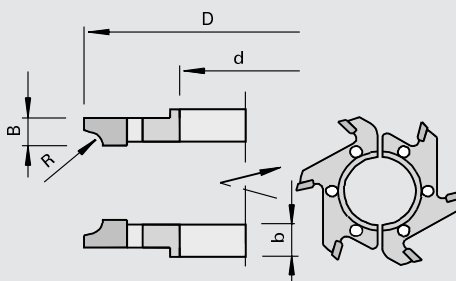
Chamfer	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
30	70	9	9	30	6	IMA (BIMA)	180164	180163
2	70	9	9	30	6	IMA (BIMA)	180161 s	180162 s
[°]	[mm]	[mm]	[mm]	[mm]				

122110

Edge Rounding Cutters HW two-part version - IMA (BIMA)

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines IMA model BIMA with glueing device / flush cutting unit 6135

for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

two part version

with shear angle

n max = 18,000 min-1

Advantages

Notes

sense of rotation see drawing

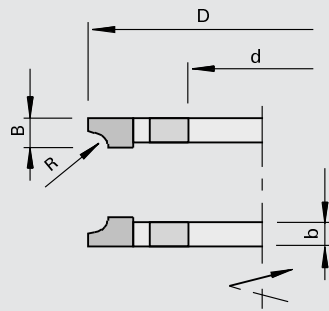
R	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
2	70	6	6	30	6	IMA (BIMA)	180155 s	180156 s
2	70	9	9	30	6	IMA (BIMA)	180157	180158
2,5	70	6	6	30	6	IMA (BIMA)	708379 s	708378 s
2,5	70	7,6	6	30	6	IMA (BIMA)	710972 s	710971 s
3	70	6	6	30	6	IMA (BIMA)	180165 s	180166 s
3	70	9	9	30	6	IMA (BIMA)	180167	180168
4	72	7,5	6	30	6	IMA (BIMA)	713621 s	713620 s
5	74	8	6	30	6	IMA (BIMA)	711046 s	711045 s
[mm]	[mm]	[mm]	[mm]	[mm]				

122115

Edge Rounding Cutters HW one-part version - Brandt

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines Brandt
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

one part version
with shear angle
n max = 18,000 min-1

Advantages

Notes

Ø 96 mm Brandt spare part
No. 2 001-80-510-540
Ø 66 mm Brandt spare part
No. 2 001-80-480-500
sense of rotation see drawing

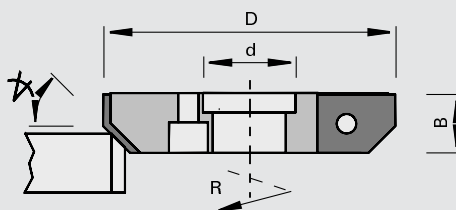
R	Ø D	Ø D1	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
2	66	60	6	6	16	6	Brandt	819471 s	819472 s
2,5	66	60	6	6	16	6	Brandt	819473 s	819474 s
3	66	60	6	6	16	6	Brandt	819475 s	819476 s
2	96	86	8	6	40	6	Brandt	820051 s	820052 s
2,5	96	86	8	6	40	6	Brandt	820053 s	820054 s
3	96	86	8	6	40	6	Brandt	820055 s	820056 s
3,5	96	86	8	6	40	6	Brandt	820057 s	820058 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

120102

Edge Chamfering Cutterheads HW for machining centers - Homag

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l machining center Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Chamfer∠	∅ D	B	∅ d	Z	Ident-No. [L]	Ident-No. [R]
5	60	12	19	3	179207 s	179206 s
15	60	12	19	3	178634 s	178633 s
30	60	13,5	19	3	178632	178631
45	60	12	19	3	178630 s	178629 s
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer∠	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	5	12	16	2	151545	179174	179173
	15	12	16	2	151545	177042	177045
	30	13,5	16	2	151545	177043	177046
	45	12	16	2	151545	177822	177823
	[°]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=12	925300	178759
Magnetic Stops	0,0	997800	016613
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100	985730	166090
	[mm]		

120101

Edge Chamfering Cutterheads HW for machining centers (particularly for thin edge bands) - Homag

Product	Drawing	
		tungsten carbide [HW]
		MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machining center Homag for flush-cutting and chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis cutting material: HW HL Board 05 n max = 18,000 min-1 		<ul style="list-style-type: none"> especially for thin edge bands sense of rotation according to DIN-EN 50144

Chamfer	Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
15°	62 [mm]	14 [mm]	19 [mm]	3	178640	178639

Knives	B	H	S	Class-No.	Ident-No.
Spurs	14 [mm]	14 [mm]	2 [mm]	150559	003079

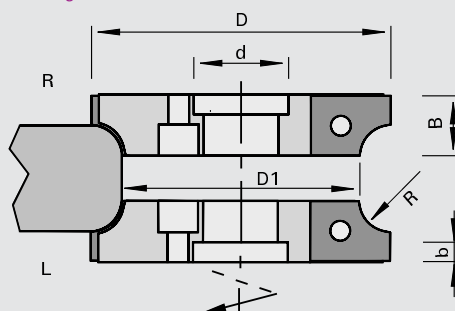
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x6 T20	995125	176199
Screwdrivers	T20x100 [mm]	985730	166092

120102

Edge Rounding Cutterheads HW for machining centers - Homag

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l machining center Homag
l for rounding of solid wood,
veneer and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
06
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R
1.5 - 3 mm; R 4 - 5 mm
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1	59	50	15	4	19	3	185197 ♂	185198 ♂
1,5	59	50	15	4	19	3	185199 ♂	185200 ♂
2	59	50	15	4	19	3	180749 ♂	180748 ♂
2,5	59	50	15	4	19	3	185201 ♂	185202 ♂
3	59	50	15	4	19	3	180751 ♂	180750 ♂
4	63	50	15	4	19	3	178795 s	178794 s
5	63	50	15	4	19	3	178797 s	178796 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	1	13	15	2	151546	180722	180721
	1,5	13	15	2	151546	181954	181953
	2	13	15	2	151546	181956	181955
	2,5	13	15	2	151546	180728	180727
	4	14	17	2	151545	177036 #	177040 #
	5	15	17	2	151545	177037	177041
	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Clamping Bars	B=12	925300	178759
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100	985730	166090
Magnetic Stops	1,0	997800	166094
Magnetic Stops	0,0	997800	016613
	[mm]		

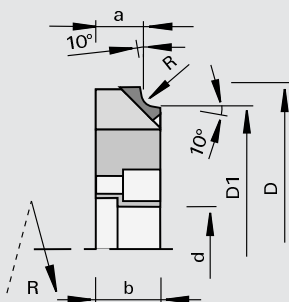
222512

DIAMAX Edge Rounding Cutters DP - Homag

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

l machining center Homag
l for rounding of solid wood, veneer and plastic edge bands

Design

l polished face
l high-finish clearance angle
l with shear angle
l n max = 24,000 min-1

Advantages

l optimum cutting quality

Notes

l constant basic dimensions a and D1
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	NL	Ident-No. [L]	Ident-No. [R]
2	57	50	11	14	15	3	3/4,2/25	179416	179417
3	57	50	11	14	15	3	3/4,2/25	179418	179419
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

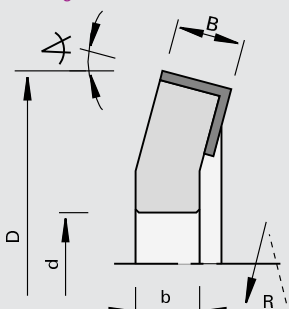
120120

Edge Chamfering Cutterheads HW - Homag

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

Chamfer \sphericalangle	Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
15	65	12	11	16	3	5x2,3 Homag	167735	167734
[°]	[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives

B	H	S	Class-No.	Ident-No.
12	12	1.5	150515	003080
[mm]	[mm]	[mm]		

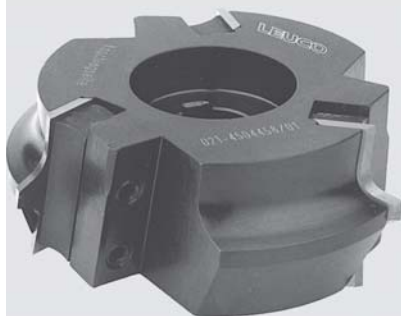
Spare parts

Dimension	Class-No.	Ident-No.
Clamping Bars	B=10	925300
Set Screws	M6x12 DIN EN ISO 4028	995161
Screwdrivers	SW3x100	985730
	[mm]	166090

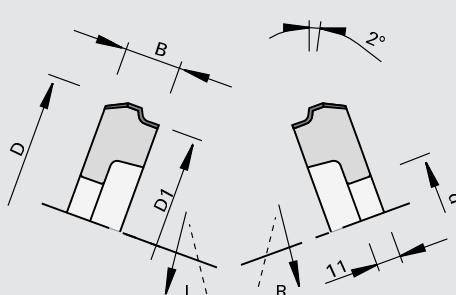
120102

Edge Rounding Cutterheads HW - Homag Softforming

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
Homag during the softforming
process
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
cutting material: HW HL Board
05
n max = 18,000 min-1

Advantages

Notes

same cutterhead body for R
2 - 3 mm; R 5 - 8 mm
sense of rotation see drawing

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	75	66	20,5	11	16	3	5x2,3	163079 s	163080 s
3	75	66	20,5	11	16	3	5x2,3	163081 ♂	163082 ♂
5	80	66	30	11	16	3	5x2,3	163085 ♂	163086 ♂
6	80	66	30	11	16	3	5x2,3	163087 ♂	163088 ♂
8	80	66	30	11	16	3	5x2,3	163091 s	163092 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
	2	20,5	15	2	151545	163062 s
	3	20,8	15	2	151545	163063
	5	30	17	2	151545	163065
	6	30,5	17	2	151545	163066
	8	30,5	17	2	151545	163068 s
	[mm]	[mm]	[mm]	[mm]		

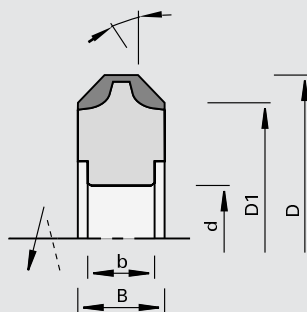
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=18	163079, 163080, 163081, 163082	925300	163077
Clamping Bars	B=27,6	163085, 163086, 163087, 163088, 163089, 163090, 163091, 163092	925300	163078
Set Screws	M6x12 DIN EN ISO 4028		995161	180214
Screwdrivers	SW3x100		985730	166090
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
Magnetic Stops	0,0		997800	016613
	[mm]			

120102

Edge Chamfering Cutterheads HW

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
l for chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l for clockwise and counter-clockwise rotation
l sense of rotation according to DIN-EN 50144

Chamfer∠	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No.
45	57	50	12	12	16	2	5x2,3 HOLZ-HER	171189 &
45	62	50	16	10	16	2	5x2,3 HOLZ-HER	173379 &
45	73	61	16	11	16	3	5x2,3 Homag	173380 &
45	82	70	16	11	16	4	5x2,3 Brandt	172728 &
45	73	61	16	11	20	3	6x3,5 HOLZ-HER	173381 &
45	82	70	16	11	20	4	6x3,5 IMA, Wilmsmeyer	172729 &
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Knives	Chamfer∠	B	H	S	Class-No.	Ident-No.
for Ø D = 57	45	12	12	1.5	151545	171190
for Ø D = 62/73/82	45	16	17.5	2	151545	169292
	[°]	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	12x9,5x6	171189	925300	170342
Clamping Bars		173379, 173380, 173381	925300	169246
Clamping Bars	B=15,6	172728, 172729	925300	163488
Set Screws	M6x12 DIN EN ISO 4028		995161	180214
Cranked Wrench Keys	SW2,5 DIN ISO 2936		985730	009671
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
Magnetic Stops	0,0		997800	016613
	[mm]			

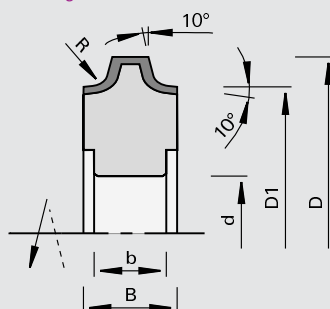
120102

Edge Rounding Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

Notes

l for clockwise and counter-
clockwise rotation
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN		Ident-No.
2	57	50	12	12	16	2	5x2,3	HOLZ-HER	170338 &
3	57	50	12	12	16	2	5x2,3	HOLZ-HER	170339 &
2	58	50	12	10	16	4	5x2,3	Brandt	177030
3	58	50	12	10	16	4	5x2,3	Brandt	177031 s
2	62	50	16	10	16	2	5x2,3	HOLZ-HER	179997
3	62	50	16	10	16	2	5x2,3	HOLZ-HER	169241
5	62	50	16	10	16	2	5x2,3	HOLZ-HER	169243 &
2	73	61	16	11	16	3	5x2,3	Homag, Ott	171128
3	73	61	16	11	16	3	5x2,3	Homag, Ott	171129
4	73	61	16	11	16	3	5x2,3	Homag, Ott	171130 &
5	73	61	16	11	16	3	5x2,3	Homag, Ott	171131 &
6	81	61	24	11	16	3	5x2,3	Homag, Ott	170254 &
8	81	61	24	11	16	3	5x2,3	Homag, Ott	170256 &
9	81	61	24	11	16	3	5x2,3	Homag, Ott	170257 &
2	78	70	16	11	16	4	5x2,3	Brandt	182086 &
2	82	70	16	11	16	4	5x2,3	Brandt	170192 &
3	82	70	16	11	16	4	5x2,3	Brandt	170193 &
4	82	70	16	11	16	4	5x2,3	Brandt	170194 &
5	82	70	16	11	16	4	5x2,3	Brandt	170195 &
2	73	61	16	11	20	3	6x3,5	HOLZ-HER	171132 &
3	73	61	16	11	20	3	6x3,5	HOLZ-HER	171133 &
4	73	61	16	11	20	3	6x3,5	HOLZ-HER	171134 &
5	73	61	16	11	20	3	6x3,5	HOLZ-HER	171135 &
2	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166882 &
3	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166881 &
4	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166880 &
5	82	70	16	11	20	4	6x3,5	IMA, Wilmsmeyer	166879 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives

	R	B	H	S	Class-No.	Ident-No.
for Ø D = 62/73/82	1,5	16	17.5	2	151545	176583
for Ø D = 58	2	12	13	2	151545	177033
for Ø D = 57	2	12	12	1.5	151545	170340
for Ø D = 78	2	16	15.5	2	151545	182087
for Ø D = 62/73/82	2	16	17.5	2	151545	163489
for Ø D = 58	3	12	13	2	151545	177032
for Ø D = 57	3	12	12	1.5	151545	170341
for Ø D = 62/73/82	3	16	17.5	2	151545	163490
for Ø D = 62/73/82	4	16	17.5	2	151545	163491
for Ø D = 62/73/82	5	16	17.5	2	151545	163492
for Ø D = 81	6	24	22	2	151545	170258
for Ø D = 81	8	24	22	2	151545	170260
	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
for Ø D = 81	9	24	22	2	151545	170261 #
	[mm]	[mm]	[mm]	[mm]		
Spare parts	Dimension	For Ident-No.			Class-No.	Ident-No.
Clamping Bars	B=10,5	177030, 177031			925300	175640
Clamping Bars	12x9,5x6	170338, 170339			925300	170342
Clamping Bars		169241, 169243, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997			925300	169246
Clamping Bars	B=15,6	166879, 166880, 166881, 166882, 170192, 170193, 170194, 170195, 182086			925300	163488
Clamping Bars	24x14,5x7	170254, 170256, 170257			925300	170262
Set Screws	M5x12 DIN EN ISO 4028	177030, 177031			995161	050565
Set Screws	M6x12 DIN EN ISO 4028	166879, 166880, 166881, 166882, 169241, 169243, 170192, 170193, 170194, 170195, 170338, 170339, 171128, 171129, 171130, 171131, 171132, 171133, 171134, 171135, 179997, 182086			995161	180214
Set Screws	M8x12 DIN EN ISO 4028	170254, 170256, 170257			995161	180001
Magnetic Stops	0,0				997800	016613
Cranked Wrench Keys	SW2,5 DIN ISO 2936				985730	009671
Cranked Wrench Keys	SW3 DIN ISO 2936				985730	009672
	[mm]					

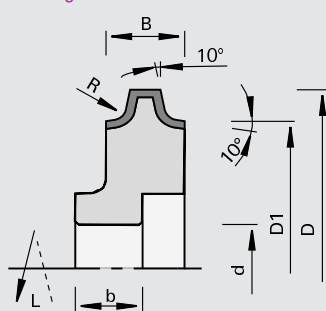
120102

Edge Rounding Cutterheads HW - IMA

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R 2 - 5 mm
l sense of rotation see drawing

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	82	70	16	13	20	4	6x3,5	168373 &	168374 &
3	82	70	16	13	20	4	6x3,5	168353 &	168354 &
4	82	70	16	13	20	4	6x3,5	168375 &	168376 &
5	82	70	16	13	20	4	6x3,5	168377 &	168378 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
Chamfering Knives		16	17.5	2	151545	169292
Radius Knives	2	16	17.5	2	151545	163489
Radius Knives	3	16	17.5	2	151545	163490
Radius Knives	4	16	17.5	2	151545	163491
Radius Knives	5	16	17.5	2	151545	163492
	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=15,6	925300	163488
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	009672
	[mm]		

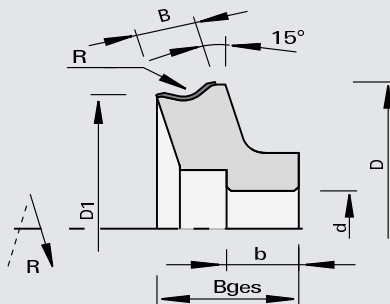
120102

Edge Rounding Cutters HW (cranked) - IMA

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R
2 - 4 mm
l sense of rotation see drawing

R	Ø D	Ø D1	B	b	b1	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
4	77.6	70	13	13	27.9	20	4	6x3,5	172712 &	172711 &
3	77.6	70	13	13	27.9	20	4	6x3,5	172710 &	172709 &
2	77.6	70	13	13	27.9	20	4	6x3,5	172708 &	172707 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives

R

B

H

S

Class-No.

Ident-No.

2

13

16

2

151555

172713

3

13

16

2

151555

172714

4

13

16

2

151555

172715 #

[mm]

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Clamping Bars

B=12

925300

162095

Set Screws

M6x12 DIN EN ISO 4028

995161

180214

Cranked Wrench Keys

SW3 DIN ISO 2936

985730

009672

[mm]

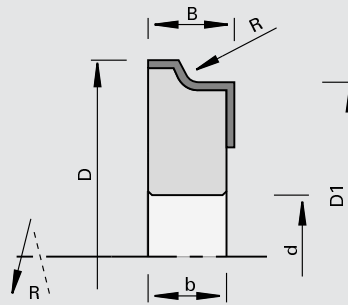
120102

Edge Rounding Cutterheads HW - Brandt

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines Brandt
l for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

l with shear angle
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

l optimum cutting quality on solid wood edges thanks to cutting edges with shear angle

Notes

l same cutterhead body for R 2 - 3 mm
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	78	70	18,5	10	16	4	5x2,3	180441 &	180440 &
3	78	70	18,5	10	16	4	5x2,3	173389 &	173388 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives

R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
3	16,1	14	2	151545	178221	178220
2	19,6	15.2	2	151545	173817	173816
3	19,6	15.2	2	151545	173393	173392
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension	Class-No.	Ident-No.
Clamping Bars B=17	925300	167971
Set Screws M6x10 DIN EN ISO 4028	995161	180002
Cranked Wrench Keys SW3 DIN ISO 2936	985730	009672
Magnetic Stops 0,0 [mm]	997800	016613

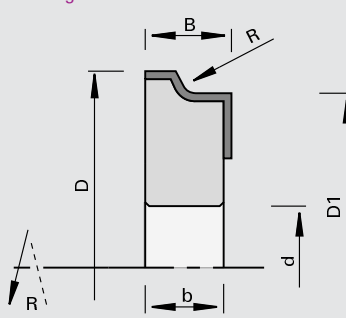
120102

Edge Rounding Cutterheads HW - Brandt, EBM, Reich

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
Brandt, EBM, Reich
l for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min-1

Advantages

Notes

l same cutterhead body for R
2 - 3 mm
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	56	50	15	11	16	3	5x2,3	179995	179996
2,5	56	50	15	11	16	3	5x2,3	177325 s	177326 s
3	56	50	15	11	16	3	5x2,3	177327	177328
2	56	50	12	11	16	4	5x2,3	172138	172137
3	56	50	12	11	16	4	5x2,3	172140 s	172139 s
2	56	50	16	11	16	4	5x2,3	178215 s	178214 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	2	12	14.5	2	151545	172142	172141
	3	12	14.5	2	151545	172144	172143
	2	15	14.5	2	151545	177317	177318
	2,5	15	14.5	2	151545	177319	177320
	3	15	14.5	2	151545	177321	177322
	2	16,1	14	2	151545	178219	178218
	[mm]	[mm]	[mm]	[mm]			

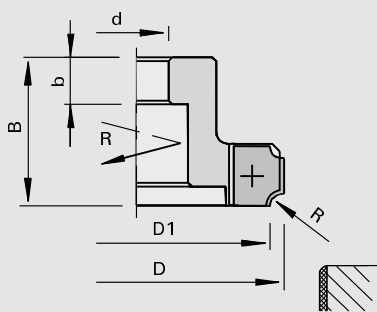
Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=10	172137, 172138, 172139, 172140	925300 171221
Clamping Bars	B=13	177325, 177326, 177327, 177328, 179995, 179996	925300 177332
Clamping Bars	B=15	178214, 178215	925300 178213 o
Set Screws	M5x10 DIN EN ISO 4026	172137, 172138, 172139, 172140	995161 180028
Set Screws	M6x12 DIN EN ISO 4028	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	995161 180214
Magnetic Stops	0,0	For all	997800 016613
Cranked Wrench Keys	SW2,5 DIN ISO 2936	172137, 172138, 172139, 172140	985730 009671
Cranked Wrench Keys	SW3 DIN ISO 2936	177325, 177326, 177327, 177328, 178214, 178215, 179995, 179996	985730 009672
	[mm]		

120115

Edge Rounding Cutterheads HW - EBM, Hebrock

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines EBM, Hebrock model: form part radius cutter FRF 130
for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

one part version
with shear angle
n max = 18,000 min-1

Advantages

Notes

sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
3	74	67	16	12	16	6	783001 s	783003 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	R	B	H	S	Class-No.	Ident-No.
	2	16	13.5	2	151586	180151
	3	16	13.5	2	151586	180152
	[mm]	[mm]	[mm]	[mm]		

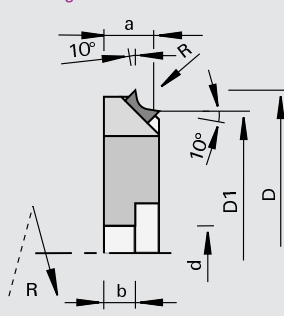
Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=10	925300	168344
Set Screws	M8x12 DIN EN ISO 4028	995161	180001
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	009672
Magnetic Stops	0,0 [mm]	997800	016613

222512

DIAMAX Edge Rounding Cutters DP - Homag, Brandt, Ott

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Homag, Brandt, Ott
for rounding of solid wood, veneer and plastic edge bands

Design

polished face
high-finish clearance angle
with shear angle
n max = 24,000 min-1

Advantages

optimum cutting quality

Notes

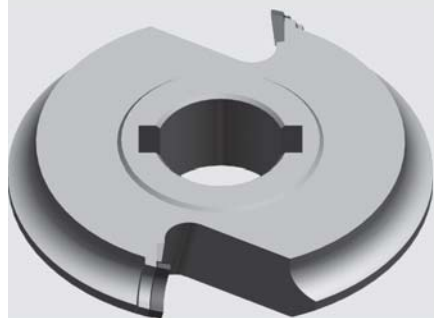
constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	69	61	9.1	10	16	4	5x2,3	177312	177311
3,0	69	61	10	10	16	4	5x2,3	177314 s	177313 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

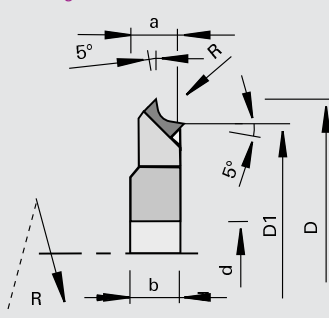
222512

DIAMAX Edge Rounding Cutters DP - HOLZ-HER

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

Notes

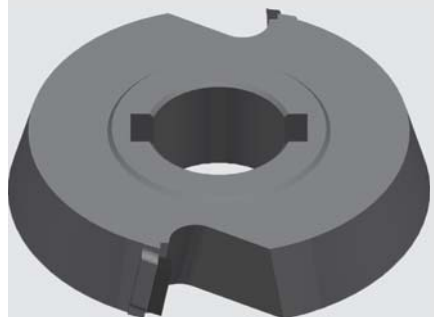
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	57	50	8.5	12.5	16	2	5x2,3	182141	182142
2,5	57	50	8.5	12.5	16	2	5x2,3	182143 o	182144 o
3,0	57	50	8.5	12.5	16	2	5x2,3	182145 o	182146 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

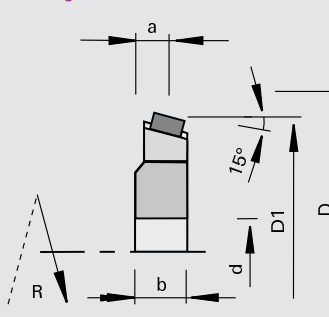
222512

DIAMAX Edge Chamfering Cutters DP - HOLZ-HER

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
n max = 24,000 min-1

Advantages

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
15	52	50	8.5	12.5	16	2	5x2,3	182147 s	182148 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

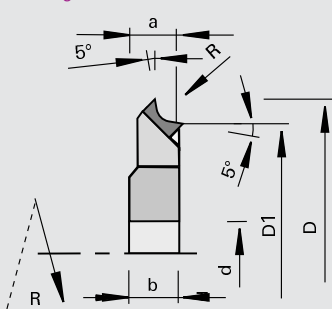
222512

DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1832

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate 1832
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

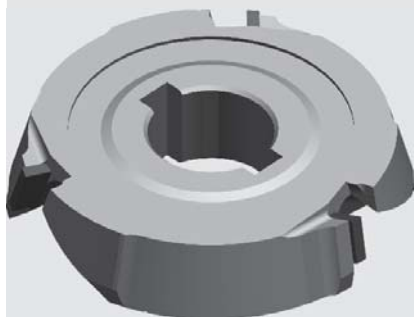
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
2	58.7	50	8.5	12	16	3	5x2,3	182684
2,5	58.7	50	8.5	12	16	3	5x2,3	182685
3	58.7	50	8.5	12	16	3	5x2,3	182686
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

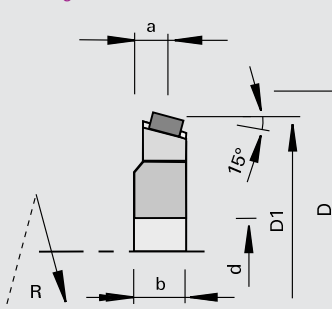
222512

DIAMAX Edge Chamfering Cutters CM DP - HOLZ-HER 1832

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- HOLZ-HER aggregate 1832
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- resharpenable area 3.5 mm
- n max = 24.000 min-1

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer∠	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No.
15	53	50	10	12	16	3	5x2,3	182687 s
45	56	50	10	12	16	3	5x2,3	182688 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

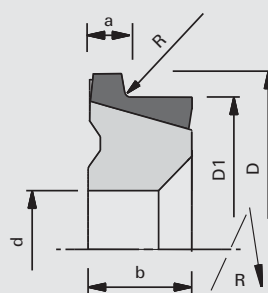
222312

Edge Rounding Cutters CM DP - HOLZ-HER 1827

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1827
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area approx. 2
mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

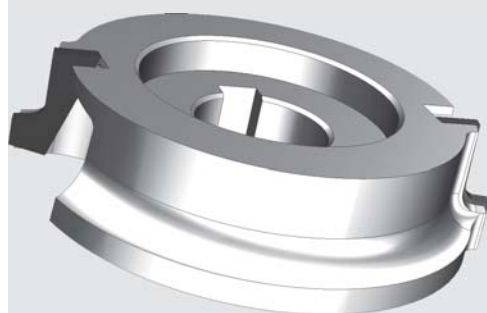
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	56	50	8	17	20	2	5x2,2	183099 s	183100 s
2	56	50	8	17	20	2	5x2,2	183101	183102
2,5	56	50	8	17	20	2	5x2,2	183103	183104
3	57	50	8	17	20	2	5x2,2	183105 s	183106 s
5	60	50	8	17	20	2	5x2,2	183107 s	183108 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

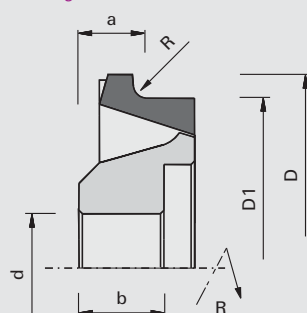
222312

Edge Rounding Cutters CM DP - HOLZ-HER 1825M

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines HOLZ-
HER aggregate 1825M
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area approx. 2
mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

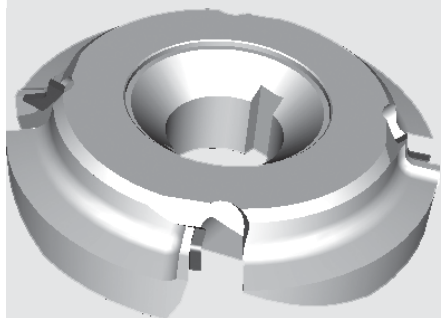
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	57	50	10	12.5	16	2	5x2,4	184319	184318
2	57	50	10	12.5	16	2	5x2,4	184321	184320
2,5	57	50	10	12.5	16	2	5x2,4	184323	184322
3	57	50	10	12.5	16	2	5x2,4	184325	184324
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

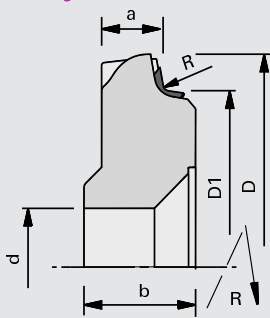
222312

Edge Rounding Cutters CM DP - HOLZ-HER 1833

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1833
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area 3.5 mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

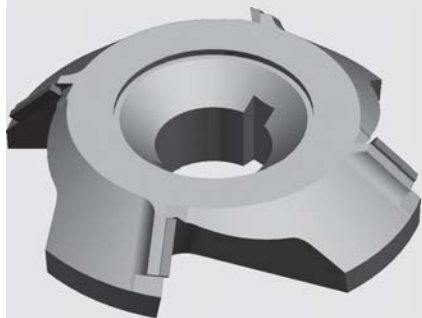
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	72.5	61	13.5	19	20	4	5x2,2	182501 s	182500 s
2	72.5	61	13.5	19	20	4	5x2,2	182503	182502
2,5	72.5	61	13.5	19	20	4	5x2,2	182505	182504
3	72.5	61	13.5	19	20	4	5x2,2	182507	182506
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

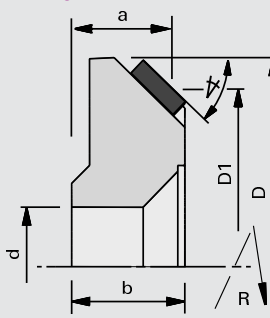
222312

Edge Chamfering Cutters CM DP - HOLZ-HER 1833

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1833
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area 3.5 mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45°	72.5	61	17	19	20	4	5x2,2	182509	182508
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

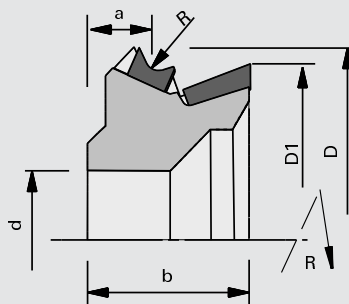
222312

Edge Rounding Flush-Cutting Cutters CM DP - HOLZ-HER 1826

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1826
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area 3.5 mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	57.3	50	10.76	23	20	2	5x2,2	182481	182480
5	57.3	50	11.80	23	20	2	5x2,2	182489 s	182488 s
1	57.3	50	10.76	23	20	3	5x2,2	182491 s	182490 s
5	57.3	50	11.80	23	20	3	5x2,2	182499 s	182498 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

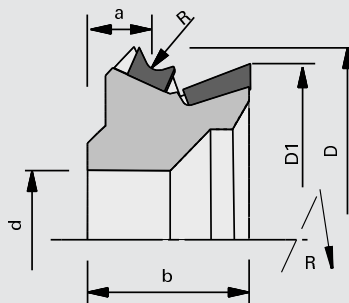
222312

Edge Rounding Trimming Cutter CM DP - HOLZ-HER 1826 - AirStream-System

Product



Drawing

AIR
STREAMLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
HOLZ-HER aggregate 1826
for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
Air-Stream-System
ChipMeister
n max = 24.000 min-1

Advantages

improved chip removal thanks
to ChipMeister version and
AirStream-System
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
low noise level

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

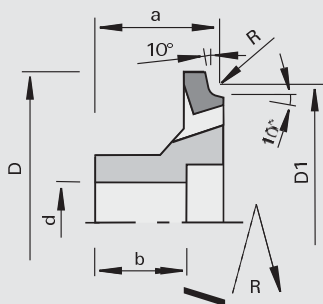
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]	
2	55	50	11.02	23.6	20	2+2	5x2,2	HOLZ-HER 1826	184735	184734
2,5	55.8	50	11.15	23.8	20	2+2	5x2,2	HOLZ-HER 1826	184737	184736
3	56	50	11.28	23.9	20	2+2	5x2,2	HOLZ-HER 1826	184739	184738
2	55	50	11.02	23.6	20	3+3	5x2,2	HOLZ-HER 1826	184741	184740
2,5	55.8	50	11.15	23.8	20	3+3	5x2,2	HOLZ-HER 1826	184743 s	184742 s
3	56	50	11.28	23.9	20	3+3	5x2,2	HOLZ-HER 1826	184745 s	184744 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			

122110

Edge Rounding Cutters HW - SCM-Stefani Round/K

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines Stefani with ED system and aggregate Round/K
for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 30,000 min-1

Advantages

optimized chip removal
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

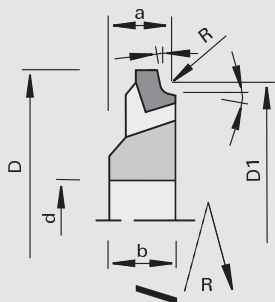
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	55.7	49,9	25.4	20	16	3	5x2,3	182446 s	182447 s
1,5	55.7	50,9	25.4	20	16	3	5x2,3	182448 s	182449 s
2,0	55.7	51,9	25.4	20	16	3	5x2,3	182450	182451
2,5	55.7	52,9	25.4	20	16	3	5x2,3	182452 s	182453 s
3,0	55.7	53,9	25.4	20	16	3	5x2,3	182454	182455
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

122212

Edge Rounding Cutters HW - SCM-Stefani K130

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

edge banding machines SCM-Stefani with aggregate K130
for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
n max = 30,000 min-1

Advantages

optimized chip removal
less chips remain inside of the machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

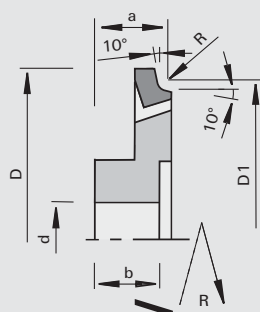
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	55.3	52	12	13.5	16	3	5x2,3	192213	192214
3,0	55.3	54	13	13.5	16	3	5x2,3	192216	192215
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

122122

Edge Rounding Cutters HW - SCM-IDM

Product

Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

edge banding machines
SCM-IDM with ED system and
aggregate C1 / C2
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
n max = 18,000 min-1

Advantages

optimized chip removal
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

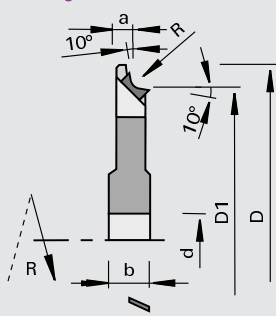
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	62,031	14.5	14	16	4	5x2,3	182911 s	182910 s
1,5	70	63,046	14.5	14	16	4	5x2,3	182909 s	182908 s
2,0	70	64,062	14.5	14	16	4	5x2,3	182907	182906
2,5	70	65,077	14.5	14	16	4	5x2,3	182905 s	182904 s
3,0	70	66,092	14.5	14	16	4	5x2,3	182903 s	182902 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222512

DIAMAX Edge Rounding Cutters DP - SCM-Stefani

Product

Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines SCM
Stefani with ED-System
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
n max = 20,000 min-1
polished face and high-finish
clearance angle

Advantages

optimized chip removal
less chips remain inside of the
machine
no malfunctions due to chips
reduction of suction power
noise reduced

Notes

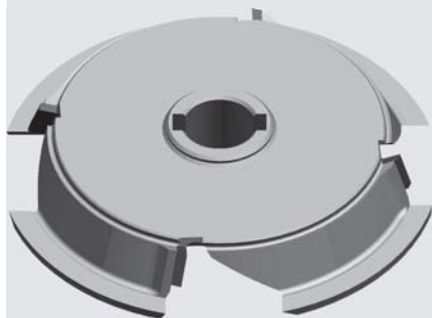
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	73	61,7	8.1	12	12	4	4x2,15	182288 s	182289 s
1,5	73	61,7	7.6	12	12	4	4x2,15	182290 s	182291 s
2,0	73	61,7	7.1	12	12	4	4x2,15	182292	182293
2,5	73	61,7	6.6	12	12	4	4x2,15	182294 s	182295 s
3,0	73	61,7	6.1	12	12	4	4x2,15	182296 s	182297 s
4,0	73	61,7	5.1	12	12	4	4x2,15	182298 s	182299 s
5,0	73	61,7	4.1	12	12	4	4x2,15	182300 s	182301 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

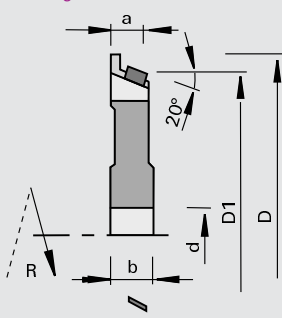
222512

DIAMAX Edge Chamfering Cutters DP - SCM-Stefani

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-Stefani with ED-System
- for chamfering of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

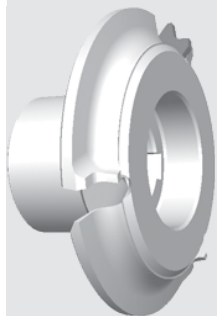
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Chamfer [°]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
20	73	61,7	8,7	12	12	4	4x2,15	182302	182303

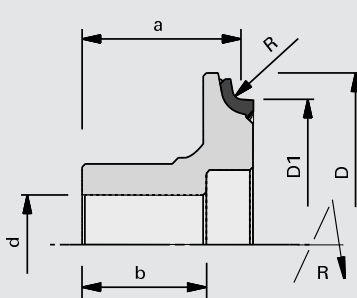
222310

Edge Rounding Cutters DP - SCM-IDM Round/K

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate Round/K
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 20,000 min-1
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

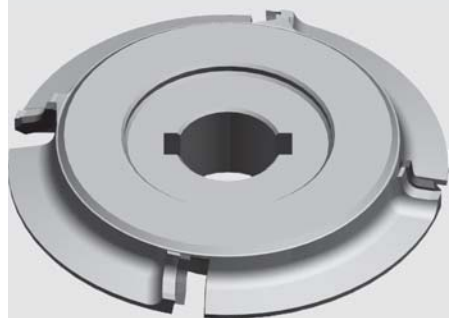
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
1	55,3	49,93	25,4	20	16	3	5x2,3	182416 s	182415 s
1,5	55,3	50,93	25,4	20	16	3	5x2,3	182418 s	182417 s
2	55,3	51,93	25,4	20	16	3	5x2,3	182414 s	182413 s
2,5	55,7	52,93	25,4	20	16	3	5x2,3	182424 s	182423 s
3	55,7	53,93	25,4	20	16	3	5x2,3	182412 s	182411 s

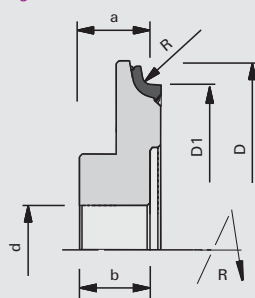
222310

Edge Rounding Cutters DP - SCM-IDM C1/C2

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines SCM-IDM with ED system and aggregate C1 / C2
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- $n_{max} = 18,000 \text{ min}^{-1}$
- polished face and high-finish clearance angle

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduced suction performance
- low noise level

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	70	60	14.5	14	16	4	5x2,2	182901 s	182900 s
1,5	70	60	14.5	14	16	4	5x2,2	182899 s	182898 s
2,0	70	60	14.5	14	16	4	5x2,2	182897 s	182896 s
2,5	70	60	14.5	14	16	4	5x2,2	182895 s	182894 s
3,0	70	60	14.5	14	16	4	5x2,2	182893 s	182892 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

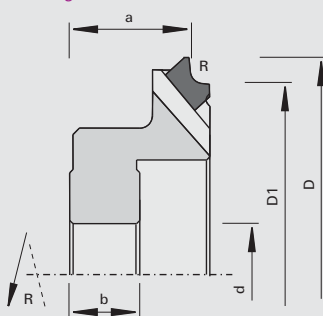
222210

DIAMAX Edge Rounding Cutters DP - Biesse Ergho, Akron

Product



Drawing

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machine Biesse Ergho/Akron 200/800 - CR 200/CR 202
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- reduced resharpening area
- $n_{max} = 24,000 \text{ min}^{-1}$

Advantages

Notes

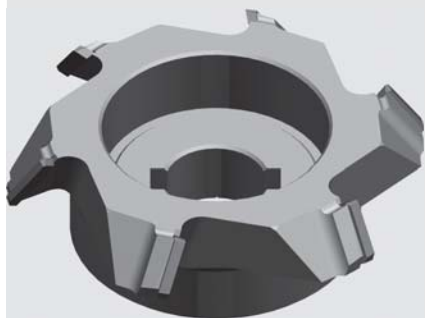
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	68	59,86	21	22.3	16	6	5x2,3	183699 s	183700 s
2	68	59,86	21	22.3	16	6	5x2,3	183701 s	183702 s
3	68	59,86	21	22.3	16	6	5x2,3	183703 s	183704 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

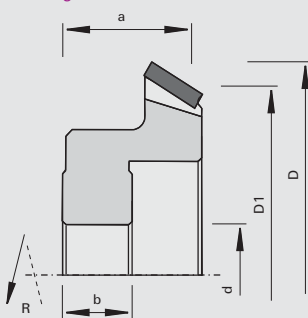
222210

DIAMAX Edge Chamfering Cutters DP - Biesse Ergho, Akron

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machine Biesse Ergho/Akron 200/800 - CR 200/CR 202
for chamfering of solid wood, veneer and plastic edge bands

Design

with shear angle
reduced resharpening area
n max = 24,000 min⁻¹

Advantages

Notes

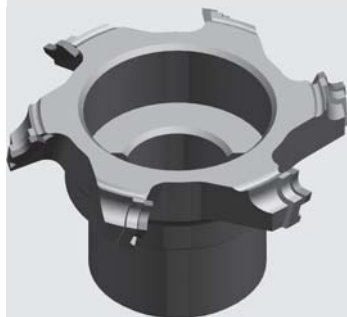
constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

Chamfer [°]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
25	68	60	20.7	22	16	6	5x2,3	183705 s	183706 s

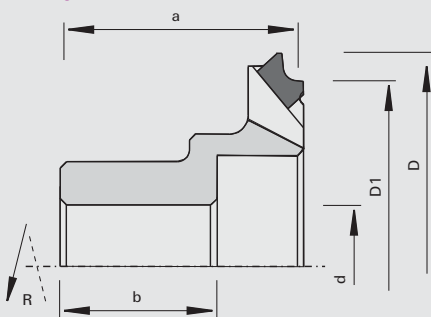
222510

DIAMAX Edge Rounding Cutters DP - Biesse

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Biesse
for rounding of solid wood, veneer and plastic edge bands

Design

with shear angle
polished face and high-finish clearance angle
reduced resharpening area
n max = 24,000 min⁻¹

Advantages

optimum cutting quality

Notes

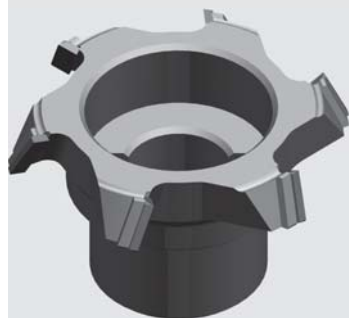
constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Ident-No. [L]	Ident-No. [R]
1,5	67	60	38.5	39.5	20	6	6x2,8	183709 s	183710 s
2	67	60	38.5	39.5	20	6	6x2,8	183711 s	183712 s
3	67	60	38.5	39.5	20	6	6x2,8	183713 s	183714 s

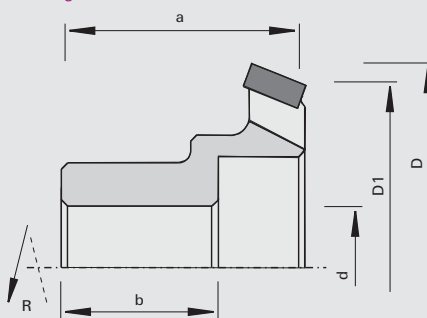
222510

DIAMAX Edge Chamfering Cutters DP - Biesse

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Biesse
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
reduced resharpening area
n max = 24,000 min-1

Advantages

optimum cutting quality

Notes

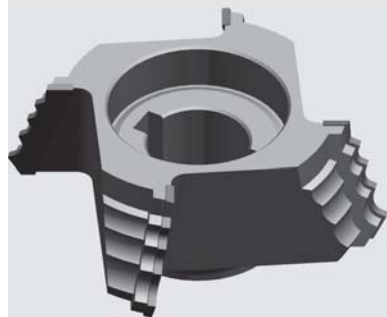
constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

Chamfer \angle	$\emptyset D$	$\emptyset D1$	a	b	$\emptyset d$	Z	DKN	Ident-No. [L]	Ident-No. [R]
25	67	60	38.5	39.5	20	6	6x2,8	183715 s	183716 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

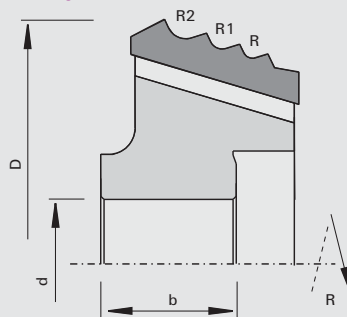
222360

Edge Rounding / Chamfering Cutters DP Multi - Biesse

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Biesse
RF 40
for rounding and chamfering of
solid wood, veneer and plastic
edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpening area 1,0 mm
n max = 24,000 min-1

Advantages

optimum cutting quality

Notes

sense of rotation according to
DIN-EN 50144

R	R1	R2	Chamfer \angle	$\emptyset D$	b	$\emptyset d$	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,5	2.0	3.0	25	75.4	30	20	4	6x2,8	183707 s	183708 s
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]		[mm]		

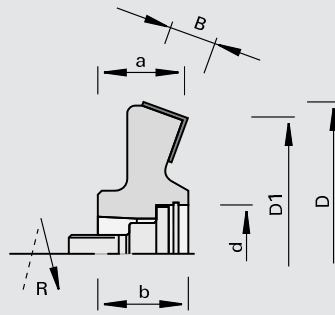
120120

Edge Chamfering Cutterheads HW HSK 25R - Homag, IMA

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag, IMA
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l cutting material: HW HL Board 05
l n max = 18,000 min-1

Advantages

l excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

l constant basic dimensions a and D1
l sense of rotation according to DIN-EN 50144

Chamfer	Ø D	Ø D1	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20 [°]	77 [mm]	70 [mm]	21.5 [mm]	12 [mm]	23 [mm]	HSK 25R [mm]	4	177594	177593
Turnover Knives				B	H	S		Class-No.	Ident-No.
				12 [mm]	12 [mm]	1.5 [mm]		150515	003080
Spare parts				Dimension				Class-No.	Ident-No.
Screws				M10x1,25x32 SW8				995190	177780
Shim Rings				18x25x1,0 DIN 988				995440	177781
Locking Rings				25x1,2 DIN 472				995460	177782
Clamping Bars				B=10				925300	164526
Set Screws				M6x12 DIN EN ISO 4028				995161	180214
Screwdrivers				SW3x100 [mm]				985730	166090

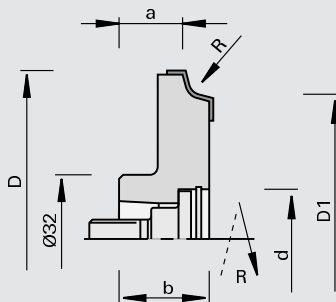
120102

Edge Rounding Cutterheads HW HSK 25R - Homag

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag
l for rounding of solid wood,
veneer and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05

Advantages

l excellent cutting quality thanks
to high radial running accuracy
and precise tool balancing

Notes

l constant basic dimensions a
and D1
l same cutterhead body for R
1.5 - 3 mm
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
1,5	79	70	16.5	23	HSK 25R	4	18000	177734 &	177733 &
2,0	79	70	16.5	23	HSK 25R	4	18000	177736 &	177735 &
2,5	79	70	16.5	23	HSK 25R	4	18000	177738 &	177737 &
3,0	79	70	16.5	23	HSK 25R	4	18000	177740 &	177739 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

Knives	R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	1,5	12	17	2	15 1521	177606	177605
	2	12	17	2	15 1521	177608	177607
	2,5	12	17	2	15 1521	177610 #	177609 #
	3	12	17	2	15 1521	177612	177611
	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	12x11x7	925300	177724
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
Set Screws	M6x16 SW3	995161	001617
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	009672
	[mm]		

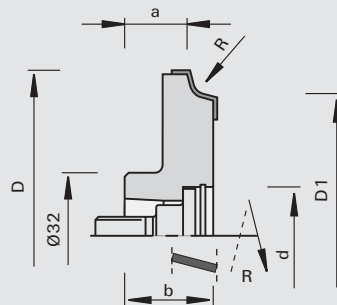
120112

Edge Rounding Cutterheads HW HSK 25R - IMA

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood, veneer and plastic edge bands

Design

l with shear angle
l cutting material: HW HL Board 06

Advantages

l excellent cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

l constant basic dimensions a and D1
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
2	80	70	16.5	23	HSK 25R	4	18000	180170 &	180169 &
3	80	70	16.5	23	HSK 25R	4	18000	180172 &	180171 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

Knives

R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
2	12	18	2	151586	180174	180173
3	12	18	2	151586	180176	180175
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension	Class-No.	Ident-No.		
Clamping Bars	12x11x7	left	925300	180255
Clamping Bars	12x11x7	right	925300	180256
Screws	M10x1,25x32 SW8		995190	177780
Shim Rings	18x25x1,0 DIN 988		995440	177781
Locking Rings	25x1,2 DIN 472		995460	177782
Set Screws	M6x16 SW3		995161	001617
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
[mm]				

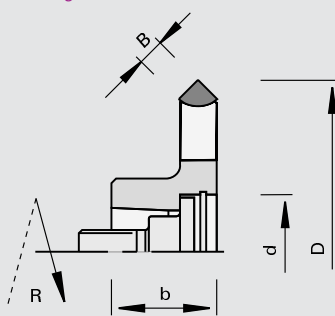
222530

Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag, IMA
for chamfering of solid wood,
veneer and plastic edge bands

Design

polished face
high-finish clearance angle
resharpenable
n max = 24,000 min-1

Advantages

optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

sense of rotation according to
DIN-EN 50144

Chamfer \angle	$\varnothing D$	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
45 [°]	75 [mm]	8 [mm]	23 [mm]	HSK 25R [mm]	4	177705 s	177706 s

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

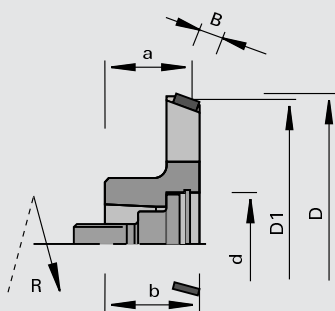
222510

DIAMAX Edge Chamfering Cutters DP HSK 25R - Homag, IMA

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag aggregate FF, IMA,
for flush-cutting and chamfer-
ing of solid wood, veneer and
plastic edge bands

Design

polished face
high-finish clearance angle
with shear angle
n max = 24,000 min-1

Advantages

optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

constant basic dimensions a
and D1
sense of rotation according to
DIN-EN 50144

Chamfer \angle	$\varnothing D1$	$\varnothing D$	a	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
20 [°]	70 [mm]	73 [mm]	21.5 [mm]	6 [mm]	23 [mm]	HSK 25R [mm]	4	177649 s	177650 s

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

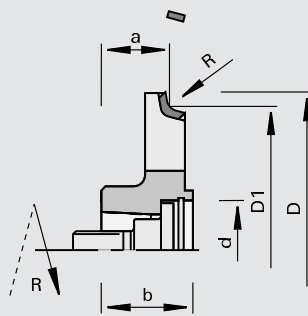
222512

DIAMAX Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag aggregate FF, IMA,
for rounding of solid wood,
veneer and plastic edge bands

Design

polished face
high-finish clearance angle
with shear angle
n max = 24,000 min⁻¹

Advantages

optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing

Notes

constant basic dimensions a
and D1
Z = 4 for feed rate 20 - 30 m/
min
Z = 6 for feed rate 30 - 45 m/
min
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	4	177655 s	177656 s
1,5	76.1	70	16.5	23	HSK 25R	4	177657 s	177658 s
2,0	77.5	70	16.5	23	HSK 25R	4	177659	177660
2,5	78.1	70	16.5	23	HSK 25R	4	177661 s	177662 s
3,0	78.8	70	16.5	23	HSK 25R	4	177663 s	177664 s
3,5	80.0	70	16.5	23	HSK 25R	4	177665 s	177666 s
4,0	81.2	70	16.5	23	HSK 25R	4	177667 s	177668 s
4,5	82.3	70	16.5	23	HSK 25R	4	177669 s	177670 s
5,0	83.3	70	16.5	23	HSK 25R	4	177671 s	177672 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	6	178545 s	178546 s
1,5	76.1	70	16.5	23	HSK 25R	6	178547 s	178548 s
2,0	77.5	70	16.5	23	HSK 25R	6	178549 s	178550 s
2,5	78.1	70	16.5	23	HSK 25R	6	178551 s	178552 s
3,0	78.8	70	16.5	23	HSK 25R	6	178553 s	178554 s
4,0	81.2	70	16.5	23	HSK 25R	6	178557 s	178558 s
4,5	82.3	70	16.5	23	HSK 25R	6	178559 s	178560 s
5,0	83.3	70	16.5	23	HSK 25R	6	178561 s	178562 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

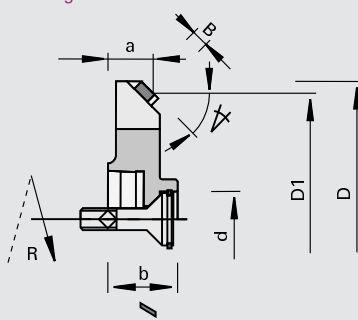
222512

DIAMAX Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing

LEUCO
toplineLEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines
Homag / aggregate FK 01, FK 02, FK 03
for chamfering of solid wood, veneer and plastic edge bands

Design

polished face
high-finish clearance angle
with shear angle
n max = 18,000 min⁻¹

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

constant basic dimensions a and D1
sense of rotation according to DIN-EN 50144

Chamfer	Ø D	Ø D1	a	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
5	62.7	62	11.5	6	17.5	HSK 32	4	177405 s	177404 s
30	65.9	62	11.5	6	17.5	HSK 32	4	177407 s	177406 s
45	71.5	62	11.5	6	17.5	HSK 32	4	177409 s	177408 s
20	64.9	62	11.5	6	17.5	HSK 32	4	176494	176493
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991	995121	173407
	[mm]		

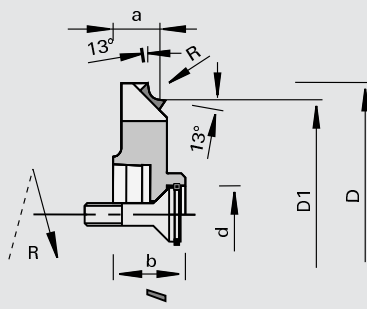
222512

DIAMAX Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag / aggregate FK 01, FK 02, FK 03
- for rounding of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 18,000 min-1
- HSK 32 shortened

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,8	68.1	62	11.5	17.5	HSK 32	4	179376 s	179377 s
1,0	68.1	62	11.5	17.5	HSK 32	4	179378 s	179379 s
1,5	68.1	62	11.5	17.5	HSK 32	4	179380 s	179381 s
2,0	71.2	62	11.5	17.5	HSK 32	4	179382	179383
2,5	71.2	62	11.5	17.5	HSK 32	4	179384 s	179385 s
3,0	71.2	62	11.5	17.5	HSK 32	4	179386 s	179387 s
3,5	75.3	62	11.5	17.5	HSK 32	4	179388 s	179389 s
4,0	75.3	62	11.5	17.5	HSK 32	4	179390 s	179391 s
4,5	75.3	62	11.5	17.5	HSK 32	4	179392 s	179393 s
5,0	75.3	62	11.5	17.5	HSK 32	4	179394 s	179395 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
0,8	68.1	62	11.5	17.5	HSK 32	6	178464 s	178465 s
1,0	68.1	62	11.5	17.5	HSK 32	6	178466 s	178467 s
1,5	68.1	62	11.5	17.5	HSK 32	6	178468 s	178469 s
2,0	71.2	62	11.5	17.5	HSK 32	6	178470 s	178471 s
2,5	71.2	62	11.5	17.5	HSK 32	6	178472 s	178473 s
3,0	71.2	62	11.5	17.5	HSK 32	6	178474 s	178475 s
3,5	75.3	62	11.5	17.5	HSK 32	6	178476 s	178477 s
4,0	75.3	62	11.5	17.5	HSK 32	6	178478 s	178479 s
4,5	75.3	62	11.5	17.5	HSK 32	6	178480 s	178481 s
5,0	75.3	62	11.5	17.5	HSK 32	6	178482 s	178483 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991	995121	173407
	[mm]		

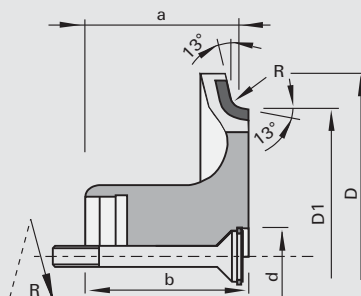
222812

Edge Rounding Cutters DP HSK 32 - Homag FK

Product



Drawing

LEUCO
toplineLEUCO
i-system

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Homag aggregate FK
- for rounding of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- machines must be equipped with i-system
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	4	180301	180300
1,5	74	62	31.5	33	HSK 32	4	180278	180279
2,0	74	62	31.5	33	HSK 32	4	180280	180281
2,5	74	62	31.5	33	HSK 32	4	180303 s	180302 s
3,0	74	62	31.5	33	HSK 32	4	180282	180283
4,0	74	62	31.5	33	HSK 32	4	180307 s	180306 s
5,0	74	62	31.5	33	HSK 32	4	180311 s	180310 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	74	62	31.5	33	HSK 32	6	180313 s	180312 s
1,5	74	62	31.5	33	HSK 32	6	180315	180314
2,0	74	62	31.5	33	HSK 32	6	180284	180285
3,0	74	62	31.5	33	HSK 32	6	180286 s	180287 s
2,5	74	62	31.5	33	HSK 32	6	180317 s	180316 s
4,0	74	62	31.5	33	HSK 32	6	180304 s	180305 s
5,0	74	62	31.5	33	HSK 32	6	180308 s	180309 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

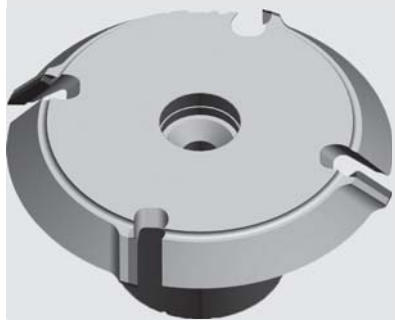
Ident-No.

Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991 [mm]	995121	173407

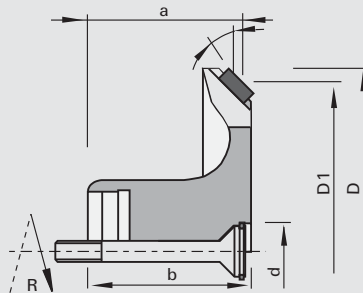
222812

Edge Chamfering Cutters DP HSK 32 - Homag

Product



Drawing



LEUCO
topline

LEUCO
i-system

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag / FK-aggregates
- for chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a and D1
- attention: machines must be re-equipped accordingly
- sense of rotation according to DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	65.1	62,3	31.5	34	HSK 32	4	180288	180289
45	70	62,3	31.5	34	HSK 32	4	180319	180318
20	65.1	62,3	31.5	34	HSK 32	6	180290	180291
45	70	62,3	31.5	34	HSK 32	6	180321 s	180320 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991	995121	173407
	[mm]		

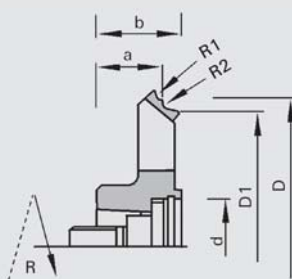
222512

DIAMAX Edge Rounding-Chamfering Cutters DP HSK 25R - Homag

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines Homag aggregate FF
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

R1	R2	Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
3	2	20	85	69	22.75	28	HSK 25R	4	179076 s	179077 s
[mm]	[mm]	[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

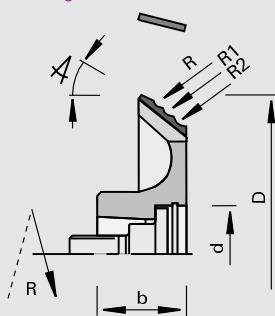
222812

Edge Rounding-Chamfering Cutters DP Multi HSK 25R - Homag FF

Product



Drawing

LEUCO
toplineLEUCO
i-system

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- Homag aggregate FF
- for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle with shear angle
- resharpenable area 1.0 mm

Advantages

- optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- optimized chip removal thanks to internal chip evacuation
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions
- Z = 4 for feed rate 20 - 30 m/min
- Z = 6 for feed rate 30 - 45 m/min
- machines must be equipped with i-system
- sense of rotation according to DIN-EN 50144

R	R1	R2	Chamfer \sphericalangle	$\varnothing D$	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
3,0	2,0		20	81.1	28	HSK 25R	4	180757	180758
3,0	2,0		20	81.1	28	HSK 25R	6	180759 s	180760 s
1,5	2,0	3,0	20	81.1	28	HSK 25R	4	180708 s	180709 s
1,5	2,0	3,0	20	81.1	28	HSK 25R	6	180763 s	180764 s
[mm]	[mm]	[mm]	[°]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

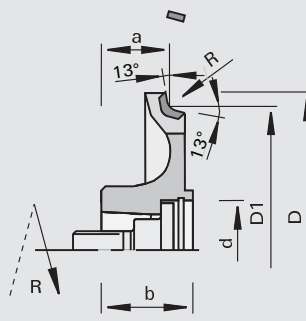
222812

Edge Rounding Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO
topline

LEUCO
i@system

polycrystalline diamond [DP]

MEC

Machine / Application

- | edge banding machines Homag aggregate FF
- | for chamfering of solid wood, veneer and plastic edge bands

Design

- | polished face
- | precise clearance angle
- | with shear angle
- | runout angle 13°

Advantages

- | optimum cutting quality thanks to high concentric accuracy and precise tool balancing
- | optimized chip removal thanks to internal chip evacuation
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | noise reduced

Notes

- | constant basic dimensions a and D1
- | Z = 4 for feed rate 20 - 30 m/min
- | Z = 6 for feed rate 30 - 45 m/min
- | machines must be equipped with i-system
- | sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	4	180542	180543
1,5	76	70	18.0	23	HSK 25R	4	180544	180545
2,0	76	70	18.5	23	HSK 25R	4	180546	180547
2,5	78	70	19.0	23	HSK 25R	4	180548 s	180549 s
3,0	78	70	19.5	23	HSK 25R	4	180550	180551
3,5	84	70	20.0	23	HSK 25R	4	180552 s	180553 s
4,0	84	70	20.5	23	HSK 25R	4	180554 s	180555 s
4,5	84	70	21.0	23	HSK 25R	4	180556 s	180557 s
5,0	84	70	21.5	23	HSK 25R	4	180558 s	180559 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	6	180560 s	180561 s
1,5	76	70	18.0	23	HSK 25R	6	180562	180563
2,0	76	70	18.5	23	HSK 25R	6	180564	180565
2,5	78	70	19.0	23	HSK 25R	6	180566 s	180567 s
3,0	78	70	19.5	23	HSK 25R	6	180568 s	180569 s
3,5	84	70	20.0	23	HSK 25R	6	180570 s	180571 s
4,0	84	70	20.5	23	HSK 25R	6	180572 s	180573 s
4,5	84	70	21.0	23	HSK 25R	6	180574 s	180575 s
5,0	84	70	21.5	23	HSK 25R	6	180576 s	180577 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

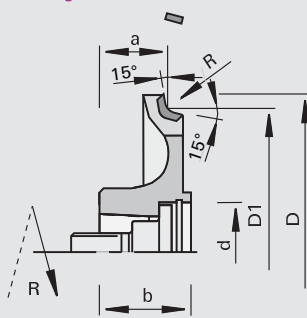
222812

Edge Rounding Cutters DP HSK 25R - IMA

Product



Drawing

LEUCO
toplineLEUCO
i-system

polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines IMA
l for chamfering of solid wood,
vener and plastic edge bands

Design

l polished face
l precise clearance angle
l with shear angle
l runout angle 15°

Advantages

l optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing
l optimized chip removal thanks
to internal chip evacuation
l less chips remain inside of the
machine
l no malfunctions due to chips
l reduction of suction power
l noise reduced

Notes

l constant basic dimensions a
and D1
l Z = 4 for feed rate 20 - 30 m/
min
l Z = 6 for feed rate 30 - 45 m/
min
l machines must be equipped
with i-system
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	4	184923	184924
1,3	76	70	17.8	23	HSK 25R	4	184927 s	184928 s
1,5	76	70	18.0	23	HSK 25R	4	184921	184922
2,0	76	70	18.5	23	HSK 25R	4	184919	184920
2,5	78	70	19.0	23	HSK 25R	4	184925 s	184926 s
3,0	78	70	19.5	23	HSK 25R	4	184917	184918
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

R	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
1,0	76	70	17.5	23	HSK 25R	6	184939 s	184940 s
1,3	76	70	17.8	23	HSK 25R	6	184937 s	184938 s
1,5	76	70	18.0	23	HSK 25R	6	184935 s	184936 s
2,0	76	70	18.5	23	HSK 25R	6	184933 s	184934 s
2,5	78	70	19.0	23	HSK 25R	6	184931 s	184932 s
3,0	78	70	19.5	23	HSK 25R	6	184929 s	184930 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

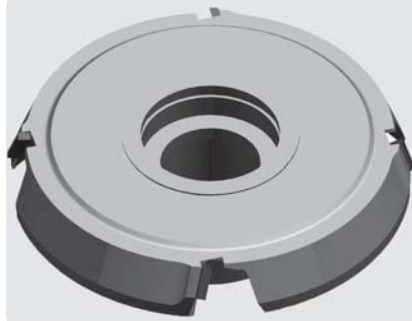
Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

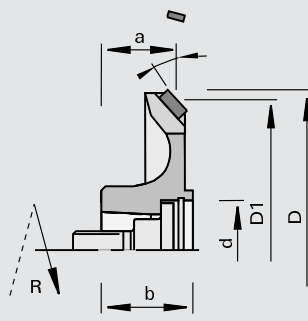
222812

Edge Chamfering Cutters DP HSK 25R - Homag FF, IMA

Product



Drawing



LEUCO
topline

LEUCO
i-system

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag aggregate FF, IMA
- for chamfering of solid wood,
veneer and plastic edge bands

Design

- polished face
- high-finish clearance angle
- with shear angle

Advantages

- optimum cutting quality thanks
to high concentric accuracy
and precise tool balancing
- optimized chip removal thanks
to internal chip evacuation
- less chips remain inside of the
machine
- no malfunctions due to chips
- reduction of suction power
- noise reduced

Notes

- constant basic dimensions a
and D1
- Z = 4 for feed rate 20 - 30 m/
min
- Z = 6 for feed rate 30 - 45 m/
min
- machines must be equipped
with i-system
- sense of rotation according to
DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
20	73	70	16.5	22.2	HSK 25R	4	180578	180579
45	73	70	17.5	22.2	HSK 25R	4	180580 s	180581 s
20	73	70	16.5	22.2	HSK 25R	6	180582 s	180583 s
45	73	70	17.5	22.2	HSK 25R	6	180584 s	180585 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

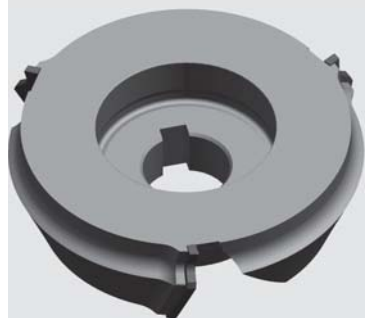
Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

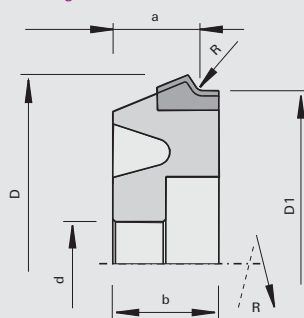
222812

Edge Rounding Cutters CM DP - Brandt

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt
for rounding of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area approx. 2
mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

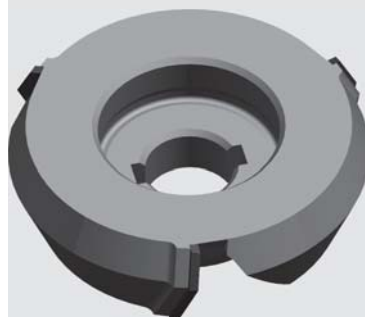
sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	70.57	65.08	17.8	20	16	3	5x2,3	183169 s	183168 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

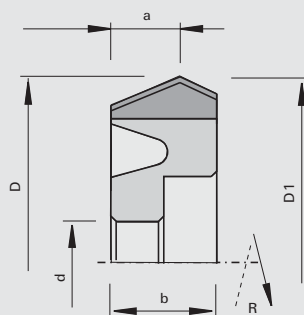
222812

Edge Chamfering Cutters CM DP - Brandt

Product



Drawing

LEUCO
toplineLEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

edge banding machines Brandt
for chamfering of solid wood,
veneer and plastic edge bands

Design

with shear angle
polished face and high-finish
clearance angle
resharpenable area approx. 2
mm
n max = 24.000 min-1

Advantages

optimized chip removal thanks
to ChipMeister version
less chips remain inside of the
machine
no malfunctions due to chips
reduced suction performance
low noise level

Notes

sense of rotation according to
DIN-EN 50144

Chamfer	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
45	70.6	69.98	13.07	20	16	3	5x2,3	183171 s	183170 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

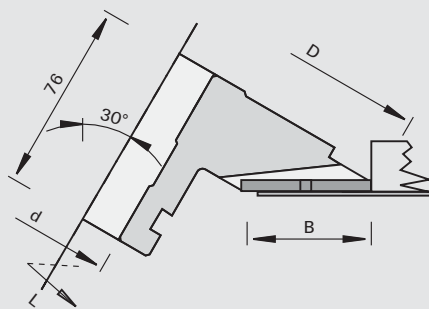
222022

Panel Raising Cutters DP Postforming - Homag, IMA

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag, IMA
l for panel raising during the direct postforming process

Design

l n max = 9,000 min-1

Advantages

Notes

l for use without inlay strip
l application with feed
l sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
200	44	76	35	4+4	10x4	180522 s	180523 s
200	54	76	35	4+4	10x4	180524 s	180525 s
[mm]	[mm]	[mm]	[mm]		[mm]		

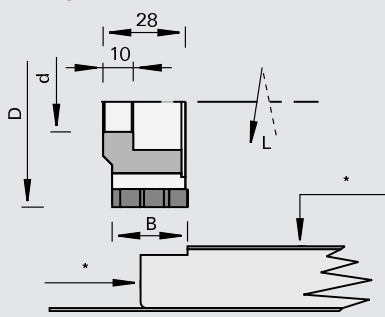
222020

Panel Raising Cutters DP Postforming - Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag
l for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design

l resharpenable area 3.5 mm
l inside edge Z = 9
l shear angle and extreme division of cutting pressure
l n max = 24,000 min-1

Advantages

l no need for extra scoring station

Notes

l with inlay profiles
l application with feed
l * tracing with copy wheel
l sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
70	25	10	20	9+3+3	6x2,8	179021 s	179022 s
[mm]	[mm]	[mm]	[mm]		[mm]		

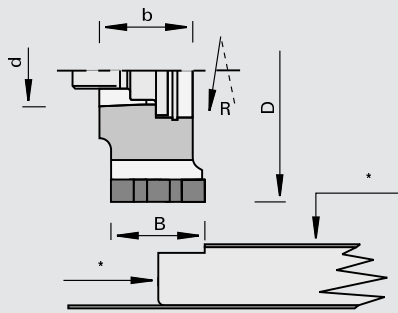
222020

Panel Raising Cutters DP HSK 25R Postforming for inlay profiles - Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag
l for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design

l resharpenable area 3.5 mm
l inside edge Z = 9 resp. Z = 12
l shear angle and extreme division of cutting pressure
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing
l no need for extra scoring station

Notes

l with inlay profiles
l application with feed
l * tracing with copy wheel
l sense of rotation see drawing

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No. [L]	Ident-No. [R]
70	25	28	HSK 25R	9+3+3	25	179020 s	179019 s
70	25	28	HSK 25R	12+6+6	35	180464 s	180463 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

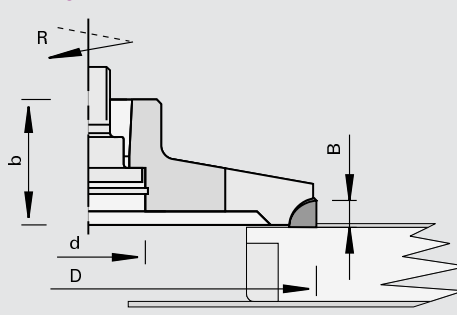
222020

Panel Raising Cutters DP HSK 25R Postforming for U and L profiles - Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l postforming machines Homag
l for panel raising during the direct postforming process

Design

l with shear angle
l resharpenable area 3.5 mm
l n max = 24,000 min-1

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l for panel raising of the U profile and flush-cutting of the L profile
l application against feed
l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
100	5	28	HSK 25R	4	177701 s	177702 s
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

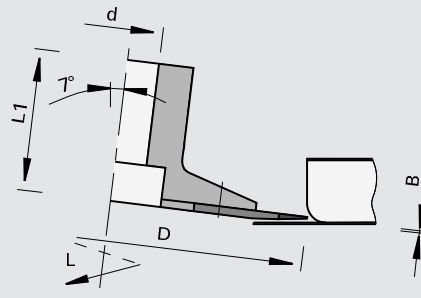
209080

Scribing Cutterheads DP Postforming - Homag, IMA

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | postforming machines Homag, IMA
- | for scribing of the radii during the postforming process

Design

- | exchangeable cutting edges
- | straight cutter axis
- | tooth configuration: symmetrical design for all radii
- | n max = 9,000 min-1

Advantages

Notes

- | for use without inlay strip
- | application against feed
- | LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
- | B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
- | sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	20	45	4	6x3	180073 &	180074 s
125	0,8	20	45	4	6x3	180955 &	180956 s
125	1,2	20	45	4	6x3	180830 &	180831 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts

	Class-No.	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	180063	180064
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	180959	180960 s
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	180834	180835 s
Countersunk Flat Headed Screws	995125		178722
Screwdrivers	985730		171188

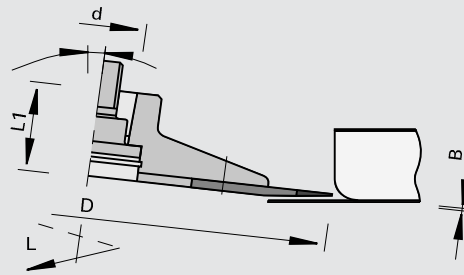
209080

Scribing Cutterheads DP HSK 25R Postforming - Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

postforming machines Homag
for scribing of the radii during the postforming process

Design

cutting edges parallel to cutter axis
tooth configuration: symmetrical design for all radii
n max = 9,000 min-1

Advantages

optimum cutting quality thanks to high concentric and runout accuracy and precise tool balancing

Notes

for use without inlay strip
application against feed
LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	HSK 25R	26	4		180075 &	180076 &
125	0,8	HSK 25R	26	4	6x3	180957 &	180958 s
125	1,2	HSK 25R	26	4		180832 &	180833 s
[mm]	[mm]	[mm]	[mm]		[mm]		

Spare parts

	Class-No.	Ident-No. [L]	Ident-No. [R]
LEUCODIA inserts "B" 0.5 mm with countersunk screws	232921	180063	180064
LEUCODIA inserts "B" 0.8 mm with countersunk screws	232921	180959	180960 s
LEUCODIA inserts "B" 1.2 mm with countersunk screws	232921	180834	180835 s
Screws	995190		177780
Shim Rings	995440		177781
Locking Rings	995460		177782
Countersunk Flat Headed Screws	995125		178722
Screwdrivers	985730		171188

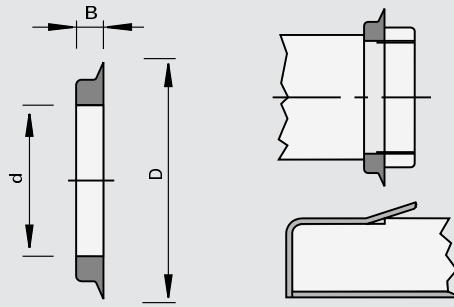
164507

Circular Knives solide carbide for edge trimming Softforming - Homag

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

I machines Homag
I for cutting of softforming inlay profiles

Design

I LEUCODUR solid carbide circular knife


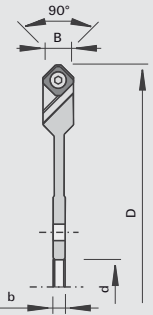

Advantages

Notes

$\varnothing D$	B	$\varnothing d$	Ident-No.
40	3	25	172757
[mm]	[mm]	[mm]	

120405

V-groove profile cutterheads HW for aluminum composite materials - HOLZ-HER

Product		Drawing		Notes		
				 tungsten carbide [HW] MAN		
Machine / Application		Design		Advantages		
<ul style="list-style-type: none"> vertical panel sizing saws for the production of facade elements, frames, corner elements from aluminum composite material, gutbond etc. 		<ul style="list-style-type: none"> anodized aluminum body cutting material: HL Solid 40 		<ul style="list-style-type: none"> consistent cutting circles thanks to turnover knives simple handling thanks to quick knife change 		
Ø D	B	b	Ø d	Z	Ident-No.	
244 [mm]	16,5 [mm]	6.5 [mm]	30 [mm]	8	182616	
Turnover Knives		B	H	S	Class-No.	Ident-No.
		14 [mm]	14 [mm]	2 [mm]	151514	182079
Spare parts		Dimension		Class-No.	Ident-No.	
Countersunk Flat Headed Screws		M5x9 T10 / T15 [mm]		995125	879309	

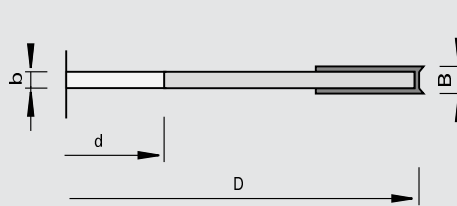
120455

Grooving Cutterheads HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free grooving in solid woods and in wood-based panels

Design

l n = 6,500 - 11,000 min-1

Advantages

Notes

l application against feed with and across the grain

Ø D	B	b	Ø d	Ø dmax	Z	Ident-No.
125	4	3	30	40	4+4	167253
125	5	4	30	40	4+4	165922
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

B

H

S

Class-No.

Ident-No.

Spurs

14

14

1.2

150559

163701

Turnover Knives

for B = 4

18

18

1.95

150508

163699

Turnover Knives

for B = 5

18

18

2.5

150508

165906

[mm]

[mm]

[mm]

Spare parts

Dimension

For Ident-No.

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M4x0,5x3,2 T9

167253

995125

163925

Countersunk Flat Headed Screws

M4x0,5x4,2 T9

165922

995125

165908

Special Nuts

M4x0,5x1,6

995290

163704

Special Nuts

M4x0,5x2,2

167253

995290

163703

Special Nuts

M4x0,5x2,75

165922

995290

165907

Screwdrivers

T9

985730

164344

[mm]

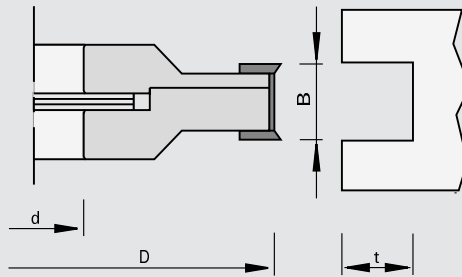
121455

Grooving Cutterheads HW - adjustable 4-15 mm

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | table shapers
- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

- | Ø 130 mm: n = 6,000 - 10,000 min-1
- | Ø 160 mm: n = 5,000 - 8,000 min-1
- | Ø 180 mm: n = 4,500 - 7,400 min-1

Advantages

Notes

- | application against feed with and across the grain
- | cutting width 4 - 7.5 mm two-piece
- | cutting width 4 - 15 mm three-piece
- | cutting width adjustable with shims in 0.1 mm increments
- | single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	Ident-No.
130	4 - 7,5	30	25	4+4		166509
180	4 - 7,5	30	35	8+4		168081
180	4 - 7,5	35	35	8+4	10x4	168083
180	4 - 7,5	40	35	8+4	12x5	168085 s
180	4 - 15	30	35	8+2+4		168080
180	4 - 15	35	35	8+2+4	10x4	168082 s
180	4 - 15	40	35	8+2+4	12x5	168084 s
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	1.2	150559	163701
Turnover Knives	7,6	12	1.5	150515	052543
Turnover Knives	18	18	1.95	150508	163699
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=7,2	168080, 168082, 168084	925300	168074
Set Screws	M5x12 DIN EN ISO 4028	168080, 168082, 168084	995161	050565
Counter Wedges	B=6,8	166509, 168083, 168085	925200	010751 #
Clamping Wedges	B=6,8	166509, 168083, 168085	925100	010750 #
Countersunk Flat Headed Screws	M4x0,5x3,2 T9	166509, 168081, 168083, 168085	995125	163925
Spacer Sets	50x3,5x30	166509	955521	166367
Spacer Sets	66x3,5x30	168080, 168081	955521	168075
Spacer Sets	70x3,5x35	168082, 168083	955521	168076
Spacer Sets	70x3,5x40	168084, 168085	955521	168077
Special Nuts	M4x0,5x1,6	166509, 168081, 168083, 168085	995290	163704
Special Nuts	M4x0,5x2,2	166509, 168081, 168083, 168085	995290	163703
Screwdrivers	T9	For all	985730	164344
Screwdrivers	SW2,5x100	For all	985730	168010
	[mm]			

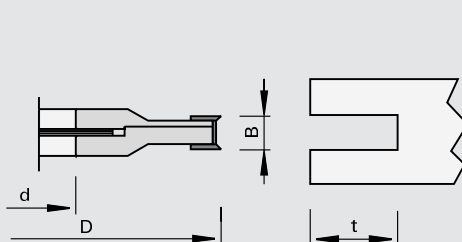
121455

Grooving Cutterheads HW - adjustable 8-24 mm

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | table shapers
- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

- | n = 4,500 - 7,400 min-1

Advantages

Notes

- | application against feed with and across the grain
- | cutting width 8 - 15 mm and 12,6 - 24 mm two-piece
- | cutting width adjustable with shims in 0.1 mm increments
- | single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	Ident-No.
180	8,0 - 15	30	35	4+4		178725
180	8,0 - 15	35	35	4+4	10x4	178726 &
180	8,0 - 15	40	35	4+4	12x5	178727 s
180	12,6 - 24	30	40	4+4		178729
180	12,6 - 24	35	40	4+4	10x4	178730 &
180	12,6 - 24	40	40	4+4	12x5	178731 s
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives

B	H	S
14	14	2
7,6	12	1.5
12	12	1.5
[mm]	[mm]	[mm]

Class-No.

Ident-No.

Spurs	150559	003079
Turnover Knives	150515	052543
Turnover Knives	150515	003080

Spare parts

Dimension

For Ident-No.

Class-No.

Ident-No.

Clamping Bars	B=10	178729, 178730, 178731	925300	164526
Clamping Bars	B=7,2	178725, 178726, 178727	925300	168074
Countersunk Flat Headed Screws	M5x6 T20	For all	995125	176199
Set Screws	M5x20 DIN EN ISO 4028	178725, 178726, 178727	995161	178741
Set Screws	M6x20 DIN EN ISO 4028	178729, 178730, 178731	995161	178742
Spacer Sets	66x11,5x30	178729	955521	167278
Spacer Sets	70x11,5x35	178730	955521	167279
Spacer Sets	70x11,5x40	178731	955521	167280
Spacer Sets	66x7x30	178725	955521	167282
Spacer Sets	70x7x35	178726	955521	167283
Spacer Sets	70x7x40	178727	955521	167284
Screwdrivers	SW3x100	178729, 178730, 178731	985730	166090
Screwdrivers	SW2,5x100	178725, 178726, 178727	985730	168010
Screwdrivers	T20x100	For all	985730	166092
Adjusting Gauges	0,3	For all	985200	055883
	[mm]			

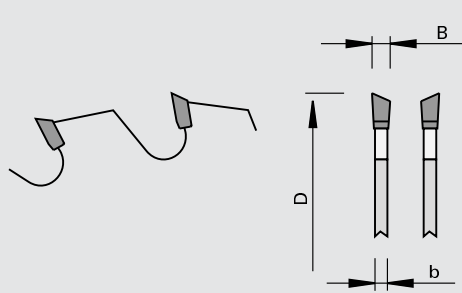
109085

Lamello Grooving Cutters HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

l machines Lamello, ELU
l for chip-free grooving of Lamello wood joints in solid woods and in wood-based panels

Design

Advantages

Notes

l application against feed with and across the grain

$\varnothing D$	B	b	$\varnothing d$	Z	NL	nmin-nmax		Ident-No.
100	4,0	3,45	22	6 WS	4/4,5/36	7600-13000	Lamello	189095
102	3,85	3,0	22	12 WS		7500-13100	ELU DS 140	188358
[mm]	[mm]	[mm]	[mm]			[min-1]		

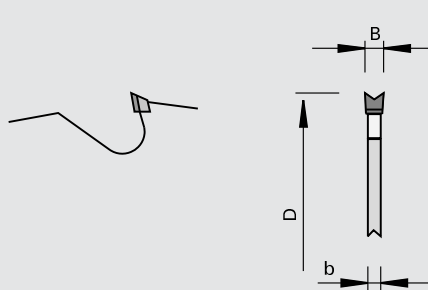
209285

Lamello Grooving Cutters DP

Product



Drawing

LEUCO
DIAMAX

polycrystalline diamond [DP]

MAN

Machine / Application

l machines Lamello
l for chip-free grooving of Lamello wood joints in solid woods and in wood-based panels

Design

Advantages

Notes

l reduced resharpenable area
l tooth configuration: concave
l n = 7,700 - 13,300 min-1

l application against feed with and across the grain

$\varnothing D$	B	b	$\varnothing d$	Z		Ident-No.
100	3,95	4	22	4		178496
[mm]	[mm]	[mm]	[mm]			

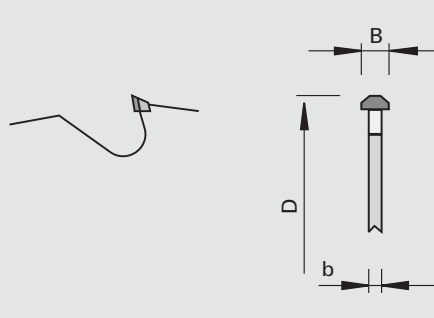
209285

Lamello Grooving Cutters DP - Clamex P

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MAN

Machine / Application

l CNC machining centers
l for chip-free grooving for Lamello Clamex P joints in solid woods and wood-based panels

Design

l not resharpenable
l tooth configuration: specific
l $n = 7.700 - 13.300 \text{ min}^{-1}$

Advantages

Notes

l application against feed with and across the grain
l can be used on CNC machines as a grooving cutter
l Mosquito Through-Hole Bits VHW for Lamello Clamex P see chapter Drill Bits

$\emptyset D$	B	b	$\emptyset d$	Z	NL		Ident-No.
100.4	7,0	4	30	3	4/6,6/48	for Lamello Clamex P	189711
[mm]	[mm]	[mm]	[mm]				

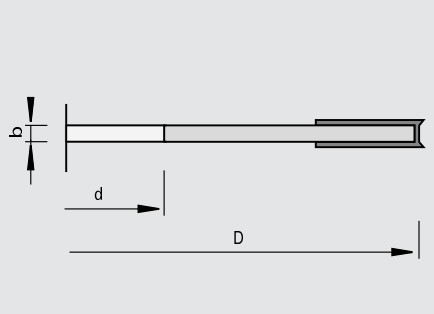
120455

Lamello Grooving Cutterheads HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

l machines Lamello
l for chip-free grooving of Lamello wood joints in solid woods and in wood-based panels

Design

l $n = 7,700 - 13,300 \text{ min}^{-1}$

Advantages

Notes

l application against feed with and across the grain

$\emptyset D$	B	b	$\emptyset d$	Z	NL		Ident-No.
100	4	4	22	4+4	4/4,5/36		164838
[mm]	[mm]	[mm]	[mm]				

Turnover Knives

	B	H	S
Spurs	14	14	1.2
Turnover Knives	18	18	1.95
	[mm]	[mm]	[mm]

Class-No.

Ident-No.

				150559	163701
				150508	163699

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws		M4x0,5x3,2 T9	995125	163925
Special Nuts	for profile knives	M4x0,5x2,2	995290	163703
Special Nuts	for spurs	M4x0,5x1,6	995290	163704
Screwdrivers		T9	985730	164344
		[mm]		

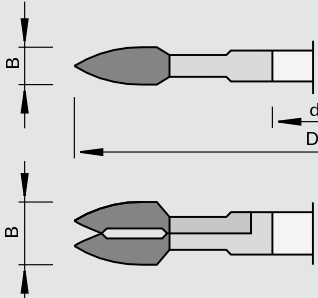
122415

Cutters HW for removing resin pockets

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

l Mini-Spot machines
l for cutting out defects in solid woods

Design

l with alternating shear angle
l n max = 12,000 min-1

Advantages

Notes

l for patch sizes 1-4

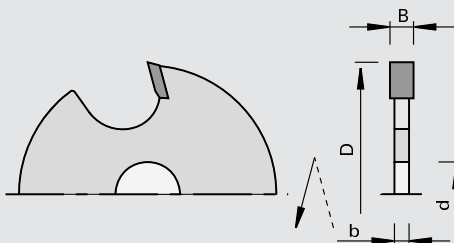
Ø D	B	Ø d	Z	NL	Ident-No.
100	8	22	4	4/4,3/36	180469
100	14	22	4		70176331 o
100	15	22	4		70176420 o
[mm]	[mm]	[mm]			

109015

Grooving Cutters HW - portable routers

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for grooving in solid woods and wood-based panels

Design

l two brazed flat-tooth cutting edges
l n max = 18,000 min-1

Advantages

Notes

l clamping elements: cutter arbor

Ø D	B	b	Ø d	Z	Ident-No.
40	1,8	1.0	8	2	001367
40	2,0	1.2	8	2	001370
40	2,5	1.5	8	2	001374
40	3,0	2.0	8	2	001377
40	3,5	2.5	8	2	001380
40	4,0	3.0	8	2	001383
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Arbors	8x8 [mm]	997200	160363
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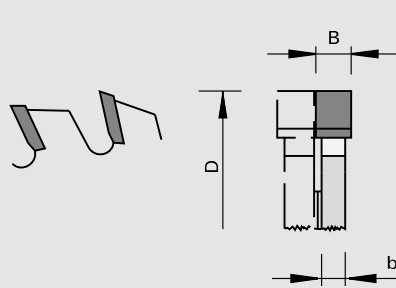
109015

Grooving Cutters HW - MAN

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

table shapers
for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- | application against feed with the grain (solid wood)
- | application with feed only with MEC (wood-based panels)
- | for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
- | groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	1,5	0.8	30	12	6100-10500	188359
125	1,8	1.0	30	12	6100-10500	188360
125	2,0	1.2	30	12	6100-10500	188361
125	2,2	1.2	30	12	6100-10500	188362
125	2,5	1.4	30	12	6100-10500	188363
125	3,0	2.0	30	12	6100-10500	188364
125	3,5	2.5	30	12	6100-10500	188365
125	4,0	2.5	30	12	6100-10500	188366
125	4,5	3.0	30	12	6100-10500	188367
125	5,0	4.0	30	12	6100-10500	188368
125	6,0	4.0	30	12	6100-10500	188369
125	7,0	5.0	30	12	6100-10500	188370
125	8,0	5.0	30	12	6100-10500	188371
125	10,0	6.0	30	12	6100-10500	188372
150	1,5	0.8	30	12	5200-8800	188373
150	2,0	1.2	30	12	5200-8800	188375
150	2,2	1.2	30	12	5200-8800	188376
150	2,5	1.5	30	12	5200-8800	188377
150	3,0	2.0	30	12	5200-8800	188378
150	3,5	2.5	30	12	5200-8800	188379
150	4,0	3.0	30	12	5200-8800	188380
150	4,5	3.5	30	12	5200-8800	188381
150	5,0	4.0	30	12	5200-8800	188382
150	6,0	4.0	30	12	5200-8800	188383
150	7,0	5.0	30	12	5200-8800	188384
150	8,0	5.0	30	12	5200-8800	188385
150	9,0	6.0	30	12	5200-8800	188386
150	10,0	6.0	30	12	5200-8800	188387
[mm]	[mm]	[mm]	[mm]		[min-1]	

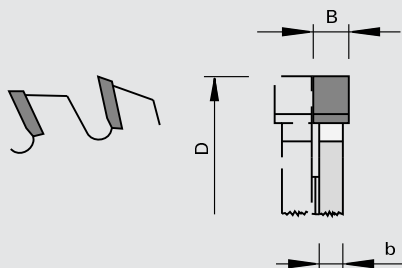
109010

Grooving Cutters HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- | for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
- | groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
150	4,0	3.0	30	12		12700	160802
150	5,0	4.0	30	12		12700	001434
150	6,0	4.0	30	12		12700	161617
150	7,0	5.0	30	12		12700	161619
150	8,0	5.0	30	12		12700	161620
150	10	6.0	30	12		12700	161622
150	5,0	4.0	35	12	10x4	12700	001435 &
150	10	6.0	35	12	10x4	12700	161623 &
150	1,5	0.8	35	18	10x4	12700	001447
150	1,8	1.0	35	18	10x4	12700	001448
150	2,0	1.2	35	18	10x4	12700	001449
150	2,2	1.2	35	18	10x4	12700	001450
150	2,5	1.5	35	18	10x4	12700	001451
150	3,0	2.0	35	18	10x4	12700	001452
150	4,0	3.0	35	18	10x4	12700	001453
150	5,0	4.0	35	18	10x4	12700	001454
150	6,0	4.0	35	18	10x4	12700	161627
150	8,0	5.0	35	18	10x4	12700	161628
150	4,0	3.0	30	24		12700	169689
150	5,0	4.0	30	24		12700	169688
150	6,0	4.0	30	24		12700	169687
150	4,0	3.0	30	48 WS		12700	160804
180	4,0	3.0	30	12		10300	001442
180	5,0	4.0	30	12		10300	001443
180	6,0	4.0	30	12		10300	161624
180	8,0	5.0	30	12		10300	161625
180	10	6.0	30	12		10300	161626
180	4,0	3.0	30	18		10600	169685
180	5,0	4.0	30	18		10600	169684
180	8,0	5.0	30	18		10600	169683
180	10,0	6.0	30	18		10600	169682
196	6,0	5.0	30	12 WS		9600	163836
200	4,0	2.8	30	24			1527332 o
200	4,5	2.8	30	24			1527333 o
200	5,0	2.8	30	24			1527334 o
200	5,5	2.8	30	24			1527335 o
200	6,0	2.8	30	24			1527336 o
200	6,5	2.8	30	24			1527337 o
200	7,0	5.0	30	24			1527339 o
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

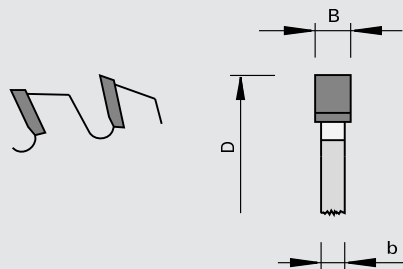
Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
200	7,5	5.0	30	24			1527340 o
200	8,0	5.0	30	24			1527341 o
200	8,5	5.0	30	24			1527342 o
200	9,0	5.0	30	24			1527343 o
200	9,5	5.0	30	24			1527344 o
200	10	5.0	30	24			1527345 o
220	4,0	3.0	30	30			1521934 o
220	4,5	3.0	30	30			1521935 o
220	5,0	3.0	30	30			1521936 o
220	5,5	3.0	30	30			1521937 o
220	6,0	3.0	30	30			1521938 o
220	6,5	3.0	30	30			1521939 o
220	7,0	5.0	30	30			1521941 o
220	7,5	5.0	30	30			1521942 o
220	8,0	5.0	30	30			1521943 o
220	8,5	5.0	30	30			1521944 o
220	9,0	5.0	30	30			1521945 o
220	9,5	5.0	30	30			1521946 o
220	10	5.0	30	30			1521947 o
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

109010

Grooving Cutters HW - CNC machining center

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

| CNC machining centers
 | for chip-free grooving in solid
 woods and in wood-based
 panels

Design

| positive hook angle
 | without shear angle
 | pin holes with countersink
 | tooth configuration: flat "F"
 | cutting material: HW
 | HL Board 06

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
100	3,2	2.2	30	20		Weeke 189571
100	4	3.0	30	20		Weeke 189647
100	5	3.0	30	20		Weeke 189260
120	4	3.0	35	30	4/6/50	Biesse, Felder Profit H22 189262
125	3,2	2.2	30	36	2 x 4/6, 1/48	Weeke 189306
125	4,0	3.0	30	36	2 x 4/6, 1/48	Weeke 189995
[mm]	[mm]	[mm]	[mm]			

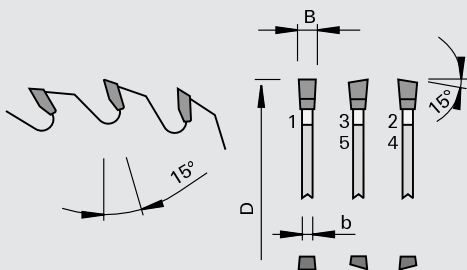
109080

Grooving Cutters "G5"

Product



Drawing

LEUCO
G5 systemLEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- l Weeke BHX series
- l CNC machining centers and aggregates
- l for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

- l tooth configuration: G5
- l cutting material: HW HL Board 03

Advantages

- l excellent cutting quality
- l especially low noise level
- l long edge lives also thanks to highly wear-resistant cutting material

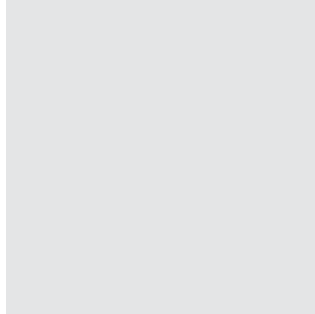
Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
100	4,0	2.8	30	35		Weeke BHX Series 050/055 189994
100	5,0	4.0	30	35		Weeke BHX Series 050/055 191947
120	4,0	2.8	20	35		191948
120	5,0	4.0	20	35		191949
120	4,0	2.8	20	35	3/4,5/35	SCM / Morbidelli 191950 &
120	5,0	4.0	20	35	3/4,5/35	SCM / Morbidelli 191951 &
120	4,0	2.8	35	35	4/6,3/50	Biesse 191952 &
120	5,0	4.0	35	35	4/6,3/50	Biesse 191953 &
125	4,0	2.8	30	35	2 x 4/5,5/48	Weeke BHX Series 500 and other BAZ, BOF m/c and aggregates 189993
125	5,0	4.0	30	35	2 x 4/5,5/48	Weeke BHX 500 series and other machining centers and aggregates 191946
[mm]	[mm]	[mm]	[mm]			

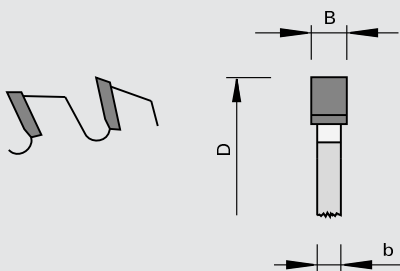
209010

Grooving Cutters DP - machining centers

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- l CNC machining centers
- l for chip-free grooving in solid woods and in wood-based panels

Design

- l positive hook angle
- l without shear angle
- l pin holes with countersink
- l tooth configuration: flat "F"

Advantages

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
125	3,2	2.2	30	36	4/6,1/48 + 4/6,1/48	Weeke 189649 s
125	4	3	30	36	4/6,1/48 + 4/6,1/48	Weeke 189648 s
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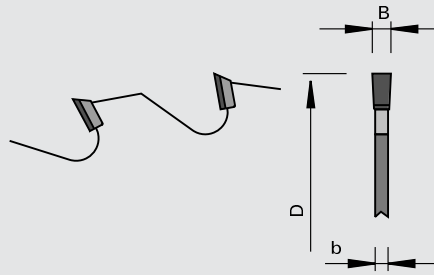
209010

Grooving Cutters DP

Product



Drawing

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge banding machines
- | for chip-free grooving in solid woods and in wood-based panels

Design

- | resharpenable area 3.5 mm
- | tooth configuration: flat
- | n max = 10,000 min-1

Advantages

Notes

- | application with feed
- | number of teeth depends on the feed rate, the material to be cut and the desired cutting quality

Ø D	B	b	Ø d	Z	DKN	Ident-No.
180	4	3	35	12	10x4	178194 s
180	4	3	35	18	10x4	178195 s
180	4	3	35	24	10x4	178196 s
180	5	4	35	18	10x4	178197 s
180	5	4	35	24	10x4	178198 s
180	6	5	35	12	10x4	178199 s
180	6	5	35	18	10x4	178200 s
180	6	5	35	24	10x4	178201 s
180	8	7	35	12	10x4	178202 s
180	8	7	35	18	10x4	178203 s
180	8	7	35	24	10x4	178204 s
180	5	4	35	12	10x4	178205 s
[mm]	[mm]	[mm]	[mm]		[mm]	

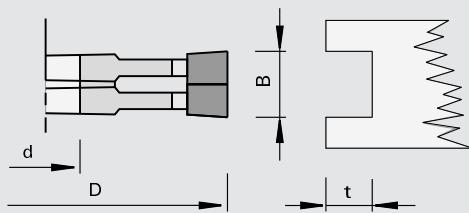
123455

Grooving Cutter Set HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | table shapers
- | molders
- | double end tenoners
- | for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- | application with and across the grain (solid wood)
- | cutting width adjustable with shims in 0.1 mm increments

Ø D	B	Ø d	Tmax	Z	KN	nmin-nmax	Ident-No.
120	1,8 - 3,4	30	18	4+4		6400-10000	006188
120	2,2 - 4,0	30	18	4+4		6400-10000	006189 s
150	4,0 - 7,5	30	37	4+4		5200-9000	006190 s
150	7,5 - 14,5	30	37	4+4		5200-9000	006191 s
150	4,0 - 7,5	35	30	4+4	10X4	5200-9000	006195 s
140	2,2 - 4,0	30	20	4+4		5400-9000	171136
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

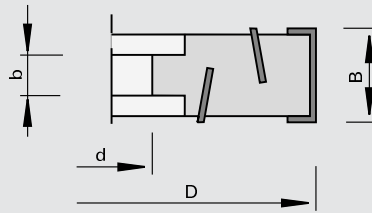
120215

Jointing Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free jointing of plastic-laminated panels

Design

l opposing shear angle
l cutting material: HW HL Board 05

Advantages

Notes

l application against feed with and across the grain

Ø D	B	b	Ø d	Z	DKN	nmin-nmax	Ident-No.
100	34	35	30	3+3	8x3	7700-13300	171972 s
125	56	54	30	3+3	8x3	6100-10500	177004
150	56	54	30	3+3	8x3	5200-8800	177006
180	56	25	35	3+3	10x4	4200-7200	177002
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives

B	H	S	Class-No.	Ident-No.
20	12	1.5	150515	003082
30	12	1.5	150515	003083
[mm]	[mm]	[mm]		

Spare parts

Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=17	171972	925300 167971
Pressure Jaws	28x11x6	177002, 177004, 177006	925300 180344
Clamping Parts	12x8,5/M6L	177002, 177004, 177006	925100 180356
Set Screws	M8x12 DIN EN ISO 4028	171972	995161 180001
Clamping Setscrews	M6/M6Lx18	177002, 177004, 177006	995161 180338
Screwdrivers	SW4x100	171972	985730 166091
Screwdrivers	T15x80	177002, 177004, 177006	985730 171188
[mm]			

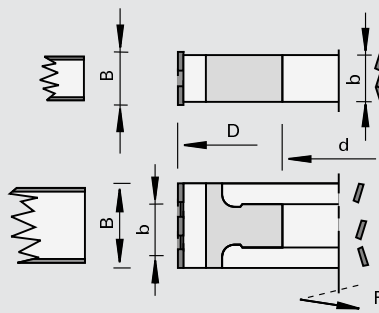
222220

DIAMAX Jointing Cutters DP LowNoise

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l through feed machines
l for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

l convex and non-convex design
l symmetrical and asymmetrical design
l for left and right hand rotation
l opposing shear angle
l spiral cutting edges
l resharpening area 1.5 mm

Advantages

l optimal glueing of edges
l optimized as to noise level and chip flow

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
60	64	62	25	2+2	8x3,3	31000	Felder/Format 4	asymmetrical	184651	184650
85	45	45	30	3+3	8x3,3	22000	Ott	asymmetrical	184647	184646
85	65	45	30	3+3	8x3,3	22000	Ott	asymmetrical	184649	184648
100	34	37.6	30	3+3	8x3,3	19000	IMA, Brandt	asymmetrical	184673	184672
100	45,5	61	30	2+2	8x3,3	19000	EBM / Hebrock	asymmetrical	184288	184287
100	48	25	25	2+2	8x3,3	19000	Brandt Ambition 1110 F (KDF 110), 1120 FC (KDF 120 C)	asymmetrical	185113	185112
100	48	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani	asymmetrical	184283	184284
100	48	40.6	30	3+3	8x3,3	19000	IMA, Brandt, SCM, Biesse	asymmetrical	184210	184211
100	63	39.5	30	2+2	8x3,3	19000	HOLZ-HER	asymmetrical	184279	184280
100	63	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	184212	184213
100	64	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani, EBM	asymmetrical	184281	184282
100	64	40.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	184285	184286
125	28	37.6	30	3+3	8x3,3	15000	Homag	symmetrical	184645	184645
125	36	40	30	3+3	8x3,3	15000	Homag	symmetrical	184752	184752
125	43	40	30	3+3	8x3,3	15000	Homag	symmetrical	184029	184029
125	43	40.6	30	3+3	8x3,3	15000	Homag, IMA aggregate 08.378	asymmetrical	184943	184944
125	43	57	30	3+3	8x3,3	15000	IMA aggregate 08.379	asymmetrical	184949	184950
125	63	40	30	3+3	8x3,3	15000	Homag	symmetrical	184030	184030
125	63	40.6	30	3+3	8x3,3	15000	IMA aggregate 08.378	asymmetrical	184945	184946
125	63	57	30	3+3	8x3,3	15000	IMA aggregate 08.379	asymmetrical	184951	184952
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	43	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184965 s	184966 s
125	43	70/30	3+3	15000	IMA aggregate 08.379 Hydro	asymmetrical	185115 s	185114 s
125	63	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184967 s	184968 s
125	63	70/30	3+3	15000	IMA aggregate 08.379 Hydro	asymmetrical	185117 s	185116 s
[mm]	[mm]	[mm]		[min-1]				

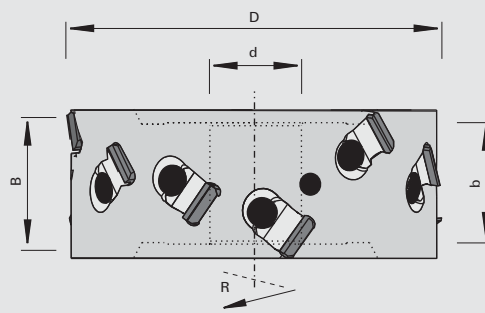
220220

DIAMAX SmartJoiner Jointing Cutterhead DP

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l edge banding machines
l for jump-milling units for the jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

l aluminum body
l symmetrical and asymmetrical design
l resharpening area 1,5 mm

Advantages

l low noise level
l low-weight design thanks to aluminum body
l exchangeable DP cutting edges incl. wear-resistant chip evacuation gap

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax			Ident-No. [L]	Ident-No. [R]
85	45	47	30	3+3	8x3,3	15500	Ott	asymmetrical	183911 s	183910 s
100	43,5	25	30	3+3	8x3,3	13000	HOLZ-HER, SCM	asymmetrical	183917	183916
100	43,5	40.6	30	3+3	8x3,3	13000	Brandt	asymmetrical	183915	183914
100	43,5	61	30	3+3	8x3,3	13000	EBM	asymmetrical	183913 s	183912 s
100	63	25	30	3+3	8x3,3	13000	HOLZ-HER, SCM	asymmetrical	183919	183918
100	65	40.6	30	3+3	8x3,3	13000	Brandt	asymmetrical	183923	183922
100	65	40.6	30	3+3	8x3,3	13000	SCM	asymmetrical	183925 s	183924 s
100	65	44	30	3+3	8x3,3	13000	Ott	asymmetrical	183921 s	183920 s
125	43	40.6	30	3+3	8x3,3	10500	Homag, IMA aggregate 08.378	asymmetrical	184957 s	184958 s
125	43	57	30	3+3	8x3,3	10500	IMA aggregate 08.378	asymmetrical	184983 s	184984 s
125	43,5	40	30	3+3	8x3,3	10500	Homag	symmetrical	183926	183926
125	43,5	40	30	3+3	8x3,3	10500	Homag	asymmetrical	183929 s	183928 s
125	63	40	30	3+3	8x3,3	10500	Homag	symmetrical	184708	184708
125	63	40.6	30	3+3	8x3,3	10500	IMA aggregate 08.378	asymmetrical	184959 s	184960 s
125	63	57	30	3+3	8x3,3	10500	IMA aggregate 08.379	asymmetrical	184985 s	184986 s
125	65	40	30	3+3	8x3,3	10500	Ott	asymmetrical	183931 s	183930 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax			Ident-No. [L]	Ident-No. [R]
125	43	70/30	3+3	10500	IMA aggregate 08.378 Hydro	asymmetrical	184973 s	184974 s
125	43	70/30	3+3	10500	IMA aggregate 08.379 Hydro	asymmetrical	185123 s	185122 s
125	63	70/30	3+3	10500	IMA aggregate 08.378 Hydro	asymmetrical	184975 s	184976 s
125	63	70/30	3+3	10500	IMA aggregate 08.379 Hydro	asymmetrical	185125 s	185124 s
[mm]	[mm]	[mm]		[min-1]				

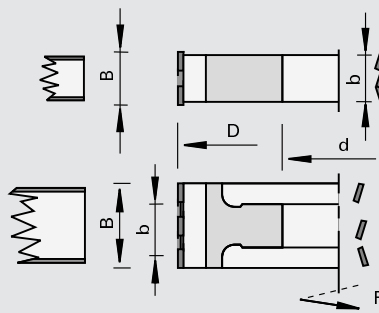
222220

DIAMAX Jointing Cutters CM DP - Biesse

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- crowned design
- symmetrical design
- applicable left and right
- opposing shear angle
- spiral cutting layout
- resharpenable area 1.5 mm

Advantages

- optimal glueing of edges
- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- low noise level

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [R]
80	32	53	30	3+3	8x3	23300	Biesse Akron 400	183694 s
80	45	53	30	3+3	8x3	23300	Biesse Akron 400	183695 s
80	65	53	30	3+3	8x3	23300	Biesse Akron 400	183696 s
100	45	75	30	3+3	8x3	18500	Biesse Akron 600/800	183697 s
100	65	75	30	3+3	8x3	18500	Biesse Akron 600/800	183698 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

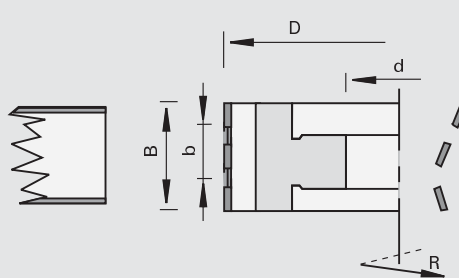
222220

DIAMAX Jointing Cutters CM DP- HOLZ-HER, Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- through feed machines HOLZ-HER
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- opposing shear angle
- spiral cutting edges
- resharpening area 1.5 mm

Advantages

- optimized chip removal thanks to ChipMeister version
- noise reduced

Notes

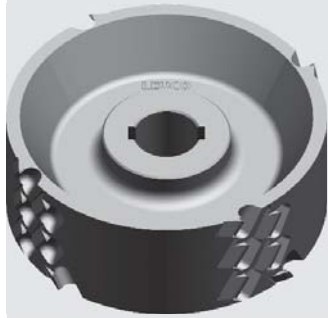
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
70	54	31	30	2	8x3,3	18000	HOLZ-HER aggregate 1801	182515	182514
70	48	41	30	2+2	8x3,3	18000	HOLZ-HER Arcus 1801	183073	183074
70	64	41	30	2+2	8x3,3	18000	HOLZ-HER Arcus 1801	183075	183076
100	48	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961 from 2008	182690 s	182691 s
100	53	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961	182173 s	182172 s
100	63	25	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1961 from 2008, Homag	182692	182693
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

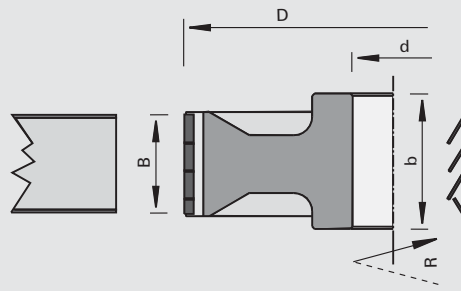
222220

DIAMAX Jointing Cutters CM DP - Homag

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l through feed machines Homag
l for chip-free jointing of melamine-, paper-, HPL-laminated and veneered panels

Design

l opposing shear angle
l spiral cutting edges
l resharpenable area 1.5 mm

Advantages

l high quality in the decor
l optimized chip removal thanks to ChipMeister version (with i-system jointing aggregate)
l noise reduced

Notes

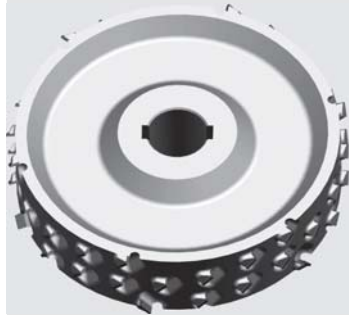
l application with or against feed
l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]
180	43	58.5	35	4+4	10x3,3	10000	181217 s	181216 s
180	63	58.5	35	4+4	10x3,3	10000	181261 s	181262 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

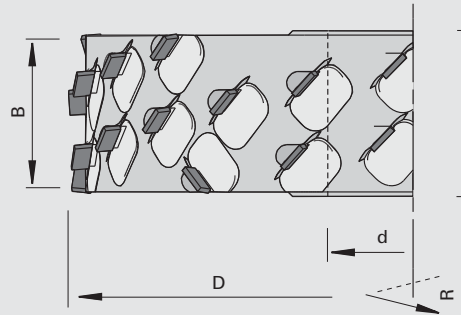
222020

Jointing Cutter CM DP - one-part

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

l double end tenoners
l edge banding machines
l for use on milling aggregates
l for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

l asymmetrical design
l large opposing shear angle
l resharpening area 4 mm

Advantages

l optimized chip removal thanks to ChipMeister version
l less chips remain inside of the machine
l no malfunctions due to chips
l reduction of suction power
l optimal glueing of edges
l excellent cutting quality even in the case of loose core
l suitable for laser edging

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]	
180	43	48	35	5+5	10x3,3	10000	asymmetrical	185065	185066
180	64,2	60	35	5+5	10x3,3	10000	asymmetrical	185067	185068
180	32,4	37	35	6+6	10x3,3	10000	asymmetrical	185131	185130
180	43	48	35	7+7	10x3,3	10000	asymmetrical	185047 s	185048 s
180	64,2	60	35	7+7	10x3,3	10000	asymmetrical	185049 s	185050 s
200	32,4	37	35	6+6	10x3,3	9000	asymmetrical	185133	185132
200	43	48	35	6+6	10x3,3	9000	asymmetrical	185069	185070
200	64,2	60	35	6+6	10x3,3	9000	asymmetrical	185051 s	185052 s
200	43	48	35	8+8	10x3,3	9000	asymmetrical	185053 s	185054 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
200	64,2	60	35	8+8	10x3,3	9000	asymmetrical	185055 s	185056 s
200	43	48	35	10+10	10x3,3	9000	asymmetrical	185057 s	185058 s
200	64,2	60	35	10+10	10x3,3	9000	asymmetrical	185059 s	185060 s
220	43	48	35	12+12	10x3,3	8500	asymmetrical	185061 s	185062 s
220	64,2	60	35	12+12	10x3,3	8500	asymmetrical	185063 s	185064 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

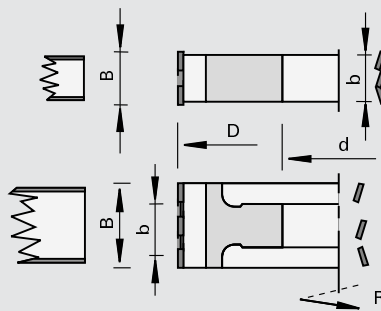
222120

DIAREX Jointing Cutters CM DP LowNoise

Product



Drawing



LOW

LEUCO DIAREX

polycrystalline diamond [DP]

MEC

Machine / Application

- edge banding machines
- for noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- symmetrical and asymmetrical design
- large opposing shear angle
- uneven cutting edge configuration
- resharpening area 3 mm

Advantages

- optimized chip removal thanks to ChipMeister version
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- optimal glueing of edges
- optimized as to noise level and chip flow
- excellent cutting quality even in the case of loose core
- suitable for laser-edge-technology

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]	
70	48,3	41	30	3+3	8x3,3	24000	HOLZ-HER	asymmetrical	184641 s	184642 s
70	64,2	41	30	3+3	8x3,3	24000	HOLZ-HER	asymmetrical	184643 s	184644 s
100	48,3	40	30	3+3	8x3,3	18000	Brandt, IMA, Biesse, SCM	asymmetrical	184637	184638
100	64,2	40.6	30	3+3	8x3,3	18000	Brandt, IMA, Biesse, SCM	asymmetrical	184639 s	184640 s
125	32,4	36.8	30	3+3	8x3,3	15000	Homag	symmetrical	184632	184632
125	43	40	30	3+3	8x3,3	15000	Homag	symmetrical	184633	184633
125	43	40.6	30	3+3	8x3,3	15000	Homag, IMA aggregate 08.378	asymmetrical	184955	184956
125	43	57	30	3+3	8x3,3	15000	IMA aggregate 08.379	asymmetrical	184981 s	184982 s
125	63	40	30	3+3	8x3,3	15000	Homag	symmetrical	184634	184634
125	63	40	30	3+3	8x3,3	15000	Homag	asymmetrical	184897	184898
125	64,2	40.6	30	3+3	8x3,3	15000	IMA aggregate 08.378	asymmetrical	184947	184948
125	64,2	57	30	3+3	8x3,3	15000	IMA aggregate 08.379	asymmetrical	184953	184954
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]				

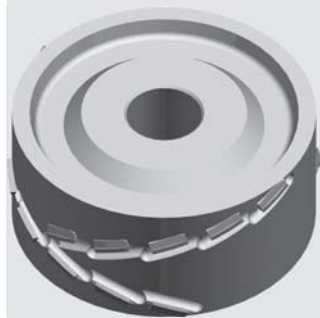
mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax		Ident-No. [L]	Ident-No. [R]	
125	43	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184969 s	184970 s
125	43	70/30	3+3	15000	IMA aggregate 08.379 Hydro	asymmetrical	185119 s	185118 s
125	64,2	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184971 s	184972 s
125	64,2	70/30	3+3	15000	IMA aggregate 08.379 Hydro	asymmetrical	185121 s	185120 s
[mm]	[mm]	[mm]		[min-1]				

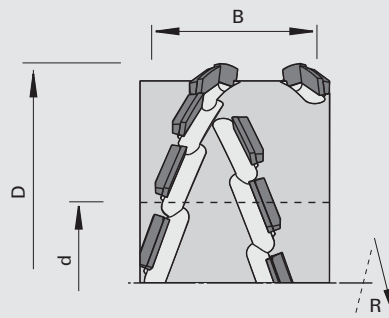
222226

DIAMAX p-System Jointing Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MAN

Machine / Application

- | table shaper
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical design
- | non-convex design
- | extremely scoring cut
- | resharpening area 1.5 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible

Notes

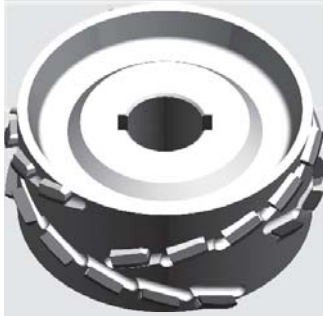
- | application against feed
- | recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- | crowned design on request
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Shear∠	nmin-nmax		Ident-No. [L]	Ident-No. [R]
125	28,2	35.2	30	2+2	70	6100-10500	symmetrical	184332	184332
125	47,8	54.8	30	2+2	70	6100-10500	symmetrical	184333	184333
125	28,2	35.2	30	3+3	70	6100-10500	symmetrical	184329	184329 s
125	47,8	54.8	30	3+3	70	6100-10500	symmetrical	184330	184330 s
[mm]	[mm]	[mm]	[mm]		[°]	[min-1]			

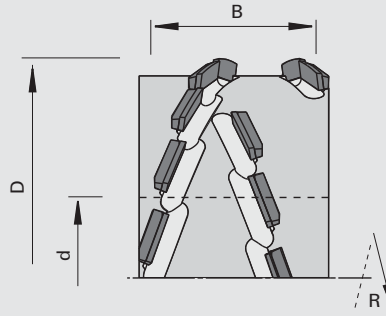
222324

p-System High-Performance Jointing Cutters CM DP - one part version

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | double end tenoners
- | edge banding machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical and asymmetrical design
- | extremely scoring cut
- | resharping area 4 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | perfectly suitable for laser-edge-technology

Notes

- | application against feed
- | recommended feed rate per tooth: wood-based panels 0.8 mm, solid wood 0.4 mm
- | crowned design on request
- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
70	47,8	41	30	3+3	8x3,3	27000	asymmetrical	184079 s	184078 s
100	42,9	40.6	30	3+3	8x3,3	19000	asymmetrical	184074 s	184073 s
100	62,5	40.6	30	3+3	8x3,3	19000	asymmetrical	184089 s	184075 s
100	62,5	40.6	30	3+3	8x3,3	19000	asymmetrical	184077 s	184076 s
125	42,9	40.6	30	3+3	8x3,3	15000	asymmetrical	184961 s	184962 s
							Homag, IMA aggregate 08.378		
125	42,9	57	30	3+3	8x3,3	15000	asymmetrical	184987 s	184988 s
							IMA aggregate 08.379		
125	47,8	40	30	3+3	8x3,3	15000	symmetrical	184071	184071
125	61,5	40	30	3+3	8x3,3	15000	quasi symmetrical	184328 s	184327 s
125	62,5	40.6	30	3+3	8x3,3	15000	asymmetrical	184963 s	184964 s
							IMA aggregate 08.378		
125	62,5	57	30	3+3	8x3,3	15000	asymmetrical	184989 s	184990 s
							IMA aggregate 08.379		
180	42,9	58.5	35	5+5	10x3,3	10000	quasi symmetrical	184085 s	184063 s
180	62,5	58.5	35	5+5	10x3,3	10000	quasi symmetrical	184086 s	184064 s
180	62,5	58.5	35	8+8	10x3,3	10000	quasi symmetrical	184087 s	184065 s
200	42,9	50	35	5+5	10x3,3	9000	quasi symmetrical	184088 s	184066 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

mounted on Hydro-Bushing Ident-No. 184310

Ø D	B	Ø d	Z	nmax		Ident-No. [L]	Ident-No. [R]	
125	42,9	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184977 s	184978 s
125	42,9	70/30	4+4	15000	IMA aggregate 08.379 Hydro	asymmetrical	185127 s	185126 s
125	62,5	70/30	3+3	15000	IMA aggregate 08.378 Hydro	asymmetrical	184979 s	184980 s
125	62,5	70/30	4+4	15000	IMA aggregate 08.379 Hydro	asymmetrical	185129 s	185128 s
[mm]	[mm]	[mm]		[min-1]				

mounted on Hydro-Bushing Ident-No. 172678

Ø D	B	Ø d	Z	nmax		Ident-No. [L]	Ident-No. [R]
200	42,9	60/40	8+8	9000	asymmetrical	184068 s	184067 s
200	62,5	60/40	8+8	9000	asymmetrical	184070 s	184069 s
[mm]	[mm]	[mm]		[min-1]			

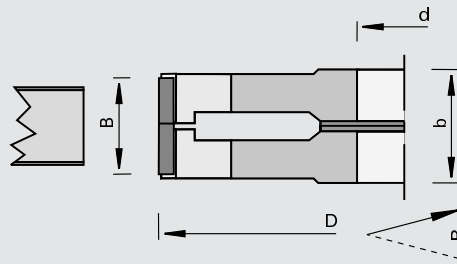
223020

Jointing Cutters DP

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

- resharpenable area 3.5 mm
- opposing shear angle
- Ø 150 mm: n max = 12,000 min-1 / Ø 200 mm: n max = 9,000 min-1
- two-part version with spacer rings

Advantages

- tool allows for 3 adjustments = four single edge lives between sharpenings

Notes

- the specified feed rates are based on Ø = 150 mm: n = 9,000 min-1 / Ø = 200 mm: n = 6,000 min-1
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	Recommended feed	Ident-No.
150	22 - 28	32	30	3+3	8x3	23	178798 s
200	22 - 28	32	35	4+4	10x4	20	178801 s
200	22 - 28	32	35	5+5	10x4	25	179073 s
200	22 - 28	32	35	6+6	10x4	30	178804
[mm]	[mm]	[mm]	[mm]		[mm]	[m/min]	

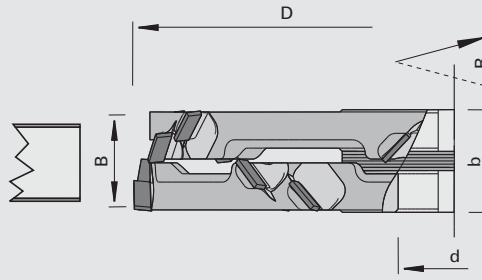
223020

Joining Cutter CM DP - two-part

Product



Drawing



LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

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

Design

- | symmetrical design
- | two-part adjustable via spacers
- | large opposing shear angle
- | resharpener area 4 mm

Advantages

- | tool allows for 3 adjustments = four single edge lives between sharpenings
- | optimized chip removal thanks to ChipMeister version
- | less chips remain inside of the machine
- | no malfunctions due to chips
- | reduction of suction power
- | optimal glueing of edges
- | excellent cutting quality even in the case of loose core
- | suitable for laser edging

Notes

- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
200	22 - 28	32	35	6+6	10x3,3	9000	symmetrical	185079	185079
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

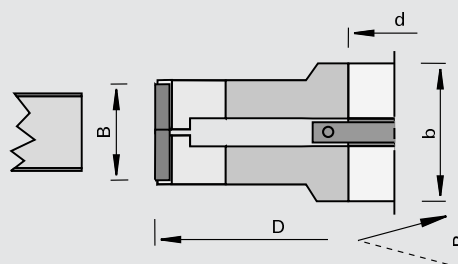
223020

Jointing Cutters DP progressively adjustable

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- double end tenoners with precision spindle (hexagon adapter)
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- resharpenable area 4.0 mm
- Ø 200 mm: n max = 9,000 min-1 / Ø 240 mm: n max = 6,000 min-1

Advantages

- clear increase of edge life thanks to concentric accuracy achieved by hydro clamping
- adjusting several times allows the addition of edge lives
- reduction of machine down-times thanks to of user-friendly adjustment device

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Recommended feed	Ident-No. [L]	Ident-No. [R]
200	22 - 28	101	40	2 x (4+4)	25	180099 s	180098 s
200	22 - 28	101	40	2 x (6+6)	35	180101 s	180100 s
200	22 - 28	101	40	2 x (8+8)	45	180103 s	180102 s
200	22 - 28	101	40	2 x (10+10)	55	180105 s	180104 s
240	22 - 28	101	40	2 x (12+12)	65	180107 s	180106 s
240	22 - 28	101	40	2 x (14+14)	80	180180 s	180179 s
[mm]	[mm]	[mm]	[mm]		[m/min]		

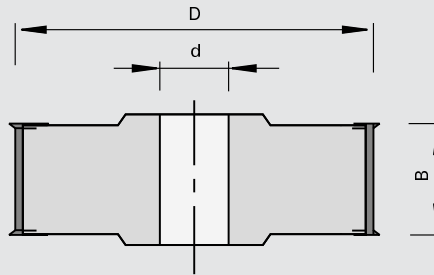
120265

Joining and Rabbeting Cutterheads HW with shear angle

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

table shapers
for chip-free joining and rabbeting in solid woods and wood-based panels

Design

with face shear angles from above and below
cutting material: HW HL Board 05
body made from high-quality light-metal alloy

Advantages

optimum cutting quality

Notes

application against feed

Ø D	B	Ø d	Z	n _{min} -n _{max}	Ident-No.
140 [mm]	60 [mm]	30 [mm]	4+4	5400-9400 [min ⁻¹]	179180

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	50 [mm]	12 [mm]	1.5 [mm]	150515	003085

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	6x11x48	925300	180346
Clamping Parts	12x8,5/M8L	925100	180357
Clamping Setscrews	M8x26 SW4	995161	180340
Countersink Screws	for spur M5x10,8 T15	995125	180840
Screwdrivers	SW4x100	985730	166091
Screwdrivers	T15x80 [mm]	985730	171188

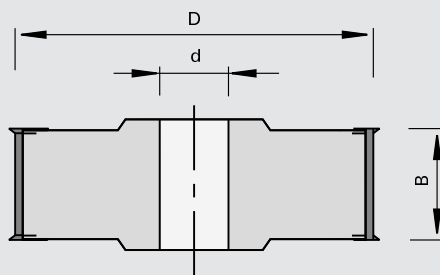
120255

Joining and Rabbeting Cutterheads HW without shear angle

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

table shapers
for joining and rabbeting in solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
cutting material: HW HL Board 05

Advantages

Notes

application against feed

Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
85	50	30	2+4		9000-15500	167038
100	30	30	2+4		7700-13300	167039 s
100	50	30	2+4		7700-13300	167040 s
125	30	30	2+4		6100-10500	167041
125	50	30	2+4		6100-10500	167043
125	50	35	2+4	10x4	6100-10500	167044 &
125	50	30	4+4		6100-10500	167046
125	50	35	4+4	10x4	6100-10500	167047 &
125	50	40	4+4	12x5	6100-10500	167048 &
[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	30	12	1.5	150515	003083
Turnover Knives	50	12	1.5	150515	003085
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=30	167039, 167041	925300	164185
Clamping Bars	B=48	167038, 167040, 167043, 167044, 167046, 167047, 167048	925300	166984
Set Screws	M6x12 DIN EN ISO 4028	167038, 167040	995161	180214
Set Screws	M6x16 SW3	167039, 167041, 167043, 167044, 167046, 167047, 167048	995161	001617
Countersink Screws	M5x10,8 T15	For all	995125	180840
Screwdrivers	SW3x100	For all	985730	166090
Screwdrivers	T15x100	For all	985730	180470
Adjusting Gauges	1,0 [mm]	For all	985200	011103

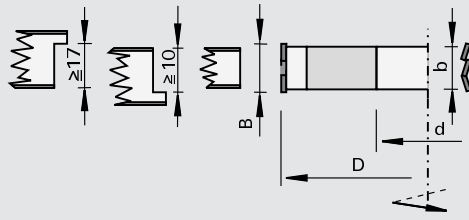
222225

DIAMAX Jointing / Rabbeting Cutters DP

Product



Drawing



polycrystalline diamond [DP]

MAN

Machine / Application

- table shapers
- machines Homag
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels

Design

- opposing shear angle
- resharpenable area 1.5 mm

Advantages

Notes

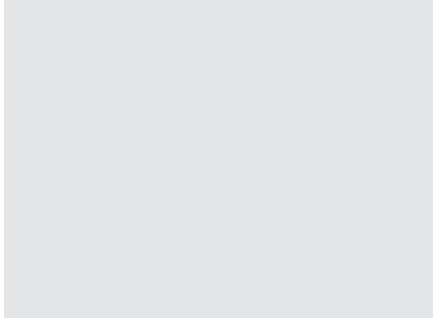
- application against feed
- sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
125	25	30	2+2	8x3	6100-10500	173710
125	25	50	2+2		6100-10500	173786 s
125	43	30	2+2	8x3	6100-10500	182704
[mm]	[mm]	[mm]		[mm]	[min-1]	

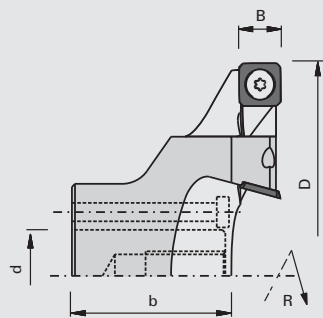
120200

Planing and Rabbeting Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design

- cutting material: HL Solid 25

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	DKN	Z	NL	nmax	Ident-No.
150	14	51.9	30	8x3,3	4	6/7/48	10100	182439 s
[mm]	[mm]	[mm]	[mm]	[mm]			[min-1]	

Turnover Knives

B	H	S
14	14	2
[mm]	[mm]	[mm]

Class-No.

150558

Ident-No.

180932

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M5x6 T20

995125

176199

Screwdrivers

T20x100


985730

166092

[mm]


128200

Planing and Rabbeting Cutterheads HW - mounted on arbor

Product		Drawing					 tungsten carbide [HW] MEC	
Machine / Application CNC routers for planing and rabbeting in wood-based panels		Design mounted on tool holder HSK 63 F		Advantages high milling performance when dressing the workbench boards, e.g. with Nesting-technology smooth surface thanks to special cutting edge geometry			Notes sense of rotation according to DIN-EN 50144	
$\varnothing D$	B	$\varnothing d$	L1	a	Z	nmax	Ident-No.	
150 [mm]	14 [mm]	HSK 63F [mm]	138 [mm]	113 [mm]	4	10100 [min-1]	182440 s	
Spare parts							Class-No.	Ident-No.
Mounting Arbors with HSK shank							933069	183748

220020

Planing and Rabbeting Cutters DP

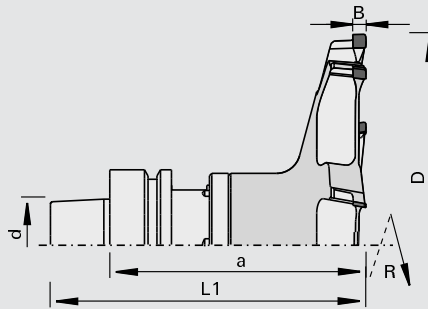
Product		Drawing					 polycrystalline diamond [DP] MEC	
Machine / Application CNC routers for planing, rabbeting and panel raising in wood-based panels		Design resharpening area 3.0 mm		Advantages high milling performance when dressing the workbench boards, e.g. with Nesting technology smooth surface thanks to special cutting edge geometry			Notes sense of rotation according to DIN-EN 50144	
$\varnothing D$	B	b	$\varnothing d$	Z	nmax	Ident-No.		
150 [mm]	5,6 [mm]	55 [mm]	30 [mm]	8	12700 [min-1]	182662 s		
180 [mm]	5,6 [mm]	58 [mm]	30 [mm]	8	10300 [min-1]	182426 s		

229020

Planing and Rabbeting Cutterheads HW - mounted on arbor

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for planing and rabbeting in wood-based panels

Design

- mounted on tool holder HSK 63 F
- resharpenable area 3.0 mm

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting-technology
- smooth surface thanks to special cutting edge geometry

Notes

- sense of rotation according to DIN-EN 50144

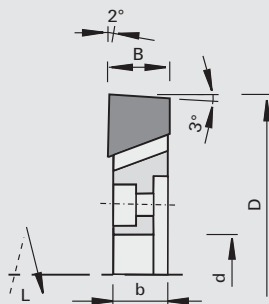
Ø D	B	Ø d	L1	a	Z	nmax	Ident-No.
150	5,6	HSK 63F	128	103	8	12700	182661 s
180	5,6	HSK 63F	128	103	8	10300	182425 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

122200

Corner Notching Cutter HW - Homag

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- CNC machining centers Homag / aggregate 7547
- for sharp-edged cutting out of inside corners

Design

- n max = 24.000 min-1

Advantages

Notes

- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No.
75	15	13	16	4	182457
[mm]	[mm]	[mm]	[mm]		

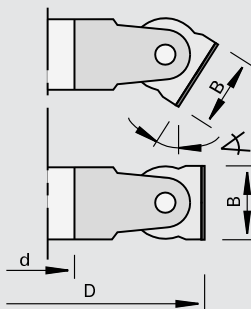
120305

Pivoting Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

table shapers
for chamfering, jointing and rabbeting with adjustable chamfer angle in solid woods and in veneered and plastic-coated panels

Design

cutting edges parallel to cutter axis
cutting material: HW HL Board 05

Advantages

Notes

application against feed
rabbeting with additional spur
pivot range up to 60 degree
Ø 120 mm chamfer angle adjustable from 5 degree to 5 degree
Ø 150 mm chamfer angle adjustable from 1 degree to 1 degree

Ø D	B	Ø d	Z	nmin-nmax	Ident-No. top
120	40	30	2	6400-11000	179184 s
150	50	30	2	5200-9000	179185
150	50	40	2	5200-9000	180903
160	50	50	2	4800-8000	180904
[mm]	[mm]	[mm]		[min-1]	

Pre-scoring discs	Ø D	B	Ø d	Z	Class-No.	Ident-No.
	150	8	30	2	120255	179182 s
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	40	12	1.5	150515	164078
Turnover Knives	50	12	1.5	150515	003085
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=40	925300	50930125 s
Clamping Bars	B=50	925300	50930124
Screws for spurs	M5x6,8 T15	995125	180839
Set Screws	M6x16 SW3	995161	001617
Screwdrivers	SW3x100	985730	166090
Cranked Wrench Keys	SW6 DIN ISO 2936	985730	009675
	[mm]		

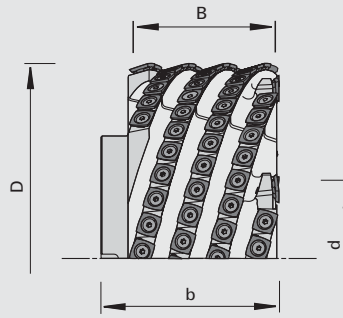
120281

Joining / Rabbeting Cutterheads HW

Product



Drawing



LEUCO
P-system

tungsten carbide [HW]

MEC

Machine / Application

- | machine
- | EWD FR15, FR16
- | for milling of corners

Design

- | one part and segmented
- | turnover knives can be used on all four sides
- | extremely scoring cut
- | cutting material: HW HL Solid 20

Advantages

- | no chippings due to knots
- | considerable improvement of surface quality compared to the existing chipping knives
- | small chips suitable for pellet production
- | extremely long edge lives (up to 8 million running meters)

Notes

- | chips are not suitable for paper industry
- | feed rate per tooth $f_z = 2-8$ mm

Ø D	B	b	Ø d	Z	Shear∠	
360	139,5	164	110	8+8	70	vertical axis top
360	139,5	164	110	8+8	70	vertical axis bottom
360	64	164	60	4+4	70	horizontal axis right
360	64	164	60	4+4	70	horizontal axis left
360	64	164	60	5+5	70	horizontal axis right
360	64	164	60	5+5	70	horizontal axis left
360	64	164	60	8+8	70	horizontal axis right
360	64	164	60	8+8	70	horizontal axis left
360	89,2	164	60	6+6	70	horizontal axis right
360	89,2	164	60	6+6	70	horizontal axis left
[mm]	[mm]	[mm]	[mm]		[°]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
	21	21	5.5	151517	184786
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M7x16,8	995125	50930305
Head Cap Screws	M14x60 ISO 4762	995111	185008
Head Cap Screws	M14x80 DIN 4762	995111	185181
Conical Screws	M6x10 D7.8x20GRD	995191	184891
	[mm]		

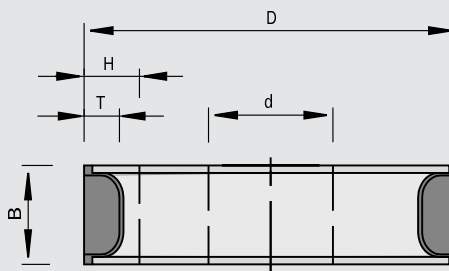
120607

SuperProfiler HW (inside profile) - MAN

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- table shapers
- for planing and profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- $n = 6.200 - 10.700 \text{ min}^{-1}$
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- application against feed
- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

$\emptyset D$	B	$\emptyset d$	$\emptyset d_{max}$	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 1	167263
125	60	30	35	15	2	SP 2	167264
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28,2	HL Board 06	SP 1	152526	179112
SP blanks	40,6	28,2	HL Solid 60	SP 1	152529	177367
SP blanks	60,8	30,2	HL Board 06	SP 2	152526	179113
SP blanks	60,8	30,2	HL Solid 60	SP 2	152529	177368
support plates	40	28		SP 1	925402	178007
support plates	60	30		SP 2	925402	178008
deflector plates	40	28		SP 1	925407	167267
deflector plates	60	30		SP 2	925407	167268
	[mm]	[mm]				

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	36x12x8	167263	925300	166737
Clamping Bars	58x12x8	167264	925300	166738
Special Set Screws	M8x24		995191	167269
Screwdrivers	SW4x100		985730	166091
	[mm]			

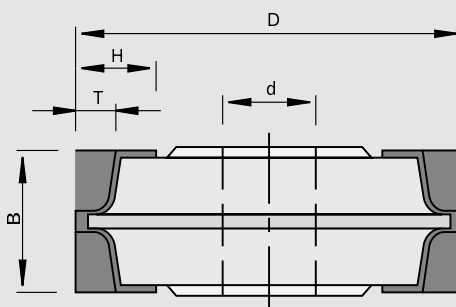
120607

SuperProfiler HW (outside profile) - MAN

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | n = 6.200 - 10,700 min-1
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | application against feed
- | profile knife can be profiled per customer specifications
- | included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 3	167897 s
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

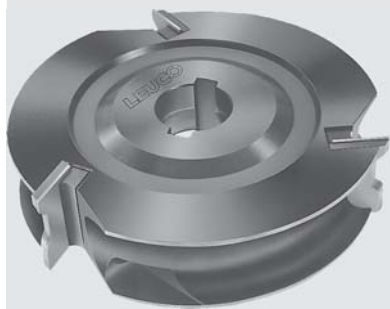
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 3	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 3	152529	177367
support plates	40	28		SP 3	925402	178011
deflector plates	40	28		SP 3	925407	167898
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	36x12x8	925300	166737
Special Set Screws	M8x24	995191	167269
Screwdrivers	SW4x100	985730	166091
	[mm]		

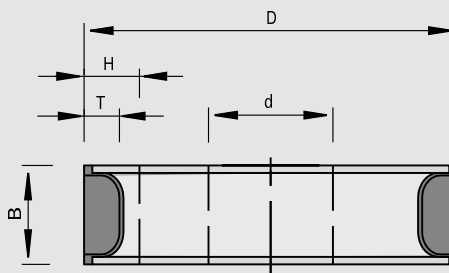
120602

SuperProfiler HW (inside profile) - MEC

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | double end tenoners
- | molders
- | profiling unit and length processing unit IMA
- | for profiling of solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | profile knife can be profiled per customer specifications
- | included in delivery: cutterhead with clamping elements, without profile knives and support plates

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	nmax	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	8x3	12000	SP 7	167439
125	40	31,75	35	13	2		12000	SP 7	167440 s
125	60	31,75	35	15	2		12000	SP 5	167442 s
150	40	30	50	13	3	8x3	10000	SP 7	166971
150	40	31,75	50	13	3		10000	SP 7	176184 s
150	40	35	50	13	3	10x4	10000	SP 7	166972
150	40	40	50	13	3	12x5	10000	SP 7	166973
150	60	30	50	15	3	8x3	10000	SP 5	166975
150	60	40	50	15	3	12x5	10000	SP 5	166977
150	60	31,75	35	25	3		7200	SP 4	176230
165	40	30	50	20	3	8x3	8500	SP 33	176088
180	40	35	50	13	3	10x4	8000	SP 7	166720
180	40	40	50	13	3	12x5	8000	SP 7	166721
180	60	35	50	15	3	10x4	8000	SP 5	166723
180	60	40	50	15	3	12x5	8000	SP 5	166724
180	60	31,75	50	25	3		6000	SP 4	168127
180	60	50	50	25	3		6000	SP 4	168131
180	80	40	50	25	3	12x5	6000	SP 6	167993
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 7	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 7	152529	177367
SP blanks	60,8	30.2	HL Board 06	SP 5	152526	179113
SP blanks	60,8	30.2	HL Solid 60	SP 5	152529	177368
SP blanks	40,6	40.6	HL Board 06	SP 33	152526	179115
SP blanks	40,6	40.6	HL Solid 60	SP 33	152529	178844
SP blanks	60,6	45.6	HL Board 06	SP 4	152526	179999
SP blanks	60,6	45.6	HL Solid 60	SP 4	152529	178845
SP blanks	80,6	45.6	HL Board 06	SP 6	152526	180016
SP blanks	80,6	45.6	HL Solid 60	SP 6	152529	180017
support plates	40	28		SP 7	925402	178007
support plates	40	40		SP 33	925402	178006
support plates	60	30		SP 5	925402	178008
support plates	60	45		SP 4	925402	178009
support plates	80	45		SP 6	925402	178013
	[mm]	[mm]				

Spare parts	Dimension	For drawing/foil	Class-No.	Ident-No.
Clamping Bars	36x12x8	SP 7	925300	166737
Clamping Bars	36x14x8	SP 33	925300	176096
Clamping Bars	56x12x8	SP 4	925300	167055
Clamping Bars	58x12x8	SP 5	925300	166738
Clamping Bars	76x15x8	SP 6	925300	167989
Set Screws	M8x20 DIN EN ISO 4028		995161	001625
Screwdrivers	SW4x100		985730	166091
	[mm]			

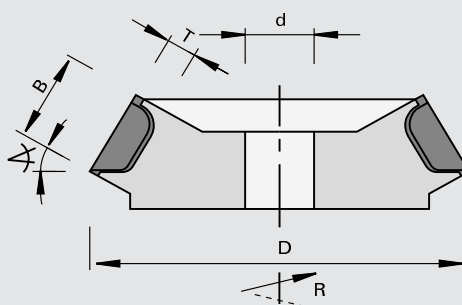
120622

SuperProfiler HW (outside profile) - MEC

Product



Drawing



**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- double end tenoners
- molders
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- profile knife can be profiled per customer specifications
- included in delivery: cutterhead with clamping elements, without profile knives and support plates
- sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	Crank∠	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
165	40	30	40	13	3	8x3	30	9000	SP 13	167967 s	167968 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 12 / 13	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 12 / 13	152529	177367
support plates	40	28		SP 12 / 13	925402	178007
	[mm]	[mm]				

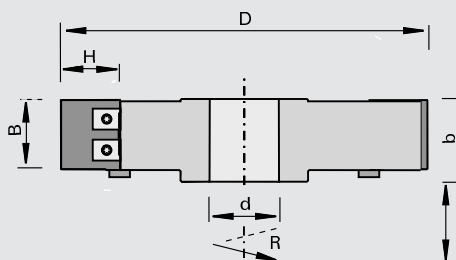
Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	36x12x8	left	925300
Clamping Bars	36x12x8	right	925300
Set Screws	M8x20 DIN EN ISO 4028		995161
Screwdrivers	SW4x100		985730
	[mm]		

120603

EcoPro Cutterheads HW (straight) - MAN

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | special aluminum cutterhead body
- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead body and knives will be profiled according to customer specifications

Notes

- | profile knives can be profiled according to customer specifications
- | cutterhead body can be used only for one profile
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	b	Ø d	Ø dmax	Z	nmin-nmax	EP-No.	Drawing	Ident-No. unprofiled
125	30	30	36	30	30	3	7700-10480	50	EP 382	179050 s
125	40	30	46	30	30	3	7700-9480	51	EP 384	179051 s
125	50	33	56	30	30	3	7700-8420	52	EP 386	179052 s
150	30	30	36	30	50	3	6200-9620	53	EP 382	179053 s
150	40	30	46	30	50	3	6200-8420	54	EP 384	179054 s
150	50	33	56	30	50	3	6200-7300	55	EP 386	179055 s
180	30	30	36	30	50	4	4800-8600	56	EP 382	179056 s
180	40	30	46	30	50	4	4800-7520	57	EP 384	179057 s
180	50	33	56	30	50	4	5200-6500	58	EP 386	179058 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No. [L]	Ident-No. [R]
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Board 06	EP 382	152586		178528
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Solid 60	EP 382	152589		179528
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Board 06	EP 384	152586		178534
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Solid 60	EP 384	152589		179534
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06	EP 386	152586		178540
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60	EP 386	152589		179540
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Board 06 Topline	EP 382	152786	179585 &	179586 &
179050, 179053, 179056, 179087, 179090, 179093, 179094	30,2	30,4	HL Solid 60 Topline	EP 382	152789	179659 &	179660 &
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30,4	HL Board 06 Topline	EP 384	152786	179597 &	179598 &
	[mm]	[mm]					

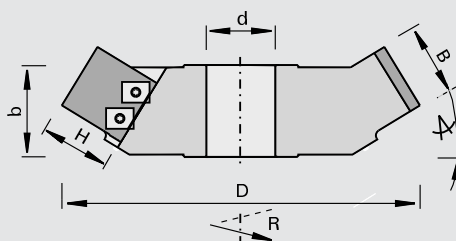
Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No. [L]	Ident-No. [R]
179051, 179054, 179057, 179088, 179091, 179095, 179096	40,1	30.4	HL Solid 60 Topline	EP 384	152789	179671 &	179672 &
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Board 06 Topline	EP 386	152786	179609 &	179610 &
179052, 179055, 179058, 179089, 179092, 179097, 179098	49,9	33	HL Solid 60 Topline	EP 386	152789	179683 &	179684 &
	[mm]	[mm]					
Spare parts	Dimension			Class-No.	Ident-No.		
Screws	M4,5x4,6x9 T15			995195	178239		
Screwdrivers	T15x80			985730	171188		
	[mm]						

120613 EcoPro Cutterheads HW (cranked) - MAN

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | with shear angle
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead body and knives will be profiled according to customer specifications

Notes

- | profile knives can be profiled according to customer specifications
- | cutterhead body can be used only for one profile
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	b	Ø d	Ø dmax	Z	Crank∠	nmin-nmax	EP-No.	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
150	40	30	49	30	30	3	30	6300-7460	59	EP 390	179350 s	179059 s
180	40	30	50	30	50	4	30	5000-6580	61	EP 390	179355 s	179061 s
180	50	33	57	30	50	4	30	5000-5700	62	EP 392	179358 s	179062 s
165	40	30	46	30	30	3	45	5300-6920	63	EP 396	179360 s	179063 s
165	50	33	53	30	30	3	45	4600-6040	64	EP 398	179362 s	179064 s
195	40	30	46	30	50	4	45	5300-6160	65	EP 396	179365 s	179065 s
195	50	33	53	30	50	4	45	4600-5320	66	EP 398	179368 s	179066 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[min-1]		[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30.4	HL Board 06	EP 390, EP 396	152586		178534
	[mm]	[mm]					

Blanks for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30,4	HL Solid 60	EP 390, EP 396	152589		179534
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Board 06	EP 392 / 398	152586		178540
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110, 179351, 179352, 179356, 179357, 179358, 179361, 179362, 179366, 179367, 179368	49,9	33	HL Solid 60	EP 392 / 398	152589		179540
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30,4	HL Board 06 Topline	EP 390, EP 396	152786	179597 &	179598 &
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108	40,1	30,4	HL Solid 60 Topline	EP 390, EP 396	152789	179671 &	179672 &
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Board 06 Topline	EP 392 / 398	152786	179609 &	179610 &
179060, 179062, 179064, 179066, 179100, 179103, 179104, 179106, 179109, 179110	49,9	33	HL Solid 60 Topline	EP 392 / 398	152789	179683 &	179684 &
	[mm]	[mm]					
Spare parts			Dimension		Class-No.	Ident-No.	
Screws			M4,5x4,6x9 T15		995195	178239	
Screwdrivers			T15x80		985730	171188	
			[mm]				

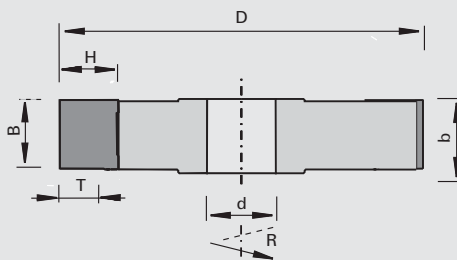
120604/120606

UltraProfiler-Messerköpfe HW (straight) - MAN

Product



Drawing



LEUCO
ultraprofiler

tungsten carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | cutterhead body made from extremely tight aluminum alloy
- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- | large profile depths possible
- | cutterhead body and knives will be profiled according to customer specifications

Notes

- | knives in Topline Plus design (polished face, precise clearance angle)
- | sense of rotation according to DIN-EN 50144

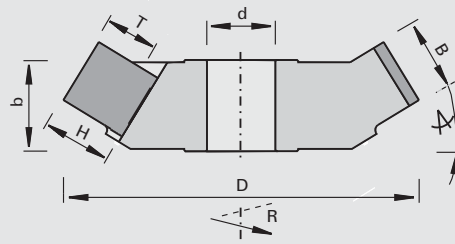
Ø D	B	H	Ø d	Ø dmax	T	Z	nmax
125	32	35	30	30	16	2	12000
125	32	35	30	30	16	3	12000
125	40	35	30	30	16	2	10500
125	40	35	30	30	16	3	10500
125	50	35	30	30	16	2	9500
125	50	35	30	30	16	3	9500
125	60	35	30	30	16	2	7200
125	60	35	30	30	16	3	7200
150	32	40	30	50	21	2	9000
150	32	40	30	50	21	3	9000
150	40	40	30	50	21	2	8000
150	40	40	30	50	21	3	8000
150	50	40	30	50	21	2	7500
150	50	40	30	50	21	3	7500
150	60	40	30	50	21	2	6500
150	60	40	30	50	21	3	6500
180	32	40	30	50	21	2	8500
180	32	40	30	50	21	3	8500
180	32	40	30	50	21	4	8500
180	40	40	30	50	21	2	7500
180	40	40	30	50	21	3	7500
180	40	40	30	50	21	4	7500
180	50	40	30	50	21	2	6500
180	50	40	30	50	21	3	6500
180	50	40	30	50	21	4	6500
180	60	40	30	50	21	2	6000
180	60	40	30	50	21	3	6000
180	60	40	30	50	21	4	6000
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

120614/120616

UltraProfilier-Messerköpfe HW (cranked) - MAN

Product

Drawing



LEUCO
ultraprofilier

tungsten carbide [HW]

MAN

Machine / Application

- | machining centers
- | double end tenoners
- | molders
- | table shapers
- | for profiling of solid woods and wood-based panels

Design

- | cutterhead body made from extremely tight aluminum alloy
- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

- | large profile depths possible
- | cutterhead body and knives will be profiled according to customer specifications

Notes

- | knives in Topline Plus design (polished face, precise clearance angle)
- | sense of rotation according to DIN-EN 50144

Ø D	B	H	Ø d	Ø dmax	T	Z	Crank◁	nmax
150	32	35	30	30	16	2	30	10500
150	32	35	30	30	16	3	30	10500
150	40	35	30	30	16	2	30	9500
150	40	35	30	30	16	3	30	9500
180	40	40	30	50	21	2	30	7500
180	40	40	30	50	21	3	30	7500
180	40	40	30	50	21	4	30	7500
180	50	40	30	50	21	2	30	6500
180	50	40	30	50	21	3	30	6500
180	50	40	30	50	21	4	30	6500
180	60	40	30	50	21	2	30	6000
180	60	40	30	50	21	3	30	6000
180	60	40	30	50	21	4	30	6000
165	32	35	30	40	16	2	45	9500
165	32	35	30	40	16	3	45	9500
165	40	35	30	40	16	2	45	8500
165	40	35	30	40	16	3	45	8500
165	50	35	30	40	16	2	45	7500
165	50	35	30	40	16	3	45	7500
195	40	40	30	50	21	2	45	7000
195	40	40	30	50	21	3	45	7000
195	40	40	30	50	21	4	45	7000
195	50	40	30	50	21	2	45	6500
195	50	40	30	50	21	3	45	6500
195	50	40	30	50	21	4	45	6500
195	60	40	30	50	21	2	45	6000
195	60	40	30	50	21	3	45	6000
195	60	40	30	50	21	4	45	6000
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[min-1]

Blanks	B	H	S	LEUCODUR	Class-No.	Ident-No.
	15	30.4	2	HL Board 06	1525 16	183056
	20	40.4	2	HL Board 06	1525 16	183057
	25	40.4	2	HL Board 06	1525 16	183058
	32	40.4	2	HL Board 06	1525 16	182419
	40	40.4	2	HL Board 06	1525 16	182420
	50	40.4	2	HL Board 06	1525 16	182421
	60	40.4	2	HL Board 06	1525 16	182422
	[mm]	[mm]	[mm]			

Blanks	B	H	S	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	15	30.4	2	HL Board 06 Topline	152716	183680	183680
	20	40.4	2	HL Board 06 Topline	152716	183681	183681
	25	40.4	2	HL Board 06 Topline	152716	183682	183682
	32	40.4	2	HL Board 06 Topline	152716	182563	182562
	40	40.4	2	HL Board 06 Topline	152716	182565	182564
	50	40.4	2	HL Board 06 Topline	152716	182567	182566
	60	40.4	2	HL Board 06 Topline	152716	182569	182568
	[mm]	[mm]	[mm]				



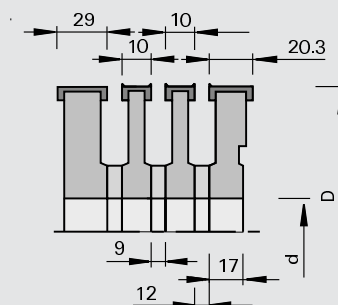
120450

Groove Bed Cutterheads HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- l molders with groove bed section Weinig
- l for cutting of guide grooves in solid woods

Design

- l n max = 10,000 min-1
- l single tools with spur
- l Ident-No. 180536 without spur

Advantages

Notes

- l application with the grain
- l attention: replacement parts for old cutterhead sets: cutterhead width = 9 mm can be replaced with new cutterhead width = 10 mm when spacer width = 10 mm is replaced with spacer width = 9 mm cutterhead width = 10.5 mm can be replaced with cutterhead width = 10 mm

Ø D	B	Ø d	Z	Ident-No.
140	10	40	2+2	176066
140	20,3	40	2+2	176067
140	29	40	2	180536 s
140	10	50	2+2	176069
140	20,3	50	2+2	176070
[mm]	[mm]	[mm]		

Spare parts	Ø D	B	Ø d	Class-No.	Ident-No.
Spacers	70	9	40	955520	177308
Spacers	70	10	40	955520	162004
Spacers	70	12	40	955520	162706
Spacers	70	10	50	955520	163886
Spacers	70	12	50	955520	163887
	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	9,6	12	1.5	150515	171163
Turnover Knives	20	12	1.5	150516	178287
Turnover Knives	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=7,2	176066, 176069	925300	168074
Set Screws	M5x12 DIN EN ISO 4028	176066, 176069	995161	050565
Countersunk Flat Headed Screws	M5x6 T20	176066, 176069	995125	176199
Adjusting Gauges	0,7	176066, 176069	985200	056096
Clamping Bars	B=17	176067, 176070	925300	167971
Set Screws	M8x16 DIN EN ISO 4028	176067, 176070, 180536	995161	164422
Countersink Screws	M5x10,8 T15	176067, 176070	995125	180840
Adjusting Gauges	1,0	176067, 176070, 180536	985200	011103
Clamping Bars	B=30	180536	925300	164185
Screwdrivers	SW2,5x100	176066, 176069	985730	168010
Screwdrivers	SW4x100	176067, 176070, 180536	985730	166091
Screwdrivers	T15x100	176067, 176070	985730	180470
	[mm]			

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Screwdrivers	T20x100 [mm]	For all	985730	166092

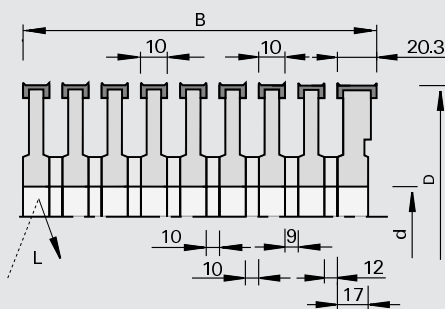
121450

Groove Bed Cutterhead Sets HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

- l molders with groove bed section Weinig
- l for cutting of guide grooves in solid woods

Design

- l n max = 10,000 min-1

Advantages

Notes

- l application with the grain
- l complete tool sets for specific wood widths "B"

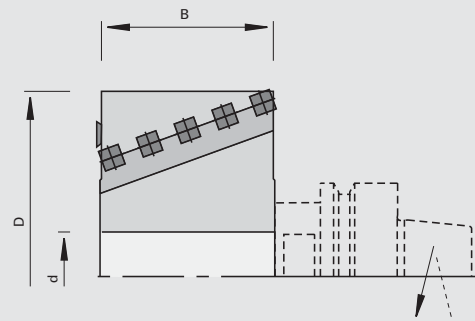
Ø D	B	Ø d	Z	Ident-No.
140	80	35	2+2	176071 &
140	100	35	2+2	176072 &
140	120	35	2+2	176073 &
140	140	35	2+2	176074 &
140	170	35	2+2	176075 &
140	80	40	2+2	176076 &
140	100	40	2+2	176077 &
140	120	40	2+2	176078 &
140	140	40	2+2	176079 &
140	170	40	2+2	176080 &
140	80	50	2+2	176081 &
140	100	50	2+2	176082 &
140	120	50	2+2	176083 &
140	140	50	2+2	176084 &
140	170	50	2+2	176085 &
[mm]	[mm]	[mm]		

120700

Spiral Cutterheads HW

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- stationary milling centers
- for dressing, rough-planing, jointing, rabbeting, copying of solid woods and laminated timber

Design

- with four-sided turnover knives, with rounded edges
- 2 front spurs HW
- spiral cutting layout of turnover knives and cut division
- high-tensile aluminum body

Advantages

- easy hogging, low cutting pressure and low noise level
- high hogging volume

Notes

- for HSK mounting arbors with double key without spacer
- for Ident-No. 183678 clamping length 50 mm with HSK mounting arbor
- for Ident-No. 183679 clamping length 80 mm with HSK mounting arbor

Ø D	B	Ø d	Z	nmax	Ident-No.
80	80	30	2+2+V2	18000	183678
80	100	30	2+2+V2	18000	183679
[mm]	[mm]	[mm]		[min-1]	

Turnover Knives

B

H

S

Class-No.

Ident-No.

Turnover Knives (with rounded edges R=50 mm)

15

15

2.5

150518

180454

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M5x15,5 T20

995125

182112

Screwdrivers

T20x100

985730

166092

[mm]

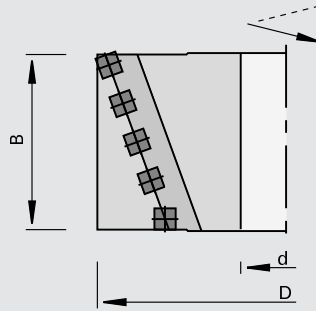
120700

Spiral Cutterheads HW - Finish

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MEC

Machine / Application

| molders
 | stationary milling centers
 | for milling, rough-planing and
 finish-planing in solid woods

Design

| with four-sided turnover knives,
 with rounded edges
 | spiral cutting layout of turnover
 knives and cut division
 | high-tensile aluminum body

Advantages

| easy hogging, low cutting
 pressure and low noise level

Notes

| for finished cut

$\varnothing D$	B	$\varnothing d$	Z	nmax	Ident-No.
125	100	40	2+2	12000	182091 o
125	130	40	2+2	12000	182092 o
125	170	40	2+2	12000	182093 o
125	230	40	2+2	12000	182094 o
125	240	40	2+2	12000	182095 o
[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives (with rounded edges R=150 mm)	15	15	2.5	150518	185274
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x15,5 T20	995125	182112
Screwdrivers	T20x100	985730	166092
	[mm]		

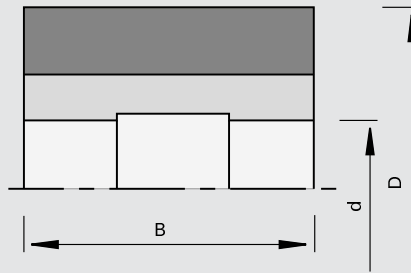
320200

Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | multi spindle plunging machines
- | for planing of solid woods

Design

- | n max = 9,000 min-1

Advantages

Notes

- | HS-tipped knives (18%) 30x3 mm
- | for adjusting the planing knives 2 adjustment rings are needed
- | alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Ident-No.
125	80	40	4	179204
125	100	40	4	181195
125	130	40	4	179194
125	150	40	4	179195
125	180	40	4	179196
125	230	40	4	181190
[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=80	925300	179205 o
Clamping Bars	B=100	925300	181191 o
Clamping Bars	B=130	925300	179198 o
Clamping Bars	B=150	925300	179199 o
Clamping Bars	B=180	925300	179200 o
Clamping Bars	B=230	925300	181192 o
Adjustment Rings	125x40	985200	179201 o
Set Screws	M10x25 DIN EN ISO 4028	995161	168108
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	009674
	[mm]		

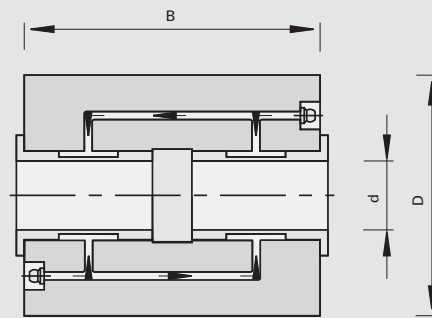
320200

Hydro Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- $n_{max} = 9,000 \text{ min}^{-1}$

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
143	60	40	4	27	178104 o
143	130	40	4	27	178105 o
143	230	40	4	27	178106 o
163	60	50	4	27	178107 o
163	100	50	4	27	178108 o
163	130	50	4	27	178109 o
163	150	50	4	27	178110 o
163	180	50	4	27	178112 o
163	230	50	4	27	178113 o
163	260	50	4	27	178115 o
163	310	50	4	27	178116 o
163	60	50	6	27	178117 o
163	100	50	6	27	178118 o
163	130	50	6	27	178119 o
163	150	50	6	27	178120 o
163	180	50	6	27	178122 o
163	230	50	6	27	178123 o
163	260	50	6	27	178125 o
163	310	50	6	27	178126 o
163	60	50	8	25	178127 o
163	100	50	8	25	178128 o
163	130	50	8	25	178129 o
163	150	50	8	25	178130 o
163	230	50	8	25	178131 o
163	260	50	8	25	178132 o
[mm]	[mm]	[mm]		[°]	

Spare parts

Dimension

Class-No.

Ident-No.

Set Screws	M12x25 DIN EN ISO 4028	995161	181466
Screwdrivers	SW6x200	985730	167817
Grease Guns		993270	163706
Grease Cartridges		993270	163707

[mm]

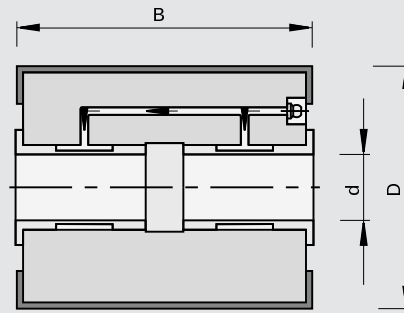
320200

Hydro-Rotaplane Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- $n_{max} = 6,000 \text{ min}^{-1}$

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
203	150	50	6	27	178133 o
203	230	50	6	27	178134 o
203	150	50	8	27	178136 o
203	230	50	8	27	178137 o
203	310	50	8	27	178139 o
203	150	50	10	23	178141 o
203	230	50	10	23	178142 o
203	310	50	10	23	178144 o
203	100	50	12	23	178145 o
203	150	50	12	23	178146 o
203	230	50	12	23	178147 o
203	310	50	12	23	178149 o
203	100	50	16	20	178150 o
203	150	50	16	20	178151 o
[mm]	[mm]	[mm]		[°]	

Spare parts

Dimension

Class-No.

Ident-No.

Set Screws	M12x25 DIN EN ISO 4028	995161	181466
Screwdrivers	SW6x200	985730	167817
Grease Guns		993270	163706
Grease Cartridges		993270	163707

[mm]

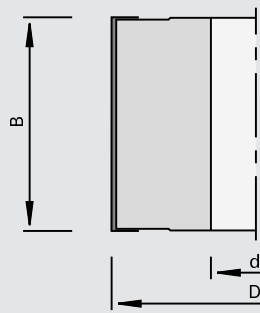
320200

Hydro Planing Cutterheads HS - Quicklock

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- all knives are clamped automatically by impressurement via grease press
- clamping wedge numbered according to the chip evacuation gap
- $n_{max} = 9,000 \text{ min}^{-1}$

Advantages

- high concentric accuracy and precise tool balancing thanks to hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality
- simple handling
- short machine downtimes
- high balance quality

Notes

- HS-tipped knives 30 x 4 mm

Ø D	B	Ø d	Z	Hook angle	Ident-No.
143	100	40	4	27	183312 s
143	130	40	4	27	183313 s
143	150	40	4	27	183314 s
143	180	40	4	27	183315 s
143	210	40	4	27	183316 s
143	230	40	4	27	183317 s
143	240	40	4	27	183318 s
143	310	40	4	27	183319 s
143	320	40	4	27	183320 s
163	100	50	6	27	183321 s
163	130	50	6	27	183322 s
163	150	50	6	27	183323 s
163	180	50	6	27	183324 s
163	210	50	6	27	183325 s
163	230	50	6	27	183326 s
163	240	50	6	27	183327 s
163	310	50	6	27	183328 s
163	320	50	6	27	183329 s
163	150	50	8	25	183330 s
163	180	50	8	25	183331 s
163	210	50	8	25	183332 s
163	230	50	8	25	183333 s
163	240	50	8	25	183334 s
163	270	50	8	25	183335 s
163	310	50	8	25	183336 s
163	320	50	8	25	183337 s
203	150	50	10	23	183338 s
203	180	50	10	23	183339 s
203	210	50	10	23	183340 s
203	230	50	10	23	183341 s
203	240	50	10	23	183342 s
203	270	50	10	23	183343 s
203	310	50	10	23	183344 s
203	320	50	10	23	183345 s
203	150	50	12	23	183346 s
203	180	50	12	23	183347 s
203	210	50	12	23	183348 s
203	230	50	12	23	183349 s
[mm]	[mm]	[mm]		[°]	

Ø D	B	Ø d	Z	Hook angle	Ident-No.
203	240	50	12	23	183350 s
203	270	50	12	23	183351 s
203	310	50	12	23	183352 s
203	320	50	12	23	183353 s
[mm]	[mm]	[mm]		[°]	

Spare parts	Class-No.	Ident-No.
Grease Guns	993270	163706
Grease Cartridges	993270	163707

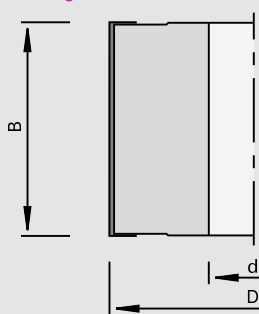
320200 / 332121 / 132121

Planing Cutterheads HS with centrifugal clamping

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | molders
- | four-side molders
- | for planing of solid woods

Design

- | n max = 9,000 min-1
- | spring-loaded balls (b) hold the knife before clamping

Advantages

- | quick tool change with centrifugal clamping, without clamping screws and without time-consuming adjustment procedure
- | tempered precision chip breaker (a) for precise positioning of the knives
- | very cost effective thanks to resharpenability
- | closed design for low noise level

Notes

- | HS-TRI -tipped knives
- | alternative cutting material: HW

Ø D	B	Ø d	Z	Ident-No.
100	80	30	3	70469103 o
100	180	30	3	70469104 o
100	120	30	3	70469105 o
125	130	40	4	70469108 o
120	120	40	4	70469109 o
125	230	40	4	70469110 o
125	180	40	4	70469112 o
120	130	40	4	70469113 o
120	180	40	4	70469115 o
120	230	40	4	70469116 o
125	80	40	4	70469117 o
125	100	40	4	70469121 o
125	120	40	4	70469122 o
125	240	40	4	70469128 o
125	130	40	2	70469159 o
125	180	40	2	70469162 o
125	230	40	2	70469163 o
125	240	40	2	70469164 o
125	190	40	4	70469209 o
125	190	40	2	70469212 o
[mm]	[mm]	[mm]		

Turnover Knives	B	Cutting material	Class-No.	Ident-No.
	60	HS - TRI	332121	70469707 o
	80	HS - TRI	332121	70469708 o
	100	HS - TRI	332121	70469710 o
	120	HS - TRI	332121	70469712 o
	130	HS - TRI	332121	70469713 o
	136	HS - TRI	332121	70469736 o
	140	HS - TRI	332121	70469714 o
	150	HS - TRI	332121	70469715 o
	160	HS - TRI	332121	70469716 o
	180	HS - TRI	332121	70469718 o
	186	HS - TRI	332121	70469786 o
	190	HS - TRI	332121	70469719 o
	200	HS - TRI	332121	70469720 o
	210	HS - TRI	332121	70469721 o
	220	HS - TRI	332121	70469722 o
	230	HS - TRI	332121	70469723 o
	240	HS - TRI	332121	70469724 o
	260	HS - TRI	332121	70469726 o
	300	HS - TRI	332121	70469730 o
	310	HS - TRI	332121	70469731 o
	400	HS - TRI	332121	70469740 o
	410	HS - TRI	332121	70469741 o
	430	HS - TRI	332121	70469743 o
	500	HS - TRI	332121	70469750 o
	510	HS - TRI	332121	70469751 o
	610	HS - TRI	332121	70469761 o
	630	HS - TRI	332121	70469763 o
	640	HS - TRI	332121	70469764 o
	710	HS - TRI	332121	70469771 o
	1350	HS - TRI	332121	70469798 o
	[mm]			
Turnover Knives	B	Cutting material	Class-No.	Ident-No.
	80	HW	132121	70469908 o
	100	HW	132121	70469910 o
	120	HW	132121	70469912 o
	130	HW	132121	70469913 o
	140	HW	132121	70469914 o
	150	HW	132121	70469915 o
	160	HW	132121	70469916 o
	180	HW	132121	70469918 o
	200	HW	132121	70469920 o
	210	HW	132121	70469921 o
	220	HW	132121	70469922 o
	230	HW	132121	70469923 o
	240	HW	132121	70469924 o
	250	HW	132121	70469925 o
	260	HW	132121	70469926 o
	300	HW	132121	70469930 o
	610	HW	132121	70469999 o
	[mm]			
Spare parts			Class-No.	Ident-No.
Knife Changers			985720	70469100 o

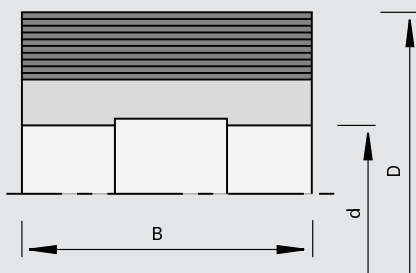
320600

Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- | molders
- | for profiling of solid woods

Design

- | hook angle 25 degrees
- | Ø 122 mm: n max = 9,000 min-1
- | Ø 137 mm: n max = 8,000 min-1

Advantages

- | high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- | precise serration (60 degrees, 1.6 mm pitch) ensures tight knife clamping
- | adjustable knives
- | profile depth and cutting circle Ø see table
- | for back-serrated blanks S = 5, 8, 10 mm
- | included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No.
122	40	40	4	179208
122	60	40	4	179209
122	80	40	4	179210
122	100	40	4	179211
122	130	40	4	179212
122	150	40	4	179213 o
122	180	40	4	179214
122	230	40	4	179215 o
137	60	50	4	179216 o
137	80	50	4	179217 o
137	100	50	4	179218 o
137	150	50	4	179219 o
137	180	50	4	179220 o
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=40	925300	179221 o
Clamping Bars	B=60	925300	179222 o
Clamping Bars	B=80	925300	179223 o
Clamping Bars	B=100	925300	179224 o
Clamping Bars	B=130	925300	179225 o
Clamping Bars	B=150	925300	179226 o
Clamping Bars	B=180	925300	179227 o
Clamping Bars	B=230	925300	179228 o
Dummy Pieces	B=40	925900	179229 o
Dummy Pieces	B=60	925900	179230 o
Dummy Pieces	B=80	925900	179231 o
Dummy Pieces	B=100	925900	179232 o
Dummy Pieces	B=130	925900	179233 o
Dummy Pieces	B=150	925900	179234 o
Dummy Pieces	B=180	925900	179235 o
Dummy Pieces	B=230	925900	179236 o
Set Screws	M10x20 DIN EN ISO 4028	995161	815807
Screwdrivers	SW5x150	985730	168703
	[mm]		

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
Dmax at D=137	176	176	186	196	196	216	216

Maximum RPM

B (mm)	50	55	60	70
Dmax at D=122	161	171	181	201
Max.RPM (min-1):	9000	8400	8000	7200
Dmax at D=137	176	186	196	216
Max.RPM (min-1):	8200	7700	7300	6600

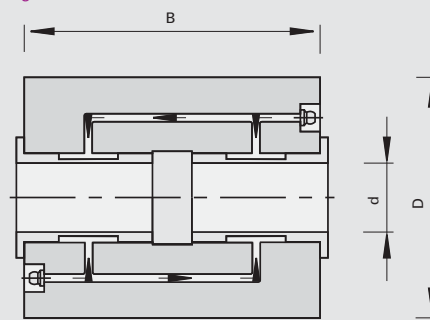
320600

Hydro Profile Cutterheads HS

Product



Drawing



MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- the max. RPM depends from the knife height (see table "Max. RPM")

Advantages

- best cutting quality without knife marks at high feed rates
- precise concentricity tolerance (system Weing) thanks to dual-chamber Hydro clamping
- high concentric accuracy and low operating vibration
- tight clamping thanks to precise serration (60 degrees, 1.6 mm pitch)

Notes

- adjustable knives
- profile depth and cutting circle \varnothing see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

$\varnothing D$	B	$\varnothing d$	Z	Ident-No.
137	60	40	4	176342 o
137	100	40	4	176343 o
137	130	40	4	176344 o
137	150	40	4	176345 o
137	180	40	4	176346 o
137	230	40	4	176347 o
150	60	50	4	176348 o
150	60	50	6	176349 o
150	100	50	4	176350 o
150	100	50	6	176351 o
150	130	50	4	176352 o
150	130	50	6	176353 o
150	150	50	4	176354 o
150	150	50	6	176355 o
150	180	50	4	176356 o
150	180	50	6	176357 o
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
150	230	50	4	176358 o
150	230	50	6	176359 o
150	260	50	4	176360 o
150	260	50	6	176361 o
150	310	50	4	176362 o
150	310	50	6	176363 o
163	60	50	8	176364 o
163	100	50	8	176365 o
163	130	50	8	176366 o
163	150	50	8	176367 o
163	180	50	8	176368 o
163	230	50	8	176369 o
163	260	50	8	176370 o
163	310	50	8	176371 o
195	60	50	10	176372 o
195	100	50	10	176373 o
195	130	50	10	176374 o
195	150	50	10	176375 o
215	60	50	12	176380 o
215	100	50	12	176381 o
215	130	50	12	176382 o
215	150	50	12	176383 o
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	181466
Screwdrivers	SW6x200	985730	167817
Grease Guns		993270	163706
Grease Cartridges		993270	163707
	[mm]		

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=137	174	174	184	194	194	214	214
Dmax at D=150	189	189	199	209	209	229	229
Dmax at D=163	202	202	212	222	222	242	242

Maximum RPM

Knife height H [mm]	50	55	60	70
Dmax at D=137	174	184	194	214
Max.RPM (min-1):	8300	7800	7400	6700
Dmax at D=150	189	199	209	229
Max.RPM (min-1):	7700	7300	6900	6300
Dmax at D=163	202	212	222	242
Max.RPM (min-1):	7200	6800	6500	6000
Dmax for D=215	254	264	274	294
Max.RPM (min-1):	5700	5400	5200	4900

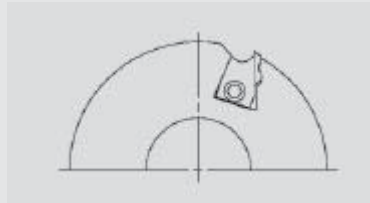
320208

Planing Cutterheads HS with Weinig HSK

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

l molders "Weinig Powermat"
l for planing of solid woods

Design

l n max = 12,000 min-1

Advantages

l quick knife change thanks to
Centrolock clamping bar

Notes

l clamping by means of front
screw
l HS-tipped turnover knives
l alternative cutting material:
HW for hard woods, glued
timber and MDF
l picture shows sense of
rotation left (acc. to DIN left)
l Turnover Knives see chapter
Turnover Knives, Knives,
Inserts

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
93	60	Weinig-HSK	2	181728 o	181737 o
93	80	Weinig-HSK	2	181729 o	181738 o
93	100	Weinig-HSK	2	181730 o	181739 o
93	130	Weinig-HSK	2	181731 o	181740 o
93	150	Weinig-HSK	2	181732 o	181741 o
93	170	Weinig-HSK	2	181733 o	181742 o
93	190	Weinig-HSK	2	181734 o	181743 o
93	210	Weinig-HSK	2	181735 o	181744 o
93	240	Weinig-HSK	2	181736 o	181745 o
[mm]	[mm]	[mm]			

Spare parts

Class-No.

Ident-No.

Hammer for Releasing the Knives

985740

181746 o

HSK-Mounting Device

985202

181747 o

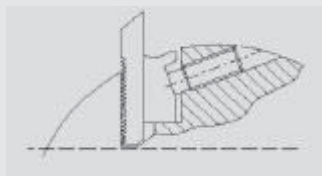
320608

Profile Cutterheads HS - Powerlock with Weinig HSK (blanks S=5,8,10 mm)

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- l molders "Weinig Powermat"
- l for profiling of solid woods

Design

- l hook angle 20 degrees (special 12 degrees)
- l n max = 12,000 min-1

Advantages

- l fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- l high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

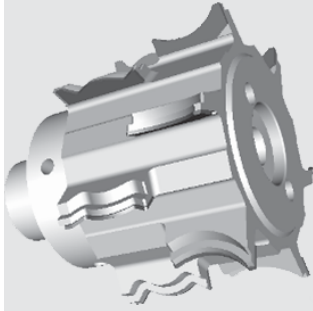
- l adjustable knives
- l possibility of sideways stop in the cutterhead
- l control of adjusting range of the knives through lunettes
- l picture shows sense of rotation right (acc. to DIN right)
- l for all back-serrated blanks S = 5, 8, 10 mm
- l included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 o	182314 o
90	60	Weinig-HSK	2	181766 o	181775 o
90	80	Weinig-HSK	2	181767 o	181776 o
90	100	Weinig-HSK	2	181768 o	181777 o
90	130	Weinig-HSK	2	181769 o	181778 o
90	150	Weinig-HSK	2	181770 o	181779 o
90	170	Weinig-HSK	2	181771 o	181780 o
90	190	Weinig-HSK	2	182313 o	181781 o
90	210	Weinig-HSK	2	181773 o	181782 o
90	240	Weinig-HSK	2	181774 o	181783 o
90	80	Weinig-HSK	4	181785 o	181794 o
90	100	Weinig-HSK	4	181786 o	181795 o
90	130	Weinig-HSK	4	181787 o	181796 o
90	150	Weinig-HSK	4	181788 o	181797 o
90	170	Weinig-HSK	4	181789 o	181798 o
90	190	Weinig-HSK	4	181790 o	181799 o
90	210	Weinig-HSK	4	181791 o	181800 o
90	40	Weinig-HSK	4	182315 o	182316 o
90	60	Weinig-HSK	4	181784 o	182317 o
90	240	Weinig-HSK	4	181792 o	182318 o
[mm]	[mm]	[mm]			

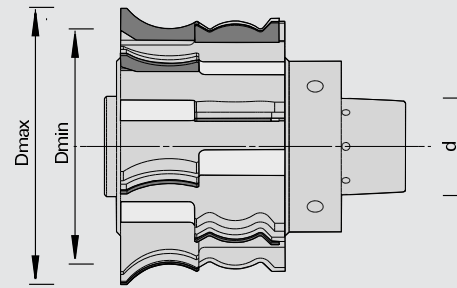
222068

PowerDiaProfiler DP

Product



Drawing



LEUCO
power
DIAProfiler

polycrystalline diamond [DP]

MEC

Machine / Application

- l molding automats with HSK-interface
- l for profiling of MDF, hard and exotic woods

Design

- l Topline (polished knife face and precise cutting edge)

Advantages

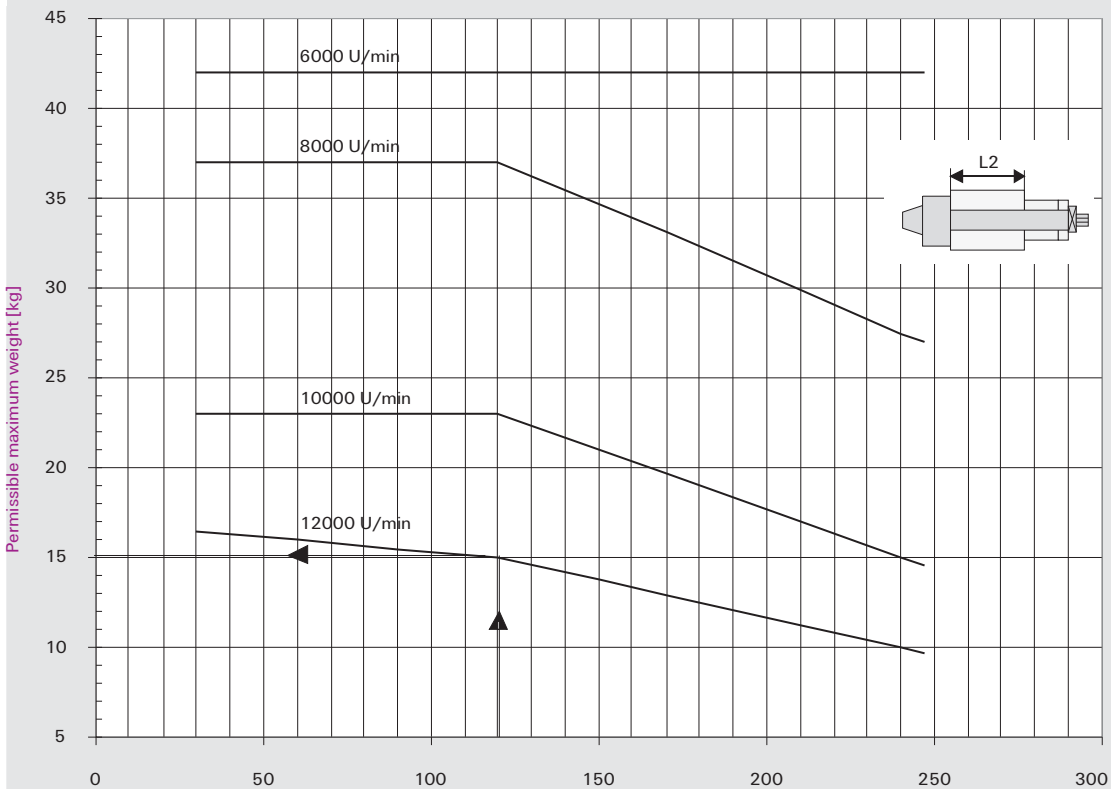
- l highest concentricity
- l feed speed and workpiece surface like in the case of jointed HW-tools

Notes

- l optimal cutting speed 80 - 100m/s
- l profiles according to customer specifications
- l price on request
- l n max = depending on L2 and weight (see chart)

\varnothing Dmax	\varnothing Dmin	\varnothing d	Z	Recommended feed
180	100	Weinig HSK	2	33
180	100	Weinig HSK	3	50
180	100	Weinig HSK	4	66
180	100	Weinig HSK	5	83
180	100	Weinig HSK	6	100
180	100	Weinig HSK	7	117
180	100	Weinig HSK	8	133
[mm]	[mm]	[mm]		[m/min]

Diagram for PowerLock-Adapter



Tool length L2 [mm]

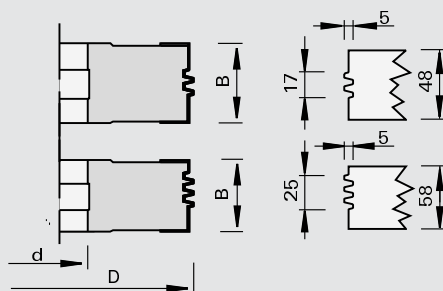
120505

Glue Joint Profile Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | molders
- | table shapers
- | for cutting of edge glue joints in solid woods

Design

- | cutting edges parallel to cutter axis
- | n = 5,700 - 9,800 min-1

Advantages

- | continuous high profile accuracy thanks to turnover knives

Notes

- | application against feed
- | fit of joints can be defined by moving the knives sideways by means of dials (see spare parts)
- | when delivered, tool is set to 0.3 mm joint play

Ø D	B	Ø d	Ø dmax	Z	H	Ident-No.
135	50	30	50	2	17-48	177007
135	60	30	50	2	25-58	177008 s
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
	50	23	2	151555	180431
	60	23	2	151555	180432
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Pressure Jaws	48x11x6	177007	925300	180433
Pressure Jaws	58x11x6	177008	925300	180434
Clamping Parts	12x8,5/M8L		925100	180357
Clamping Setscrews	M8x26 SW4		995161	180340
Screwdrivers	SW4x100		985730	166091
	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Adjustment Dials	0,1 + 0,15	995490	180435
Adjustment Dials	0,15 + 0,2	995490	180436
Adjustment Dials	0,2 + 0,25	995490	180437
Adjustment Dials	0,25 + 0,3	995490	180438
Adjustment Dials	0,3 + 0,35	995490	180439
	[mm]		

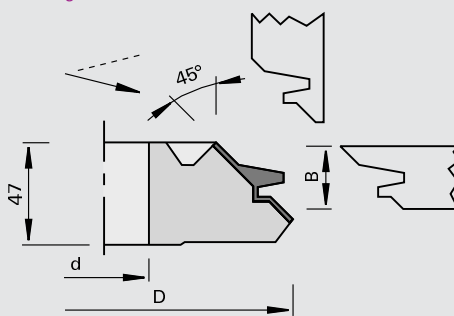
120525

Miter Lock Joint Profile Cutterheads HW

Product



Drawing



LEUCO DUR
tungsten carbide [HW]
MAN

Machine / Application

- | molders
- | table shapers
- | for cutting of miter lock joints in solid woods and wood-based panels

Design

- | body made from high-strength aluminium alloy
- | cutting edges parallel to cutter axis
- | n = 4,600 - 7,800 min-1

Advantages

- | continuous high profile accuracy thanks to profile knives

Notes

- | application against feed
- | wood thickness approx. 15 mm to max. 26 mm

Ø D	B	Ø d	Z	Ident-No.
170 [mm]	26 [mm]	30 [mm]	2+2	176097

Turnover Knives	B	H	S	Class-No.	Ident-No.
Grooving / Chamfering Knife	5,0 / 2,6		5.0	150509	184275
Miter Glue Joint Profile Knives	39,5 [mm]	12 [mm]	1.5 [mm]	151547	165916

Spare parts	Dimension	Class-No.	Ident-No.
Pressure Jaws	38x11x6	925300	180538
Clamping Parts	12x8,5/M8L	925100	180357
Clamping Setscrews	M8x26 SW4	995161	180340
Countersink Screws	M5x10,8 T15	995125	180840
Screwdrivers	SW4x100	985730	166091
Screwdrivers	T15x100 [mm]	985730	180470

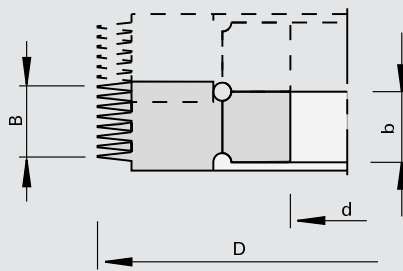
327110 / 327130

Finger Joint Cutters HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | finger joint machines
- | machines with and without cross-cutting device
- | for longitudinal joints in soft woods

Design

- | standard, for PUR glueing and topcoat

Advantages

- | strong flank surface pressure for PUR glues (fiber-free)
- | increased edge lives and higher wear resistance and gliding features thanks to Topcoat coating

Notes

- | for machines with cross-cutting device, finger length 4/4,5, 10/11, 15/16,5, 20/22
- | for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	175740
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	175741
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	178966
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	181008
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	182122 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	175742
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	175743
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	182668
180	33	31	50	2+2	6.2	20/20	5	8000	175744
180	33	31	50	2+2	6.2	20/22	5	8000	175745
250	26	24	50	3+3	1.6	4/4,5	16	6000	182113 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	175746 s
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	175747
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	175748
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	175749
260	33	31	50	3+3	6.2	20/22	5	6000	175751
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax	Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	189715 s
180	33	31	50	2+2	6.2	20/20	5	8000	192262 s
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	189716 s
260	33	31	50	3+3	6.2	20/20	5	6000	192263 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	192190 s
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	192127
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	192199 s
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	192200 s
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	192202 s
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	192191 s
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	192192 s
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	192203 s
180	33	31	50	2+2	6.2	20/20	5	8000	192193 s
180	33	31	50	2+2	6.2	20/22	5	8000	192194 s
250	26	24	50	3+3	1.6	4/4,5	16	6000	192201 s
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	192195 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	topcoat	192126
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	topcoat	192196 s
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	topcoat	192197 s
260	33	31	50	3+3	6.2	20/22	5	6000	topcoat	192198 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

327610 / 327630

Finger Joint cutters HW - real Z=4 resp. Z=6

Product

Drawing



High Speed Steel [HS]

MEC

Machine / Application

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

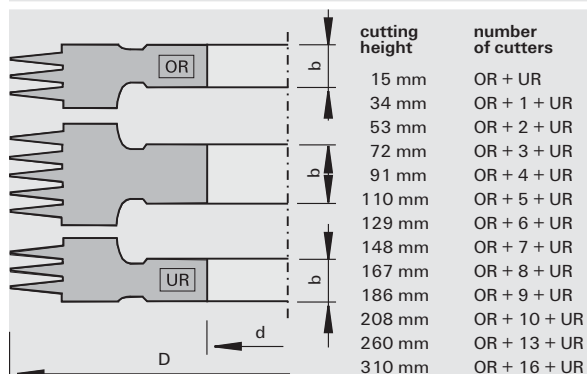
- real Z=4 or Z=6 for high feed rates
- standard, for PUR glueing and topcoat

Advantages

- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design
- longer edge life, higher wear resistance and gliding features thanks to topcoat coating

Notes

- no. of cutters: see table



Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top cutter	182675
170	41,0	19	50	4	3.8	15/15	5	8000	base cutter	182676
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom cutter	182677
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top cutter	182678
170	41,0	19	50	4	3.8	15/16,5	5	8000	base cutter	182679
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom cutter	182680
250	26,4	15.4	50	6	3.8	10/11	3	6000	top cutter	189930
250	41,0	19	50	6	3.8	10/11	5	6000	base cutter	182682
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom cutter	189931
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14,8	50	4	3,8	15/15	3	8000	top cutter for PUR glueing	192264 s
170	41,0	19	50	4	3,8	15/15	5	8000	base cutter for PUR glueing	192265 s
170	26,4	14,8	50	4	3,8	15/15	3	8000	bottom cutter for PUR glueing	192266 s
180	27,2	17,2	50	3	6,2	20/20	2	8000	top cutter for PUR glueing	192267 s
180	39,6	19,1	50	3	6,2	20/20	3	8000	base cutter for PUR glueing	192268 s
180	27,2	17,2	50	3	6,2	20/20	2	8000	bottom cutter for PUR glueing	192269 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14,8	50	4	3,8	15/15	3	8000	top cutter/topcoat	192204 s
170	41,0	19	50	4	3,8	15/15	5	8000	base cutter/topcoat	192205 s
170	26,4	14,8	50	4	3,8	15/15	3	8000	bottom cutter/topcoat	192206 s
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	top cutter/topcoat	192207 s
170	41,0	19	50	4	3,8	15/16,5	5	8000	base cutter/topcoat	192208 s
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	bottom cutter/topcoat	192209 s
250	26,4	15,4	50	6	3,8	10/11	3	6000	top cutter/topcoat	192210 s
250	41,0	19	50	6	3,8	10/11	5	6000	base cutter/topcoat	192211 s
250	26,4	15,4	50	6	3,8	10/11	3	6000	bottom cutter/topcoat	192212 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

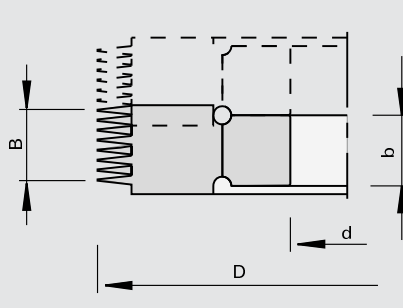
527110

Finger Joint Cutters HS - Solid 34

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- l finger joint machines
- l machines with and without cross-cutting device
- l for longitudinal joints in knotty soft woods

Design

- l cutting edge: HS Solid 34

Advantages

- l compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- l high bending strength
- l reduced risk of tooth breaking

Notes

- l for machines with cross-cutting device, finger length 10/11, 15/16,5, 20/22
- l for machines without cross-cutting device, finger length 10/10, 15/15, 20/20

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26,6	50	2+2	3,8	10/10	7	8000		183231 s
160	28,6	26,6	50	2+2	3,8	10/11	7	8000		183232 s
160	32,4	30,4	50	2+2	3,8	10/11	8	8000		183233 s
160	28,6	26,6	50	3+3	3,8	10/11	7	8000		183234 s
170	28,6	26,6	50	2+2	3,8	15/16,5	7	8000		183235 s
170	28,6	26,6	50	2+2	3,8	15/15	7	8000		183230
170	28,6	26,6	50	3+3	3,8	15/16,5	7	8000		183236 s
180	33	26,6	50	2+2	6,2	20/20	5	8000		183237 s
180	33	31	50	2+2	6,2	20/22	5	8000		183238 s
250	28,6	31	50	3+3	3,8	10/10	7	6000		183239 s
250	28,6	26,6	50	3+3	3,8	10/11	7	6000		183228
260	28,6	26,6	50	3+3	3,8	15/15	7	6000		183240 s
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000		183229
260	33	31	50	3+3	6,2	20/22	5	6000		183241 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

527610

Finger Joint Cutters HS - Solid 34

Product



Drawing

High Speed Steel [HS]

MEC

Machine / Application

- high-performance finger joint machines
- for longitudinal joints in soft woods

Design

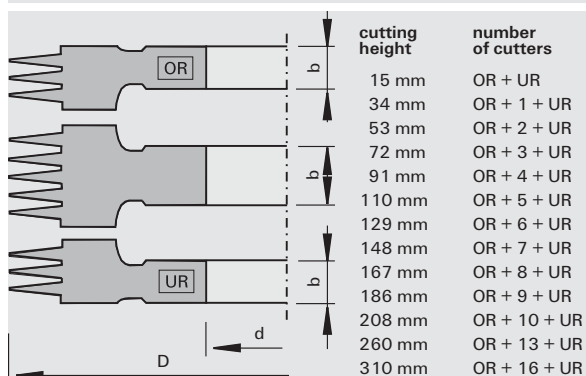
- cutting edge: HS Solid 34
- real Z=4 or Z=6 for high feed rates

Advantages

- compared to traditional HS finger joint cutters the edge life is 2 - 3 times as long
- high bending strength
- reduced risk of tooth breaking
- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

Notes

- no. of cutters: see table



Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14,8	50	4	3,8	15/15	3	8000	top cutter	183242 s
170	41,0	19	50	4	3,8	15/15	5	8000	base cutter	183243 s
170	26,4	14,8	50	4	3,8	15/15	3	8000	bottom cutter	183244 s
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	top cutter	183247 s
170	41,0	19	50	4	3,8	15/16,5	5	8000	base cutter	183245 s
170	26,4	14,8	50	4	3,8	15/16,5	3	8000	bottom cutter	183246 s
250	26,4	14,8	50	6	3,8	10/11	3	6000	top cutter	183248
250	41,0	19	50	6	3,8	10/11	5	6000	base cutter	183249
250	26,4	14,8	50	6	3,8	10/11	3	6000	bottom cutter	183250
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

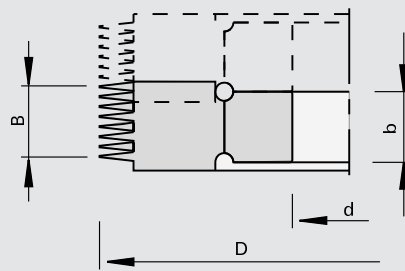
127110

Finger Joint Cutters HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | finger joint machines
- | machines with cross-cutting device
- | for longitudinal joints in hard and exotic woods

Design

Advantages

Notes

- | for machines with cross-cutting device, finger length 10/11, 15/16,5
- | for machines without cross-cutting device, finger length 10/10, 15/15

Ø D	B	b	Ø d	Z	Division	Finger joint length	Number of finger joints	nmax	Ident-No.
160	28,6	26,6	50	2+2	3.8	10/10	7	8000	175732 s
160	28,6	26,6	50	2+2	3.8	10/11	7	8000	175733
170	28,6	26,6	50	2+2	3.8	15/15	7	8000	175734 s
170	28,6	26,6	50	2+2	3.8	15/16,5	7	8000	175735 s
250	28,6	26,6	50	3+3	3.8	10/10	7	6000	175736 s
250	28,6	26,6	50	3+3	3.8	10/11	7	6000	175737
260	28,6	26,6	50	3+3	3.8	15/15	7	6000	175738 s
260	28,6	26,6	50	3+3	3.8	15/16,5	7	6000	175739 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

396961

Product



Drawing



LEUCO
TOP
COAT

High Speed Steel [HS]

MEC

Machine / Application

l finger joint machines
l for longitudinal joints in highly stressed components

Design

l tool body made from steel
l 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates
l secured against twisting
l cutting material: HS-Topcoat

Advantages

l multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to Topcoat coating

Notes

l included in delivery: tool body without knife inserts

Ø D	Ø D1	B	b	Ø d	Z	nmax	Ident-No.
129.8	160/170	30,4	30.4	50	2+2	8500	192180 s
129.8	160/170	30,4	30.4	50	3+3	8500	192181 s
216	250/260	30,4	30.4	50	2+2	6000	192182 s
216	250/260	30,4	30.4	50	3+3	6000	192183 s
216	250/260	30,4	30.4	50	4+4	6000	192188 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Overview

wood width in mm	Number of cutters	wood width in mm	Number of cutters
27	1	179	6
58	2	210	7
88	3	240	8
118	4	271	9
149	5	297	10

Knives	Class-No.	Ident-No.
HS insert Topcoat 10/10	332924	192184
HS insert Topcoat 10/11	332924	192185
HS insert Topcoat 15/15	332924	192186 s
HS insert Topcoat 15/16.5	332924	192187 s

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M8x20 DIN EN ISO 4028	995161	001625
Screwdrivers	SW4 [mm]	985730	50931919

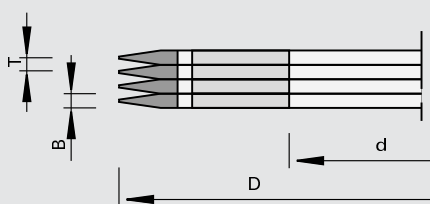
127210

Finger Joint Cutters disc-type HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l finger joint machines Grecon/Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- l machines with cross-cutting device
- l for longitudinal joints in soft and hard woods

Design

- l high-tensile steel body
- l Topline grinding
- l Ø 160 mm: n max = 11,800 min-1
- l Ø 250 mm: n max = 7,400 min-1
- l Ø 260 mm: n max = 7,200 min-1

Advantages

- l extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges

Notes

- l adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Division	Finger joint length		Ident-No.
160	3,8	70	2	3.8	10/11	soft wood	177561 s
160	3,8	70	2	3.8	10/11	hard woods/exotic woods	177562 s
160	3,8	70	4	3.8	10/11	soft woods	177563
160	3,8	70	4	3.8	10/11	hard woods/exotic woods	177564
250	3,8	70	6	3.8	10/11	hard woods/exotic woods	180938
250	3,8	70	6	3.8	10/11	soft woods	180939
260	3,8	70	6	3.8	15/16	soft woods	178253 s
[mm]	[mm]	[mm]		[mm]	[mm]		

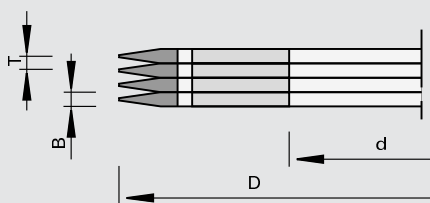
127230

Finger Joint Cutters disc-type HW - coated

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l finger joint machines Grecon/Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- l machines with cross-cutting device
- l for longitudinal joints in soft and hard woods

Design

- l high-tensile steel body
- l HW Topcoat coating
- l Ø 160 mm: n max = 11,800 min-1
- l Ø 250 mm: n max = 7,400 min-1

Advantages

- l extremely long edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- l compared to traditional HW finger joint cutters the edge live is 2 - 3 times as long

Notes

- l adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Division	Finger joint length		Ident-No.
160	3,8	70	4	3.8	10/11	soft woods	181230 s
160	3,8	70	4	3.8	10/11	hard woods/exotic woods	181231 s
250	3,8	70	6	3.8	10/11	hard woods/exotic woods	181232 s
250	3,8	70	6	3.8	10/11	soft woods	181233
[mm]	[mm]	[mm]		[mm]	[mm]		

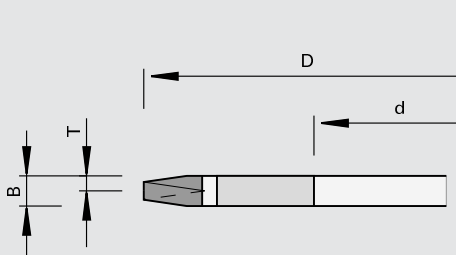
127310

Edge Finger Joint Cutters HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | finger joint machines
- | for cutting of closed visible longitudinal joints in hard and soft woods

Design

- | high-tensile steel body
- | Ø 149 mm: n max = 12,700 min-1
- | Ø 160 mm: n max = 11,800 min-1
- | Ø 239 mm: n max = 7,900 min-1
- | Ø 250 mm: n max = 7,400 min-1

Advantages

Notes

- | in combination with finger joint cutters with same Ø and pitch
- | Ø 149 mm and Ø 239 mm (half shoulder) only with scoring saw blade

Ø D	B	Ø d	Z	Division	Finger joint length	Ident-No.
149	3,8	70	4	3.8	5	180916
160	11,4	70	4	3.8	10	177574
239	3,8	70	6	3.8	10	180917 s
239	11,4	70	6	3.8	10	181245
250	11,4	70	6	3.8	10	177576
[mm]	[mm]	[mm]		[mm]	[mm]	

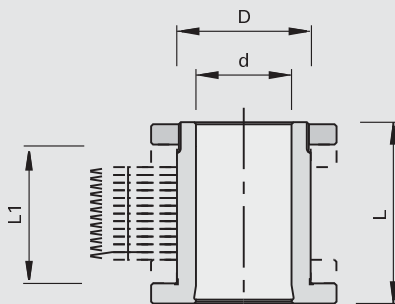
997300

Bushings for Finger Joint Cutters

Product



Drawing



Machine / Application

for clamping of finger joint cutters and edge finger joint cutters

Design

high-tensile steel body
spacers \varnothing 97 mm for cutters \varnothing 160-210 mm (not required)

Advantages

high concentric and runout accuracy
for varying wood thicknesses

Notes

- fill intermediate sizes with spacers
- for cutter \varnothing 250 mm install at least one spacer \varnothing 177 on top and bottom
- fastening nut or hydraulic clamping for cutter attachment must be ordered separately
- for cutter sets over 100 mm height we recommend hydraulic clamping
- the bushing length depends on the wood height "H" and on the type of nut
- accessories: mounting device, mounting ring and wrench is imperative for self-resharpening

\varnothing D	\varnothing d	L	L1	Ident-No.
70	50	90	57	178188
70	50	120	87	181035
70	50	130	97	178171
70	50	195	162	178172
70	50	220	187	178173
70	50	240	207	178174
[mm]	[mm]	[mm]	[mm]	

Spacer Rings	\varnothing D	B	\varnothing d	Class-No.	Ident-No.
	100	7,6	70	955520	180940
	100	11,4	70	955520	180941
	175	7,6	70	955520	181033
	175	11,4	70	955520	181034
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Mounting Devices		997300	177103
Mounting Rings	96x70x60	955520	177546
Pin-type face wrenches		985720	177102
Face Nuts	M68x1,5x14	995290	177104
Hydraulic Clumping Nuts	M68x1,5x56	933090	178787
Screwdrivers	SW4x100	985730	166091
	[mm]		

Finger Joint Cutters - Calculation of cutting width

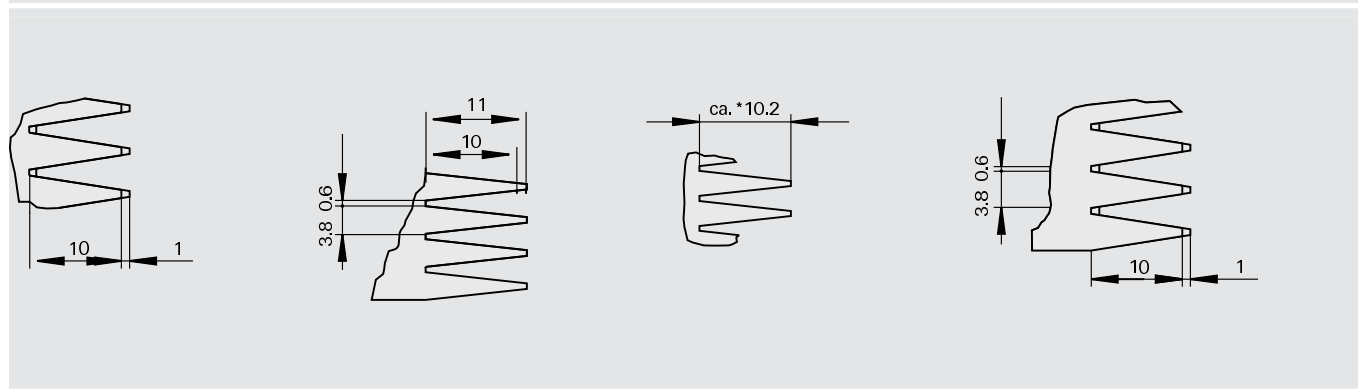
Combination of the cutter sets depending on the wood thickness

Finger length [mm]	Wood thickness [mm]	Number of cutters	Finger length [mm]	Wood thickness [mm]	Number of cutters
10+15	24	1	20	28	1
10+15	51	2	20	59	2
10+15	77	3	20	90	3
10+15	104	4	20	121	4
10+15	131	5	20	152	5
10+15	157	6	20	183	6
10+15	184	7	20	214	7
10+15	210	8	20	245	8
10+15	237	9	20	276	9
10+15	264	10	20	307	10

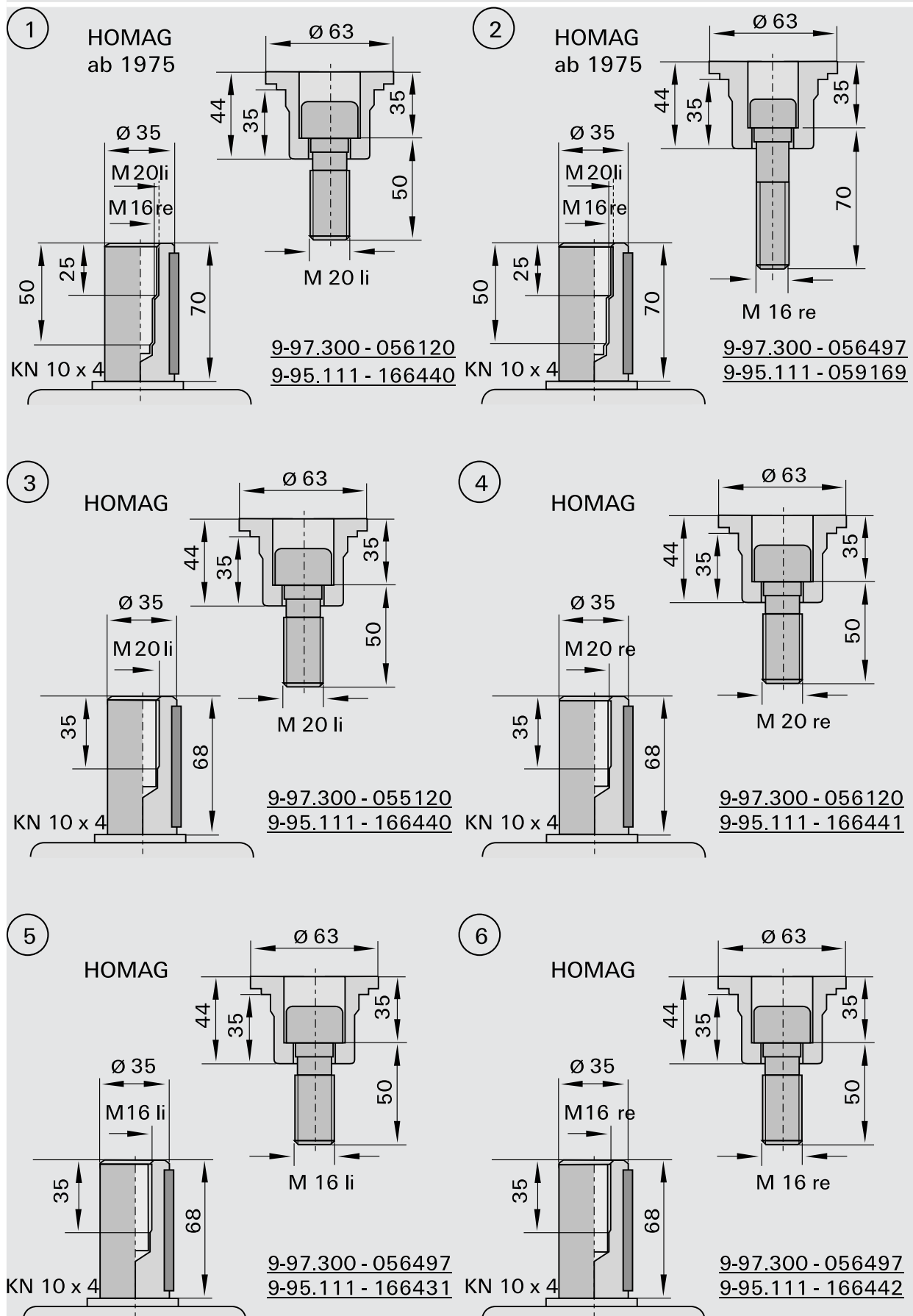
Finger joint cutters - cross cutting with extended finger joint profile

Finger length [mm]	For machines with sizing device	For machines without sizing device	Finger length [mm]
10/10		X	No
10/11	X		10-11
15/15		X	No
15/16,5	X		15-16,5
20/20		X	No
20/22	X		20-22

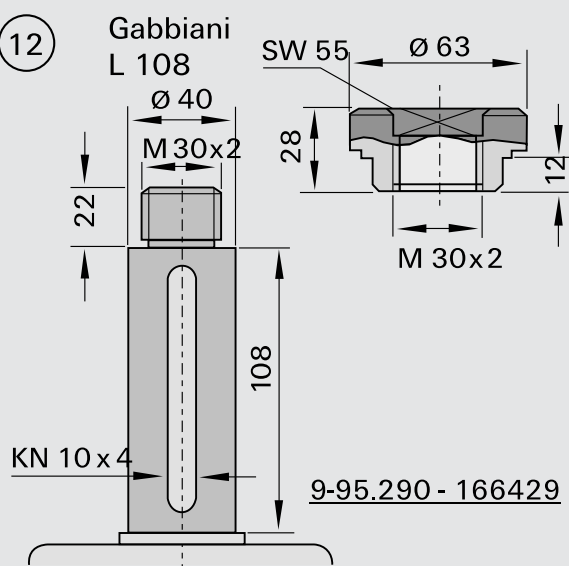
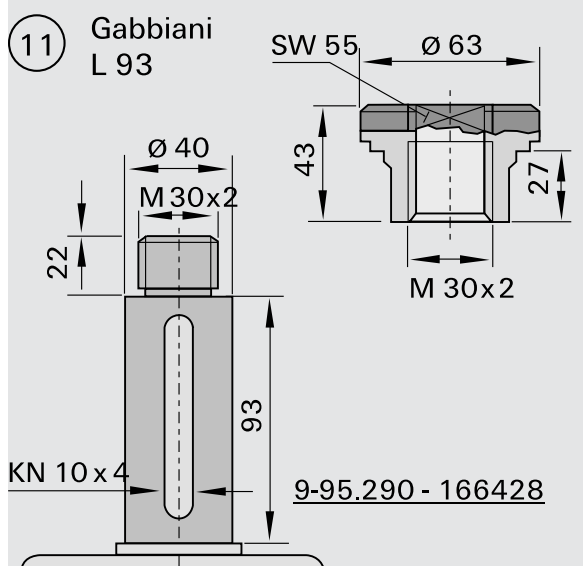
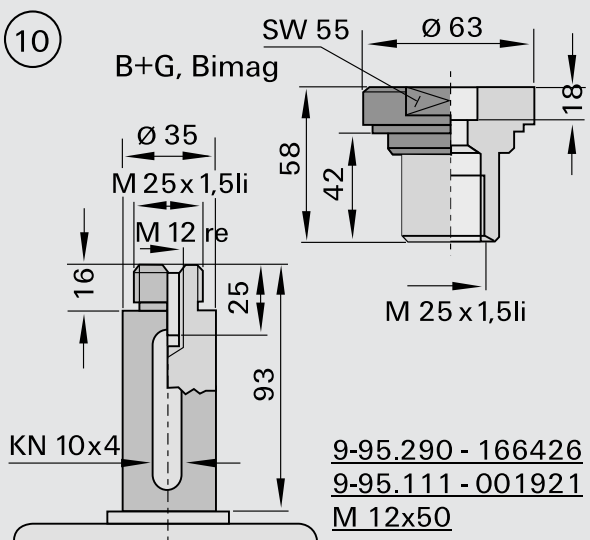
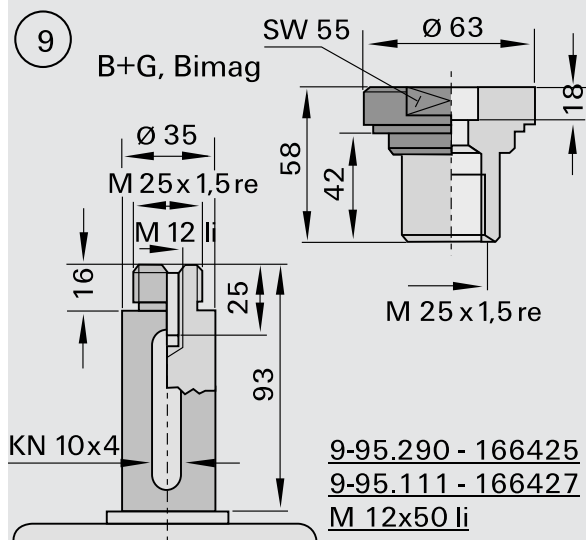
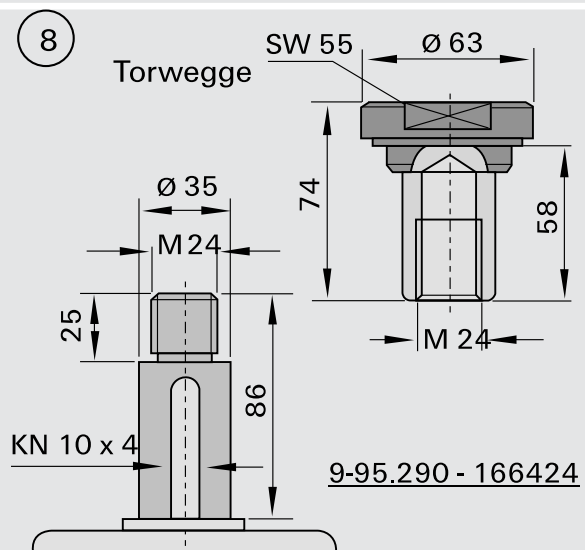
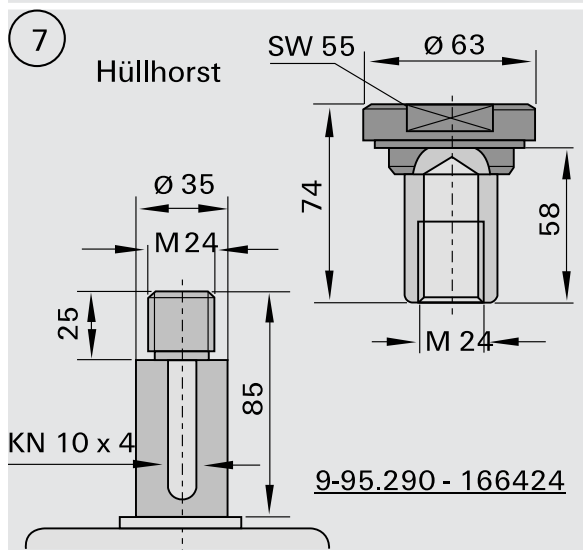
Drawing profile example



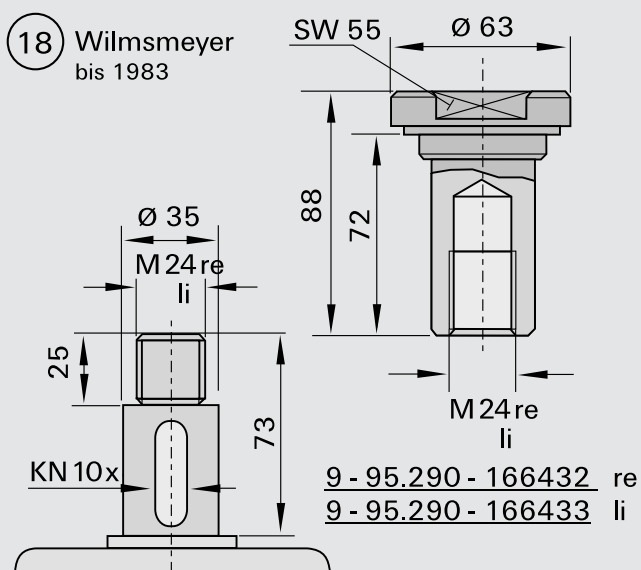
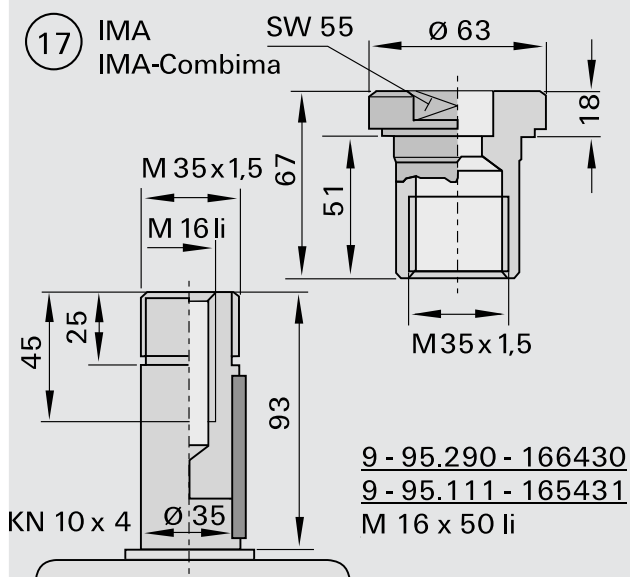
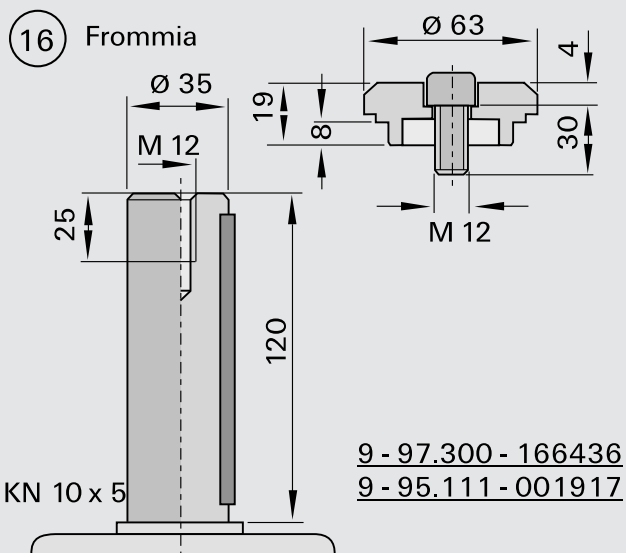
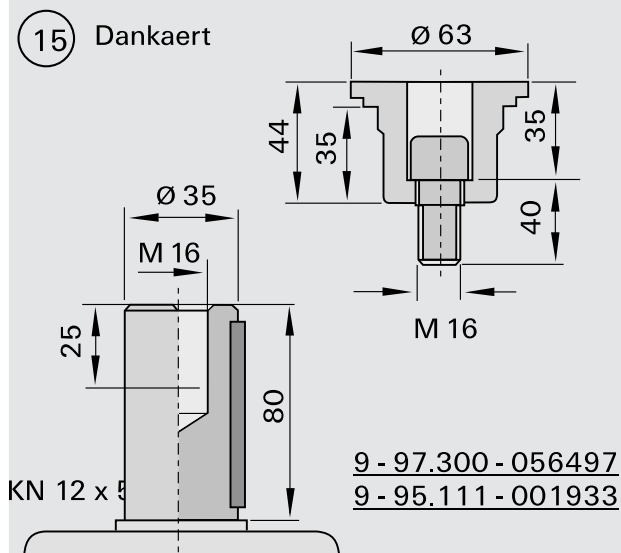
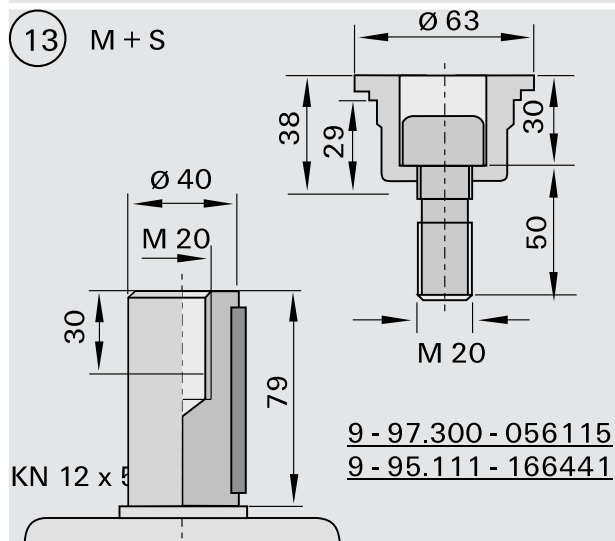
Fasteners for Jointing Cutterheads



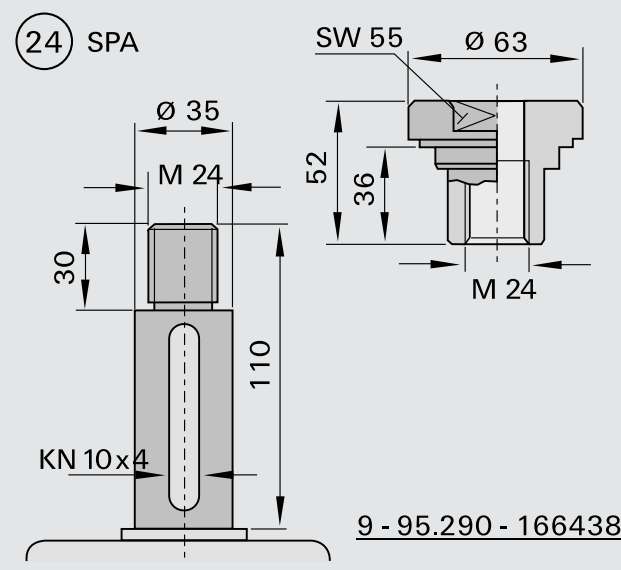
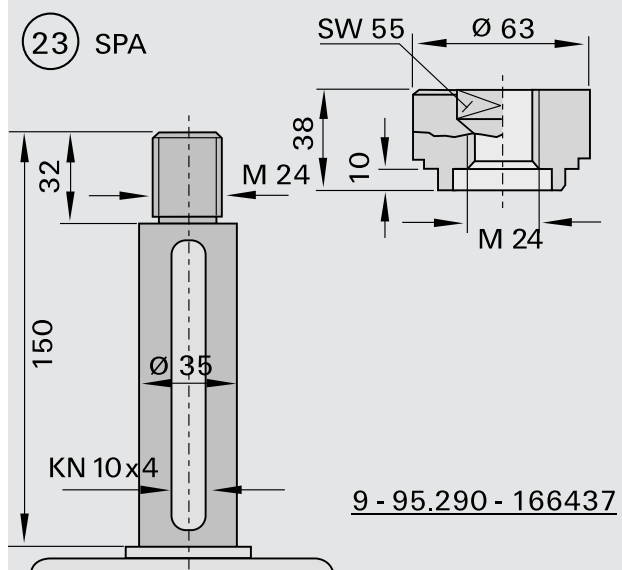
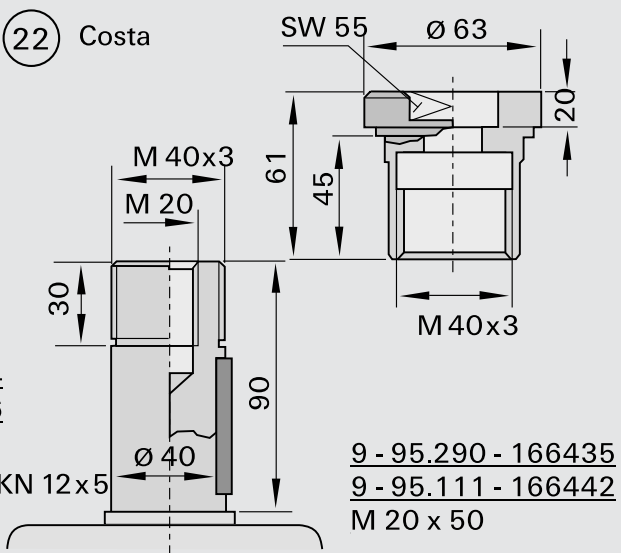
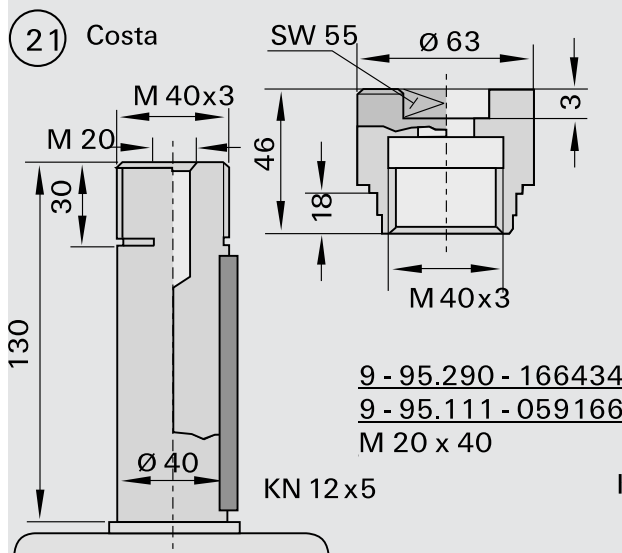
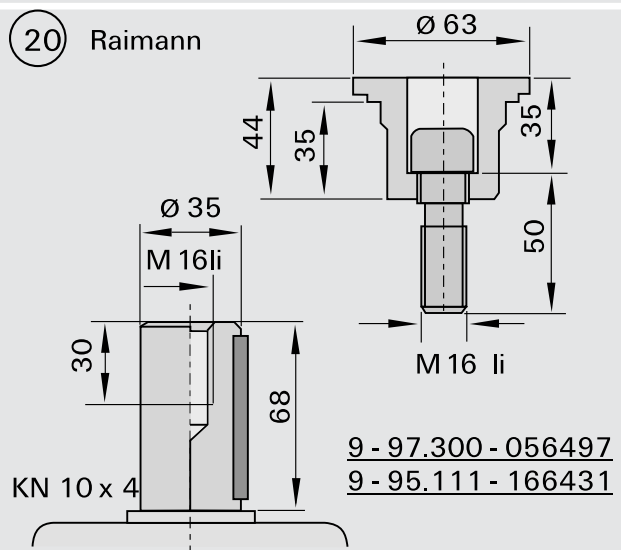
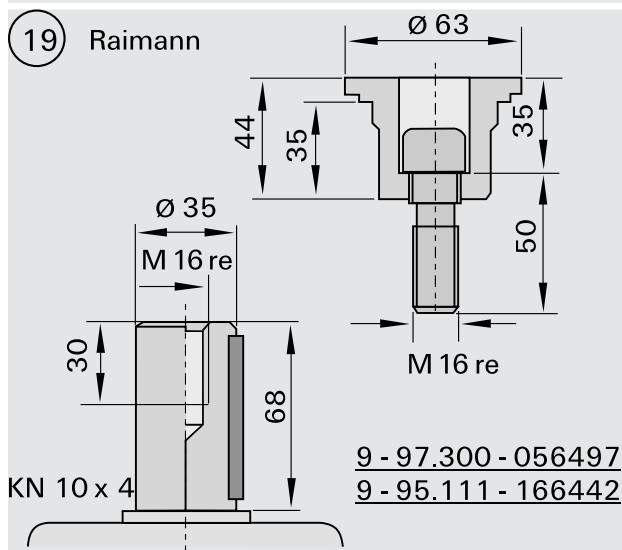
Fasteners for Jointing Cutterheads



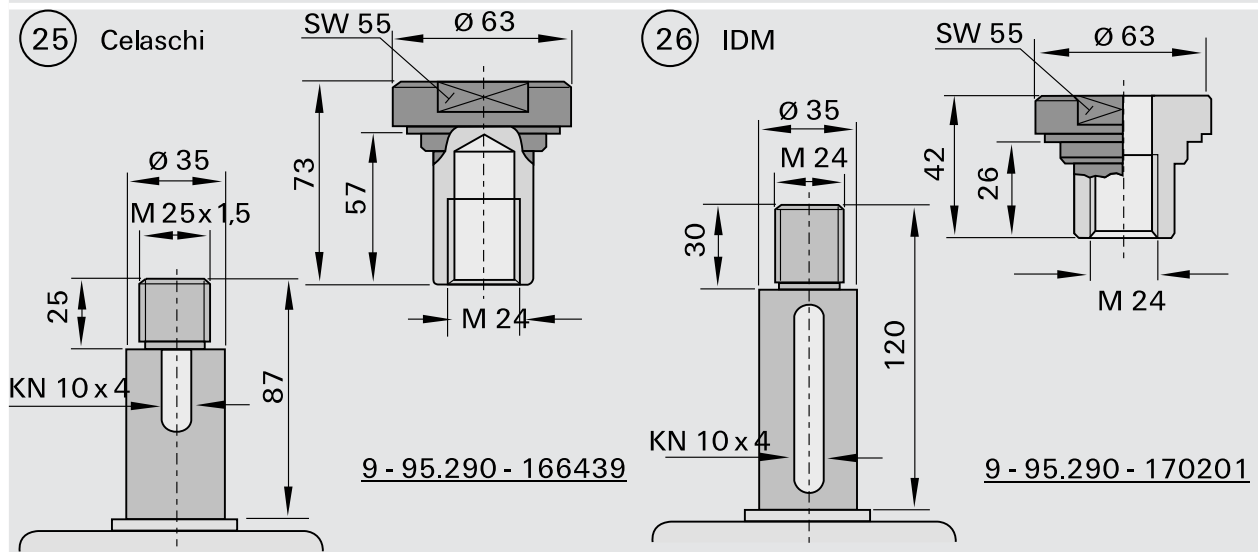
Fasteners for Jointing Cutterheads



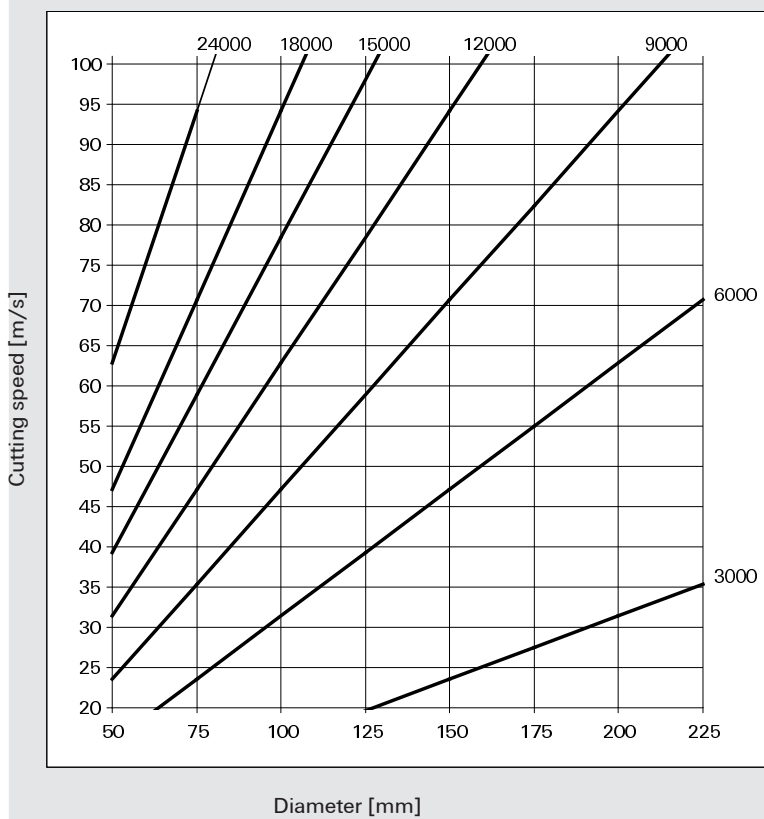
Fasteners for Jointing Cutterheads



Fasteners for Jointing Cutterheads



Determination of RPM [min-1]



Feed rate per tooth

Milling

Workpiece material	Feed rate per tooth fz [mm]
Solid woods with the grain	0,60 - 0,80
Solid woods across the grain	0,30 - 0,40
Laminated woods	0,40 - 0,50
Raw panels	0,50 - 0,70
Laminated panels	0,20 - 0,40
Veneered panels	0,10 - 0,15

Planing

Cutting quality	Effective feed rate per tooth fz eff [mm]	Formulas for calculation
Fine	1,3 - 1,7	Feed rate vf [m/min]
Medium	1,7 - 2,5	Rotations per minute (RPM) [min ⁻¹]
Coarse	2,5 - 5,0	Number of teeth z
		Effective feed rate per tooth (tooth/knife progression) fz eff [mm]
		Tools with conventional clamping
		$fz\ eff = (vf \times 1000) / (n \times 1)$
		Tools with Hydro clamping
		$fz\ eff = (vf \times 1000) / (n \times z)$

Order / Inquiry for Special Tools: Cutters with Bore

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

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

Machine

Make: _____

Model: _____

Type (e.g. DET, etc.): _____

RPM range [min-1] _____

Feed rate [m/min]: _____

Type of feed:	MAN	<input type="radio"/>	MEC	<input type="radio"/>
Sense of rotation:	Left	<input type="radio"/>	Right	<input type="radio"/>
Mode of application:	Against feed	<input type="radio"/>	With feed	<input type="radio"/>
No. of teeth [pcs.]:	_____			
Rakers:	_____			
Spur:	_____			
Grooving knives:	_____			
Edge breaker:	_____			

Workpiece

Description: _____

Cutting quality: _____

Direction of cut:

Solid wood	With grain	<input type="radio"/>	
	Across grain	<input type="radio"/>	
	On end	<input type="radio"/>	
Wood-based materials	Top layer	<input type="radio"/>	
	Middle layer	<input type="radio"/>	
	Top and middle layer	<input type="radio"/>	
Yes	<input type="radio"/>	No	<input type="radio"/>

Arrangement of cutting edges:

Shear angle:	Single-sided	<input type="radio"/>
	Alternate	<input type="radio"/>

Interface

Bore d [mm]: _____

Double keyway:	Height	Width
	_____	_____
Keyway:	Height	Width
	_____	_____

Coating

Description: _____

Further Information _____

Tool

Single tool

Tool set:

With tipped cutting edges:	<input type="radio"/>
With exchangeable cutting edges:	
EcoPro Cutterhead	<input type="radio"/>
SuperProfiler	<input type="radio"/>
UltraProfiler	<input type="radio"/>
Standard	<input type="radio"/>

Clamping Bushing [Ø]: _____

Hydro Bushing [Ø]: _____

Hydro-S-System: _____

S-System: _____

Other: _____

check if applicable

Please indicate the following on workpiece samples or drawings:

Bottom side of workpiece	Dimensions
Sense of rotation	Application conditions
Motor spindle	Profile drawing
Hydro Bushing [Ø]:	Tool drawing

Cutting diameter D [mm]: _____

basic diameter D1 [mm]: _____

Cutting width B [mm]: _____

Depth of cut [mm]: _____

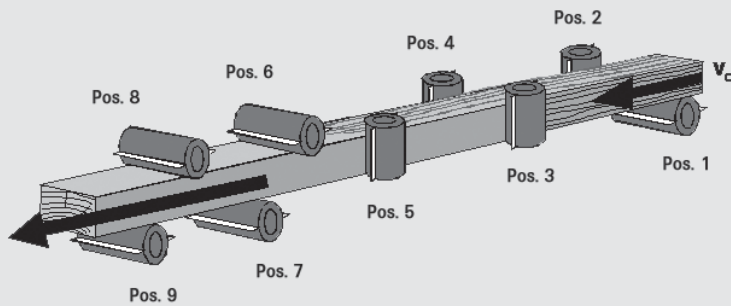
Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.

518-01.0708

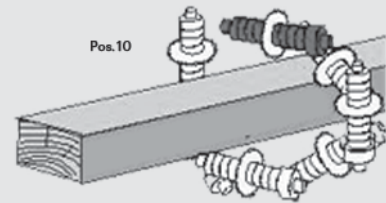
Checklist for molders (incl. „Weinig Powermat“ series)

Overview of the max.possible number of spindles (please mark with a cross)



Universal spindle (pos. 10) can be combined with every type series.

Universal spindle available: Yes No



Additional third spindle above (pos. 11), mostly after the first spindle below (see pos. 1): Yes No

Pos. 1

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 2

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 3

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 4

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

497-03.1207

Checklist for molders (incl. „Weinig Powermat“ series)

Pos. 5

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 7

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 6

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 9

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 10

Spindle diameter (mm): _____

HSK interface: Yes No

Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

Pos. 11

Spindle diameter (mm): _____

HSK interface: Yes No

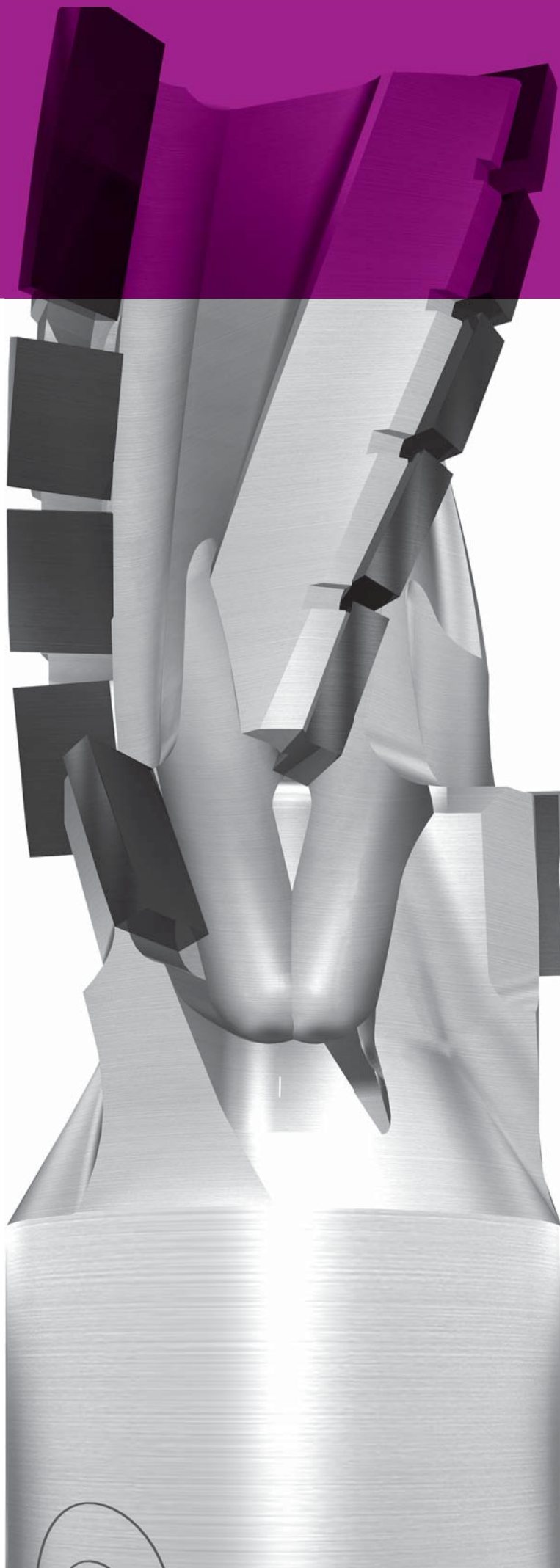
Max. tool diameter (mm): _____

Max.RPM (min-1): _____ RPM variable: Yes No From _____ to _____

Max. vertical adjusting range (mm): _____

Max. horizontal adjusting range (mm): _____

497-03.1207



Shank-Type Cutters

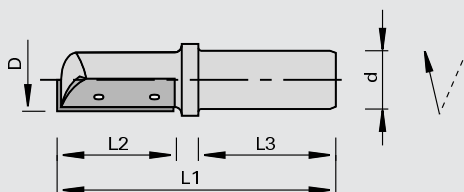
Product	Page
Straight Shank-Type Tools for stationary routers	4-1
Profiled Shank-Type Tools for stationary routers	4-56
Straight Shank-Type Tools for portable routers	4-79
Profiled Shank-Type Tools for portable routers	4-92
Modula	4-101
Technical Information	4-143

128415

Shank-Type Cutters with HW Turnover Knives - Z=1, MAN

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
8	20	9,5	30	60	1		175662
8	20	12	40	70	1		175669
10	25	9,5	30	60	1		175663 o
10	25	10	40	75	1		175678
10	25	12	40	75	1		175670
10	25	16	45	80	1		180797
12	30	12	40	80	1	175665 o	175664
14	30	12	40	80	1	175667 o	175666
16	50	12	40	100	1		175668
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+14	30	5.5	1.1	150535	173482
for Ø D = 16	50	5.5	1.1	150535	173483
	[mm]	[mm]	[mm]		

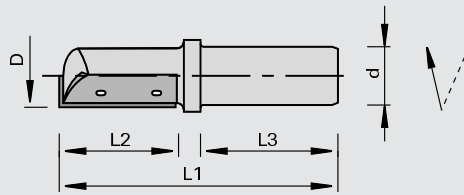
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175662, 175669	925500	175722 o
Clamping Wedges	B=25	175663, 175670, 175678, 180797	925500	175724 o
Clamping Wedges	B=30	175664	925500	175726 o
Clamping Wedges	B=30	175665	925500	175730 o
Clamping Wedges	B=30	175666	925500	175728 o
Clamping Wedges	B=30	175667	925500	175731 o
Clamping Wedges	B=50	175668	925500	175729 o
Head Cap Screws	M2,5x3 T8	175662, 175669	995115	168237
Head Cap Screws	M2,5x4 T8	175663, 175670, 175678, 180797	995115	168238
Head Cap Screws	M3x5,5 T8	175664, 175665, 175666, 175667	995115	168239
Head Cap Screws	M3,5x5,5 T15	175668	995115	168236
Screwdriver with flag	T8	175662, 175663, 175664, 175665, 175666, 175667, 175669, 175670, 175678, 180797	985730	166499
Screwdrivers	T15	175668	985730	163161
	[mm]			

128415

Shank-Type Cutters with HW Turnover Knives - Z=1 with high breaking strength, MAN

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | tool body made of heavy metal
- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05

Advantages

- | high breaking strength

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck, adapter

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	20	12	40	80	1	180816
10	25	12	40	80	1	180817
12	30	12	40	90	1	180818
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø 12	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	180816	925500	175722 o
Clamping Wedges	B=25	180817	925500	175724 o
Clamping Wedges	B=30	180818	925500	175726 o
Head Cap Screws	M2,5x3 T8	180816	995115	168237
Head Cap Screws	M2,5x4 T8	180817	995115	168238
Head Cap Screws	M3x5,5 T8	180818	995115	168239
Screwdriver with flag	T8		985730	166499
	[mm]			

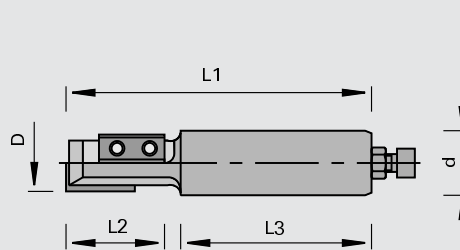
128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to cutter axis and face cutting
- | staggered cutting edges
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck, adapter
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	45	16	43	106	1+1	168612
18	45	25	55	107	1+1	168611
22	55	25	55	117	1+1	168613
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

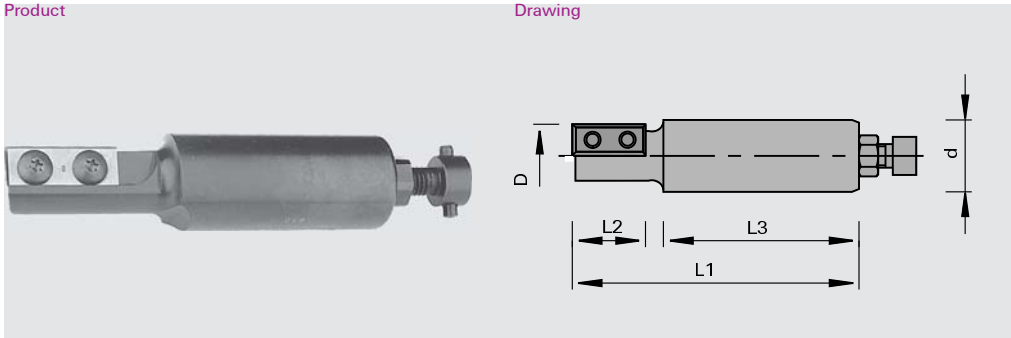
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1 changeable sense of rotation

Product

Drawing



LEUCO DUR

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edge parallel to cutter axis and face cutting
- | customized direction of rotation (right or left) by installing the appropriate turnover knife
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter
- | with attachment screw


Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	100	1(L+R)	171071
18	50	25	55	120	1(L+R)	171070
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	150515	180825
	50	12	1.7	150516	179994
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=48	171070	925900	171069
Clamping Bars	B=27	171071	925900	171068
Round Head Screws	M3,5x12 T15		995195	171067
Screwdrivers	T15		985730	163161
	[mm]			

128410

Shank-Type Cutters with HW Turnover Knives - Z=2 with mini turnover knives

<p>Product</p>	<p>Drawing</p>	 <p>tungsten carbide [HW]</p> <p>MEC</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in solid woods and wood-based panels for cutting of openings and contours traveling plunge cut using Z and X or Y axis 	<p>Design</p> <ul style="list-style-type: none"> cutting edges parallel to cutter axis; peripheral cutting and face cutting cutting material: HW HL Board 05 cutting material: HW HL Board 03 for abrasive materials, e.g. laminated panel boards with attachment screw 	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter with attachment screw
--	--	--------------------------	--

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	100	2	180804
16	50	25	55	120	2	180805
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	Ident-No.
	29,5	9	1.5	HL Board 05	150515	180821
	29,5	9	1.5	HL Board 03	150513	180807
	50	9	1.5	HL Board 03	150516	181982
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3,5x4,8 T15	995195	180915
Screwdrivers	T15	985730	163161
	[mm]		

128260

Shank-Type Cutters with HW Knives - Z=1+1 with alternating shear angle

<p>Product</p>	<p>Drawing</p>	<p>LEUCO DUR</p> <p>tungsten carbide [HW]</p> <p>MEC</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> CNC routers for jointing of chip-free cutting edges in laminated panels for cutting of openings and contours traveling plunge cut using Z and X or Y axis 	<p>Design</p> <ul style="list-style-type: none"> with alternating shear angle plunge tip: Ø 16 - Ø 18 HW-tipped; Ø 30 HW turnover knife with attachment screw 	<p>Advantages</p> <ul style="list-style-type: none"> 2 edge lives by exchanging the upper and lower knife 	<p>Notes</p> <ul style="list-style-type: none"> Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter with attachment screw
--	---	---	--

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	25	55	110	1+1	R 180443 o
16	50	25	55	130	1+1	R 180444
18	50	25	55	130	1+1	R 180445 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	Ident-No.
L2 = 30	16	7	1.5	150523	180262
L2 = 50	28	7	1.5	150523	180260
	[mm]	[mm]	[mm]		

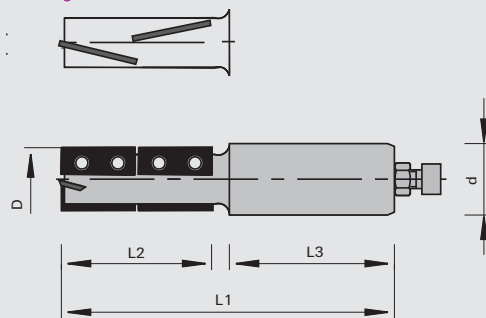
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	995195	180449
Screwdrivers	T9x60	985730	173796
	[mm]		

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, dividing, grooving and rabbeting in laminated panels and solid woods
- | traveling plunge cut using Z and X or Y axis

Design

- | staggered HW knives with with alternating shear angle
- | plunge tip: 4-side HW turnover knife

Advantages

- | 4 edge lives by turning the knives and exchanging the upper and lower turnover knife

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	33	25	55	110	2+2	R 184252
20	33	25	55	110	2+2	L 184255 o
20	53	20	55	125	2+2	R 184253
20	53	25	55	125	2+2	R 184254
20	53	25	55	125	2+2	L 184256 o
30	75	25	55	145	2+2	R 180814 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
L2 = 33	17,5	7	1.5	150515	184257
L2 = 53	29,5	7	1.5	150515	184258
L2 = 75	39,5	9	1.5	150515	180815
plunge tip for Ø 20	9	9	1.5	150515	184259
plunge tip for Ø 30	7,6	12	1.5	150515	052543
	[mm]	[mm]	[mm]		

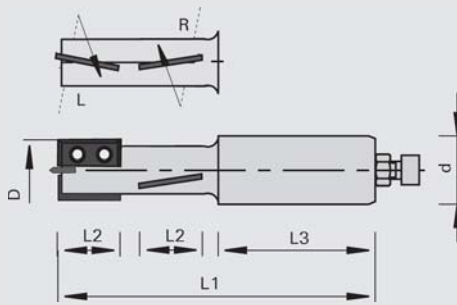
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	for Ø D = 20	995195 180449
Screwdrivers	T9x60	for Ø D = 20	985730 173796
Head Cap Screws	M3,5x5,5 T15	for Ø D = 30	995115 168236
Head Cap Screws	M4x5 T15	for Ø D = 30	995115 180819 o
Screwdrivers	T15	for Ø D = 30	985730 163161
	[mm]		

128260

Shank-Type Cutters with HW Turnover Knives - Z=2+2, sense of rotation L+R

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges of RH resp. LH cutting parts with down-shear angle
- | lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- | with attachment screw

Advantages

Notes

- | workpiece secured on clamping blocks
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
20	28	25	55	130	2+2	180442 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	Ident-No.
	28	7	1.5	150523	180260
	[mm]	[mm]	[mm]		

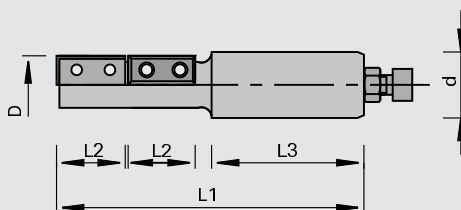
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	995195	180449
Screwdrivers	T9x60	985730	173796
	[mm]		

128410

Shank-Type Cutters with HW Turnover Knives - Z=1+1, 2+2 sense of rotation L+R

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | cutting edges parallel to cutter axis; face cutting
- | customized direction of rotation (right or left) by installing the appropriate turnover knife
- | cutting material: HW HL Board 05
- | lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle
- | Ident-No. 172269 with attachment screw
- | Ident-No. 180227 without attachment screw

Advantages

Notes

- | workpiece secured on clamping blocks
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
18	29	25	55	132	1L+1R	172269
40	40	25	55	158	2L+2R	180227
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	1505 15	180825
	40	12	1.5	1505 15	164078
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=27	925900	171068
Round Head Screws	M3,5x12 T15	995195	171067
Screwdrivers	T15x80	985730	171188
	[mm]		

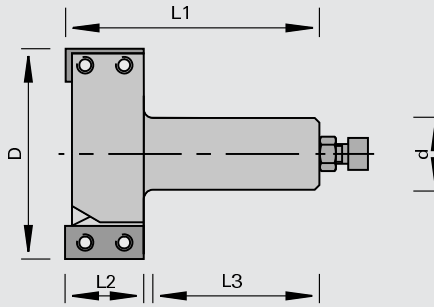
128210

Shank-Type Cutters with HW Turnover Knives for jointing, rabbeting, planing

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and planing in solid woods and wood-based panels

Design

- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with attachment screw

$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No.
80	30	25	55	89	2	168732
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Magnetic Stops	1,0	997800	166094
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

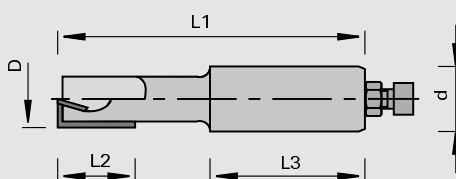
128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MEC

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	16	43	92	1+1	168682
20	30	16	43	96	1+1	168684
20	30	25	55	108	1+1	168685
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Plunge tip for Ø 16	7,6	12	1.5	1505 15	052543
plunge tip for Ø 20	9	12	1.5	1505 15	167256
Turnover Knives	29,5	12	1.5	1505 15	180825
	[mm]	[mm]	[mm]		

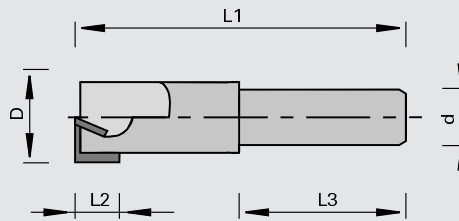
Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3,5x3,8 T15	995 115	162645
Round Head Screws	M3,5x4 T15	995 195	168893
Screwdrivers	T15	985 730	163161
	[mm]		

128215

Shank-Type Cutters with HW Turnover Knives - Z=1+1, MAN

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | 1 cutting edge parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter

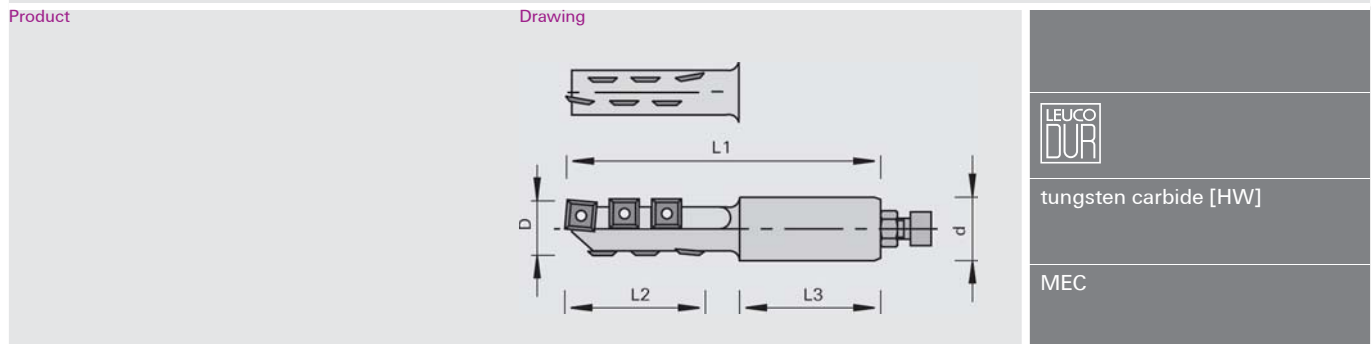
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	12	12	30	70	1+1	180809 o
18	12	12	30	70	1+1	180810 o
20	12	12	30	70	1+1	180811 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
plunge tip for Ø 16+18	7,6	12	1.5	150515	052543
plunge tip for Ø 20	9	12	1.5	150515	167256
Turnover Knives	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	180811	995195	167966
Round Head Screws	M3,5x4 T15	180809, 180810	995195	168893
Screwdrivers	T15		985730	163161
Head Cap Screws	M4x5 T15		995115	180819 o
	[mm]			

128210

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with high milling performance



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for pre-cutting and finish cutting in coated laminated materials traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> upper and lower turnover knife with shear angle cutting material: HW HL Board 05 cutting material: HW HL Board 03 with attachment screw 	<ul style="list-style-type: none"> high hogging volume chip-free cutting edges 	<ul style="list-style-type: none"> Clamping elements: ps-System, Tribos, draw-in collet chuck with attachment screw


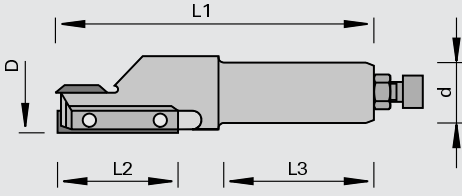

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
22	42	25	55	115	1+1	180802 o
22	60	25	55	131	1+1	180803 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	Ident-No.
	12	12	1.5	HL Board 05	150515	003080
	12	12	1.5	HL Board 03	150513	180820
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

128415

Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives

<p>Product</p> 	<p>Drawing</p> 	 <p>tungsten carbide [HW]</p> <p>MEC</p>
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<p>Machine / Application</p> <ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in solid woods and wood-based panels for cutting of openings and contours traveling plunge cut using Z and X or Y axis 	<p>Design</p> <ul style="list-style-type: none"> 1 cutting edge parallel to cutter axis and peripheral cutting 1 plunging tip cutting material: HW HL Board 05 with attachment screw 	<p>Advantages</p>	<p>Notes</p> <ul style="list-style-type: none"> Clamping elements: ps-System, Tribos, draw-in collet chuck, adapter with attachment screw
---	--	-------------------	---

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	12	40	81	1+1	L 175706 o
16	30	12	40	81	1+1	R 175705
16	30	16	45	91	1+1	L 175713 o
16	30	16	45	91	1+1	R 175712
16	50	16	45	106	1+1	R 175714
16	50	25	55	116	1+1	R 175715
18	30	12	40	81	1+1	R 175707 o
18	50	16	45	106	1+1	R 180798
18	50	25	55	116	1+1	L 175717
18	50	25	55	116	1+1	R 175716
19.05	50	19,05	50	110	1+1	R 175720 o
20	30	12	40	81	1+1	L 175710 o
20	30	12	40	81	1+1	R 175709 o
20	50	25	55	116	1+1	R 175718 o
22	30	12	40	81	1+1	R 175711 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
Mini Turnover Knives	50	5.5	1.1	150535	173483
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175706, 175713	925500	171117 o
Clamping Wedges	B=30	175705, 175712	925500	169280 o
Clamping Wedges	B=30	175707	925500	169281 o
Clamping Wedges	B=30	175710	925500	171119 o
Clamping Wedges	B=30	175709	925500	169282 o
Clamping Wedges	B=50	175714, 175715	925500	171111 o
Clamping Wedges	B=50	175717	925500	171114 o
Clamping Wedges	B=50	175716, 175720, 180798	925500	171113 o
Clamping Wedges	B=50	175718	925500	171115 o
Clamping Wedges	B=30	175711	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175705, 175706, 175707, 175712, 175713, 175714, 175715, 175716, 175717, 175720, 180798	995115	168236
Head Cap Screws	M3,5x6,5 T15	175709, 175710, 175711, 175718	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
	[mm]			

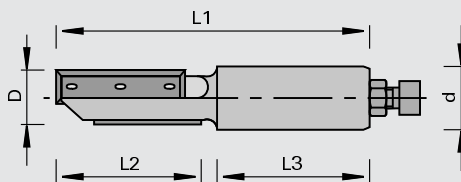
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Screwdrivers	T15 [mm]		985730	163161

128215

Shank-Type Cutters with HW Turnover Knives - Z=2

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in solid woods and wood-based panels
- l for cutting of openings and contours
- l traveling plunge cut using Z and X or Y axis

Design

- l cutting edges parallel to axis in stepped design (Ident-No. 180799 without stepped design)
- l 1 plunging tip
- l cutting material: HW HL Board 05
- l with attachment screw

Advantages

Notes

- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	55	25	55	125	2	180906	177156
20	55	25	55	125	2		177157
20	55	MK 2	55	153	2		177159 o
22	55	25	55	125	2		177158 o
25	50	25	55	119	2		180799
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives

B

H

S

Class-No.

Ident-No.

50

12

1.7

150516

179994

[mm]

[mm]

[mm]

Spare parts

Dimension

For Ident-No.

Class-No.

Ident-No.

Screwdrivers

T15

985730

163161

Round Head Screws

M4x5,9 T15

177156, 177157, 177158, 177159, 180906

995195

167966

Head Cap Screws

M4x6 T15

180799

995195

180989 o

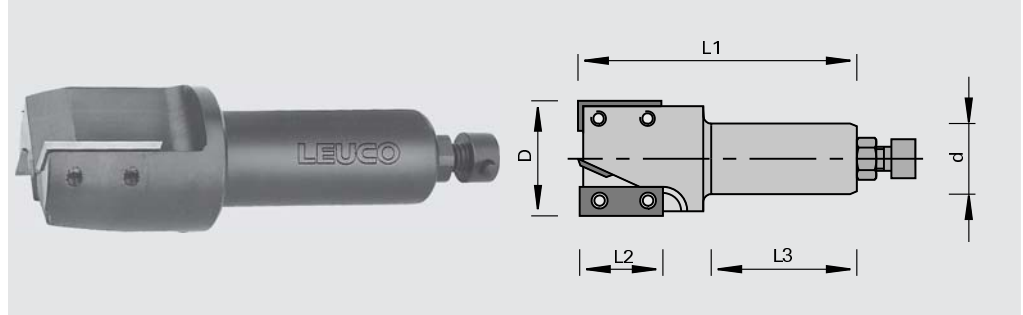
[mm]

128410

Shank-Type Cutters with HW Turnover Knives - Z=2+1

Product

Drawing



LEUCO DUR
tungsten carbide [HW]
MEC

Machine / Application

- | CNC routers
- | for jointing, rabbeting and grooving in solid woods and wood-based panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Dimension

- | 2 cutting edges parallel to cutter axis and peripheral cutting
- | 1 plunging tip with shear angle
- | cutting material: HW HL Board 05
- | with attachment screw

Advantages

Notes

- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with attachment screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
40	30	16	43	91	2+1		168731
40	30	25	55	106	2+1	170815 s	168730
[mm]	[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	29,5	12	1.5	150515	180825
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Magnetic Stops	1,0	997800	166094
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

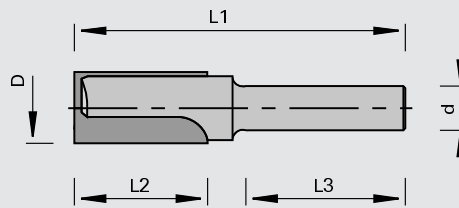
129415

Router Bits HW-tipped - face cutting

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: centric clamping chuck, draw-in collet chuck

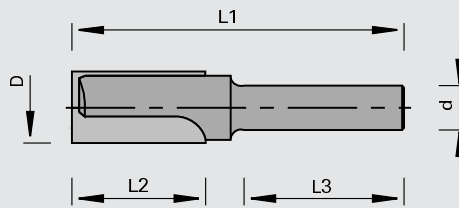
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	9,5	20	52	2	006227
11	24	9,5	20	52	2	006228
10	23	10	35	70	2	160336
12	23	10	35	70	2	160337
14	23	10	35	70	2	160338
16	23	10	35	70	2	160340
20	23	10	35	70	2	160342
12	26	12	40	72	2	006229
14	28	12	40	76	2	006231
15	30	12	40	80	2	006232
16	35	12	40	90	2	180775
18	35	12	40	90	2	180776
20	35	12	40	90	2	180777
25	41	12	40	92	2	006240
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Router Bits with solid carbide body - face cutting

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- routers
- for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

- cutting edges parallel to cutter axis

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: centric clamping chuck, draw-in collet chuck

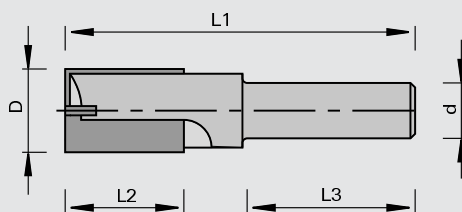
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
3	5	9,5	20	34	2	006219
4	6	9,5	20	37	2	006220
5	7	9,5	20	39	2	006221
8	14	9,5	20	48	2	006225
4	10	10	35	49	2	160332
5	12	10	35	49	2	160333
6	14	10	35	53	2	160334
8	20	10	35	60	2	160335
[mm]	[mm]	[mm]	[mm]	[mm]		

129415

Router Bits HW-tipped - face cutting and plunge tip

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l routers
l for jointing, rabbeting, grooving and copying in hard and exotic woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design and plunging insert allows plunge-cuts
l clamping elements: centric clamping chuck, draw-in collet chuck

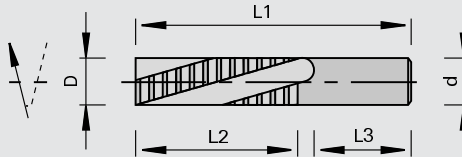
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	35	12	50	90	2	177160
12	35	12	50	90	2	177161
12	45	12	50	90	2	177162
14	35	12	50	90	2	177163
16	35	12	50	90	2	177164 o
18	35	12	50	90	2	177165 o
20	35	12	50	90	2	177166 o
22	35	12	50	90	2	177167 o
24	35	12	50	90	2	177168 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Ecoline Roughing Cutters with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough-cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | well-priced version

Notes

- | Ecoline design = reduced number of traces and less resharpener possibilities
- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

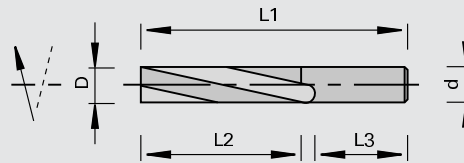
Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
8	32	8	35	75	3	positive	183950
10	32	10	30	75	3	positive	183951
12	42	12	40	90	3	positive	183952
16	35	16	38	90	3	positive	183953
16	55	16	36	110	3	positive	183954
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Ecoline Finishing Cutters with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish-cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | optimum downward chip evacuation thanks to negative spiral
- | well-priced version

Notes

- | Ecoline design = reduced number of traces and less resharping possibilities
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

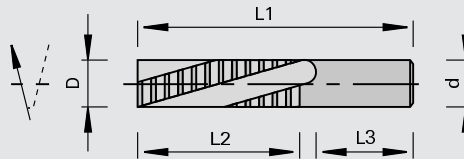
Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	15	3	36	60	2	positive	183937
3	15	6	36	60	2	positive	183938
4	15	4	36	60	2	positive	183939
4	15	4	28	60	2	negative	183940
4	15	6	36	60	2	positive	183941
5	15	6	36	60	2	positive	183942
6	22	6	30	60	2	positive	183943
6	22	6	30	60	2	negative	183944
8	30	8	36	75	2	positive	183945
8	30	8	36	75	2	negative	183946
10	30	10	35	75	2	positive	183947
10	30	10	36	75	2	negative	183948
12	42	12	40	90	3	positive	183949
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Roughing Cutters with solid carbide body - negative spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | cutting pressure towards the bottom thanks to negative spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

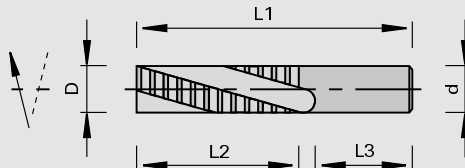
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	30	10	40	75	2	178300
12	42	12	45	90	3	178304
14	35	14	45	90	3	178306 o
16	35	16	48	90	3	178311
16	55	16	48	110	3	178312
18	55	18	48	115	3	178317 o
20	55	20	50	115	3	178320
20	75	20	50	135	3	178323 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Roughing Cutters with solid carbide body - positive spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting in solid woods, plywood and uncoated panels
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

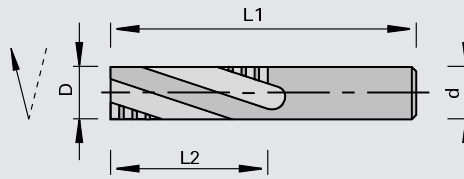
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	45	12	45	90	2	178302
12	45	12	45	90	3	178303
10	30	10	40	75	2	178301
14	35	14	45	90	3	178305
14	55	14	45	110	3	178307
16	35	16	48	90	2	178309
16	35	16	48	90	3	178310
16	55	16	48	110	2	178313
16	55	16	48	110	3	178314
18	55	18	48	115	2	178315 o
18	55	18	48	115	3	178316
20	55	20	50	115	2	178318
20	55	20	50	115	3	178319
20	75	20	50	135	2	178321 o
20	75	20	50	135	3	178322
25	55	25	50	115	4	178324
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Roughing / Finishing Cutters with solid carbide body - positive spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- CNC routers
- for grooving and copying
- shaping of solid woods and wood-based panels

Design

- Z = 4 (2 roughing and 2 finishing knives)
- n max = 30,000 min⁻¹

Advantages

- high cutting performance
- optimum lower cutting edge of the workpiece
- positive spiral direction leads to upward chip ejection

Notes

- roughing knife leads to roughness height of max 0.1 mm
- clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

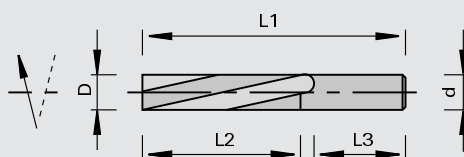
Ø D	L2	Ø d	L1	Z	Ident-No.
12	42	12	90	4	180875
14	50	14	110	4	180876 o
16	55	16	110	4	180877 o
16	35	16	90	4	180878 o
18	55	18	110	4	180879 o
20	60	20	120	4	180880 o
20	70	20	120	4	180881 o
[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters with solid carbide body - negative spiral

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | cutting pressure and chip evacuation towards the bottom thanks to negative spiral

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
4	15	4	28	60	2		178326
6	15	6	36	60	2		178327
8	30	8	36	75	2		178330
10	30	10	40	75	2		178332
12	42	12	45	90	2		178335
12	42	12	45	90	3		178336
14	35	14	45	90	2		178338 o
16	35	16	48	90	2		178342
16	35	16	48	90	3		178343
16	55	16	48	110	3	178349 o	178347
20	55	20	50	115	3		178354
20	75	20	50	135	3		178356
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Finishing Cutters with solid carbide body - positive spiral

Product

Drawing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | n max = 30,000 min-1

Advantages

- | optimal upward chip evacuation thanks to positive spiral

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

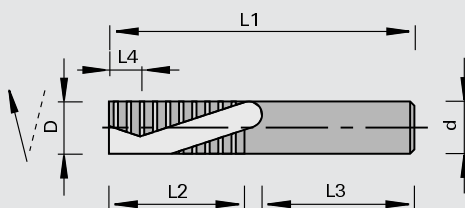
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
6	15	6	36	60	2		178328
8	30	8	36	75	2		178329
10	30	10	40	75	2		178331
12	42	12	45	90	2		178333
12	42	12	45	90	3		178334
14	35	14	45	90	3		178337
14	55	14	45	110	3		178339
16	35	16	48	90	2		178340
16	35	16	48	90	3		178341
16	55	16	48	110	2		178344
16	55	16	48	110	3	178348	178345
18	55	18	48	115	2		178350 o
18	55	18	48	115	3		178351
20	55	20	50	115	2		178352 o
20	55	20	50	115	3		178353
20	75	20	50	135	3		178355
[mm]	[mm]	[mm]	[mm]	[mm]			

129460

Roughing Cutters with solid carbide body - positive/negative spiral with shear angle

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough cutting of solid wood and plastics
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | two-sided shear angle
- | n max = 30,000 min-1

Advantages

- | optimum cutting quality in laminated panels thanks to shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

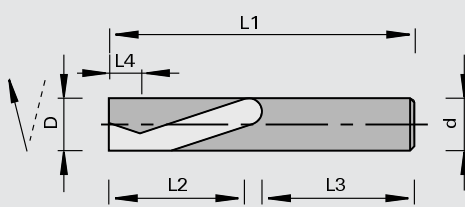
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
20	17	55	20	50	115	2+2	178358
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Finishing Cutters with solid carbide body - positive/negative spiral with shear angle

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish cutting in solid woods and plastic
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | two-sided shear angle
- | n max = 30,000 min-1

Advantages

- | optimum cutting quality in laminated panels thanks to shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

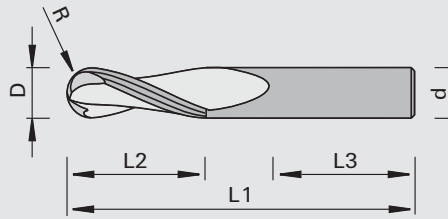
Ø D	L4	L2	Ø d	L1	Z	Ident-No.
8	7	32	8	80	2+2	180870
10	7	32	10	80	2+2	180871
12	7	42	12	90	2+2	180872
16	24	55	16	110	2+2	180873
18	30	55	18	110	2+2	180874
[mm]	[mm]	[mm]	[mm]	[mm]		

129660

Radius Shank-Type Cutter VHW

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for grooving, contour milling and template copying
- | for milling of contours, surface profiles, string wreaths, and other relief profile milling work
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral
- | face-ground
- | solid tungsten carbide (VHW)
- | right-hand cutting
- | no. of cutting edges Z=2 resp. Z=3

Advantages

- | long edge lives thanks to high-quality micrograin carbide

Notes

- | clamping elements: we recommend hydro expansion chuck ps-System, Tribos or heat shrink-fit chuck

Ø D	L2	Ø d	L1	Z	R	Ident-No.
3	12	3	50	2	1,5	185208 o
4	15	4	50	2	2	185209
5	17	5	50	2	2,5	185210 o
6	22	6	60	2	3	185211
8	22	8	70	2	4	185212
10	32	10	70	2	5	185213
10	42	10	100	2	5	185214 o
12	32	12	80	2	6	185215
12	42	12	100	2	6	185216 o
14	42	14	100	2	7	185217 o
16	42	16	100	2	8	185218
16	52	16	100	2	8	185219 o
18	52	18	100	2	9	185220 o
20	52	20	100	2	10	185221
20	72	20	130	2	10	185222 o
[mm]	[mm]	[mm]	[mm]		[mm]	

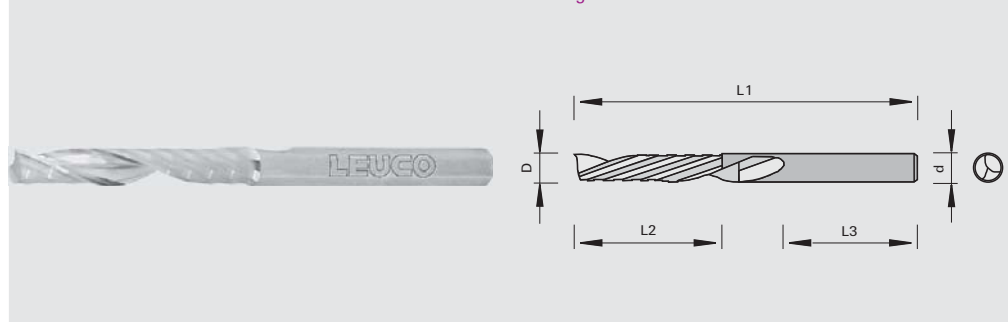
Ø D	L2	Ø d	L1	Z	R	Ident-No.
8	22	8	70	3	4	185223 o
10	32	10	70	3	5	185224 o
10	42	10	100	3	5	185225 o
12	32	12	80	3	6	185226 o
12	42	12	100	3	6	185227 o
14	42	14	100	3	7	185228 o
16	42	16	100	3	8	185229 o
16	52	16	100	3	8	185230 o
18	52	18	100	3	9	185231 o
20	52	20	100	3	10	185232 o
20	72	20	130	3	10	185233 o
[mm]	[mm]	[mm]	[mm]		[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of plastic - Z1

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for jointing, rabbeting and grooving in plastics
- l traveling plunge cut using Z and X or Y axis

Design

- l positive spiral
- l high-polish spiral grooves
- l wear-resistant micrograin carbide HL Board 10

Advantages

- l optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral

Notes

- l negative spiral on request
- l clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

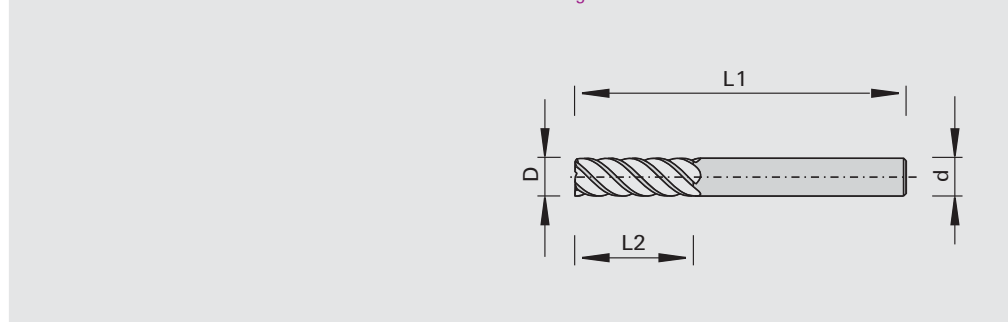
Ø D	L2	Ø d	L1	Z	Helical sense	Ident-No.
3	12	3	50	1	positive	184715
4	15	4	50	1	positive	184716
5	17	5	50	1	positive	184717
6	22	6	60	1	positive	184718
8	22	8	70	1	positive	184719
8	32	8	70	1	positive	184720
10	32	10	70	1	positive	184721
12	32	12	80	1	positive	184722
[mm]	[mm]	[mm]	[mm]			

129460

Polishing Shank-Type Cutter VHW for acrylic glass and PMMA - Z5

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- l CNC routers
- l for finishing of acrylics and PMMA with relatively clear surfaces
- l attention: these tools are not suitable for sizing or dividing but only for polishing!

Design

- l positive spiral
- l high-quality solid tungsten carbide (VHW) with 5 cutting edges

Advantages

- l reduced production times as postprocessing is no longer necessary
- l produces relatively clear surfaces which are sufficient in many cases


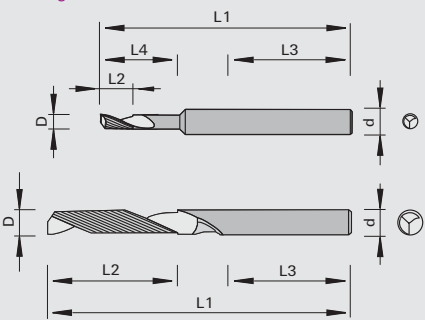

Notes

- l finish milling (removal of 0.05 - 0.1 mm) at a feedrate of approx. 0.5 - 1 m/min
- l high RPM is recommended (18,000 - 24,000 min⁻¹ or higher)
- l application against feed
- l the good quality can only be reached in connection with a precision clamping element

Ø D	L2	Ø d	L1	Z	Helical sense	Ident-No.
6	22	6	60	5	positive	184704
8	25	8	70	5	positive	184705
[mm]	[mm]	[mm]	[mm]			

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1


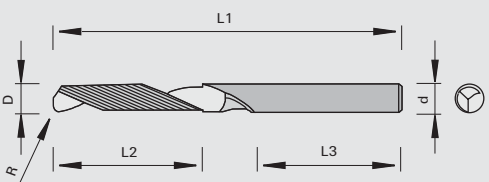

Product 	Drawing 	 Solid Tungsten Carbide MEC
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Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral polished chip gullets 	<ul style="list-style-type: none"> optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral 	<ul style="list-style-type: none"> negative spiral on request clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	L4	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	10	25	8	55	80	1	positive	184709
4	10	25	8	55	80	1	positive	184710
5	10	25	8	55	80	1	positive	184711
6	10	25	8	55	80	1	positive	184712
8	25		8	75	100	1	positive	184713
10	25		10	75	100	1	positive	184714
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z1 with radius

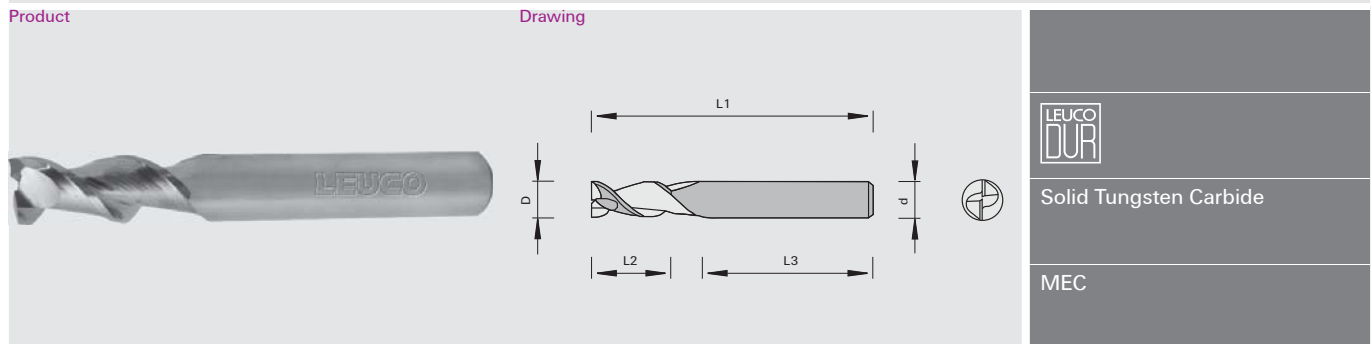
Product 	Drawing 	 Solid Tungsten Carbide MEC
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Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals especially for grooving in aluminum traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral polished chip gullets 	<ul style="list-style-type: none"> especially for aluminum with high silicium rate optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral reduced cutting pressure thanks to radius 	<ul style="list-style-type: none"> negative spiral or reinforced shank diameter on request clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical sense	R	Ident-No.
5	20	6	40	70	1	positive	1,0	183972 o
6	20	8	45	80	1	positive	1,5	183973 o
8	22	10	45	90	1	positive	1,5	183974 o
10	25	10	50	100	1	positive	2,0	183975 o
12	30	12	60	120	1	positive	2,5	183976 o
[mm]	[mm]	[mm]	[mm]	[mm]			[mm]	

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z2



Solid Tungsten Carbide


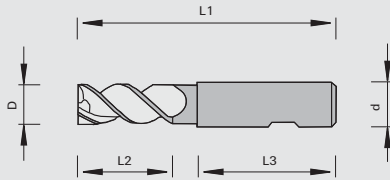

MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral polished chip gullets spiral angle 45° special grinding 	<ul style="list-style-type: none"> optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral 	<ul style="list-style-type: none"> negative spiral or reinforced shank diameter on request clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	8	6	36	57	2	positive	183977 o
4	11	6	36	57	2	positive	183978 o
5	13	6	36	57	2	positive	183979 o
6	13	6	36	57	2	positive	183980 o
8	19	8	36	63	2	positive	183981 o
10	22	10	40	72	2	positive	183982 o
12	26	12	45	83	2	positive	183983 o
16	32	16	48	92	2	positive	183984 o
20	38	20	50	104	2	positive	183985 o
[mm]	[mm]	[mm]	[mm]	[mm]			

129464

High-Performance Shank-Type Cutters with solid carbide body for the machining of aluminum - Z3

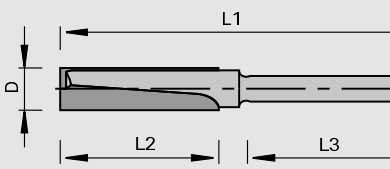

Product	Drawing	
		 Solid Tungsten Carbide MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing, rabbeting and grooving in aluminum alloys, copper alloys and NF metals traveling plunge cut using Z and X or Y axis 	<ul style="list-style-type: none"> positive spiral polished chip gullets cutting edges with variable pitch spiral angle 42° - 43° special grinding 	<ul style="list-style-type: none"> optimal chip removal and excellent cutting quality thanks to specially polished chip gullets and positive spiral smooth and low-noise running thanks to variable pitch 	<ul style="list-style-type: none"> negative spiral or reinforced shank diameter on request clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical sense	Ident-No.
3	8	6	45	57	3	positive	183986 o
4	11	6	39	57	3	positive	183987 o
5	13	6	39	57	3	positive	183988 o
6	13	6	39	57	3	positive	183989 o
8	21	8	38	63	3	positive	183990 o
10	22	10	42	72	3	positive	183991 o
12	26	12	47	83	3	positive	183992 o
16	36	16	50	92	3	positive	183993 o
20	41	20	52	104	3	positive	183994 o
[mm]	[mm]	[mm]	[mm]	[mm]			

129815

Router Bits for Sash Openings HW-tipped

Product	Drawing	
		 tungsten carbide [HW] MAN

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> stationary routers CNC routers for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis 	<ul style="list-style-type: none"> face cutting design allows plunge-cuts clamping elements: draw-in collet chuck, centric clamping chuck 	

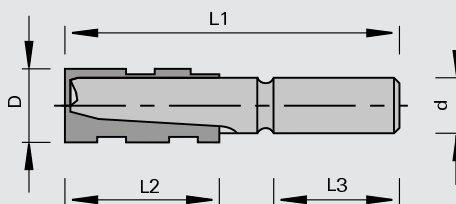
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	40	100	2	058244
[mm]	[mm]	[mm]	[mm]	[mm]		

129815

Router Bits for Sash Openings HW-tipped with chip breakers

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | stationary routers
- | CNC routers
- | for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- | cutting edges parallel to cutter axis with chip breakers

Advantages

- | reduced cutting pressure thanks to chip breakers

Notes

- | face cutting design allows plunge-cuts
- | clamping elements: draw-in collet chuck, centric clamping chuck

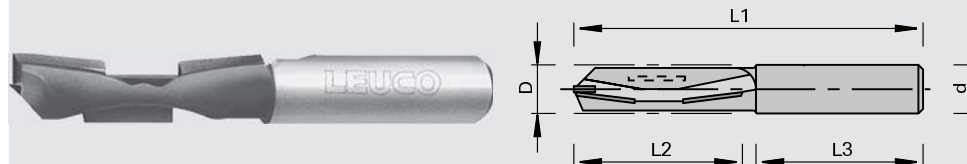
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	12	20	80	2	167728 s
14	50	14	40	100	2	170733 o
[mm]	[mm]	[mm]	[mm]	[mm]		

129860

Router Bits for Sash Openings HW-tipped with shear angle

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | stationary routers
- | CNC routers
- | for cutting of openings in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- | with shear angle
- | n max = 16.000 min-1

Advantages

- | optimum cutting quality on veneered and plastic laminated parts

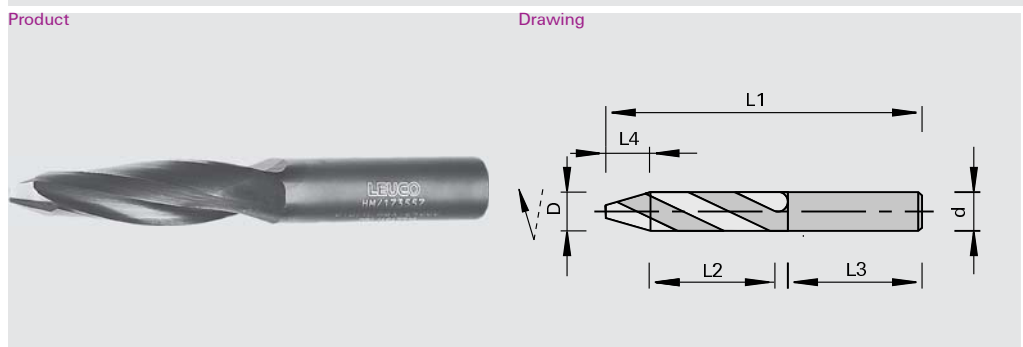
Notes

- | face cutting design allows plunge-cuts
- | clamping elements: draw-in collet chuck, centric clamping chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662
[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Plunge Cutters with solid carbide body - door manufacturing



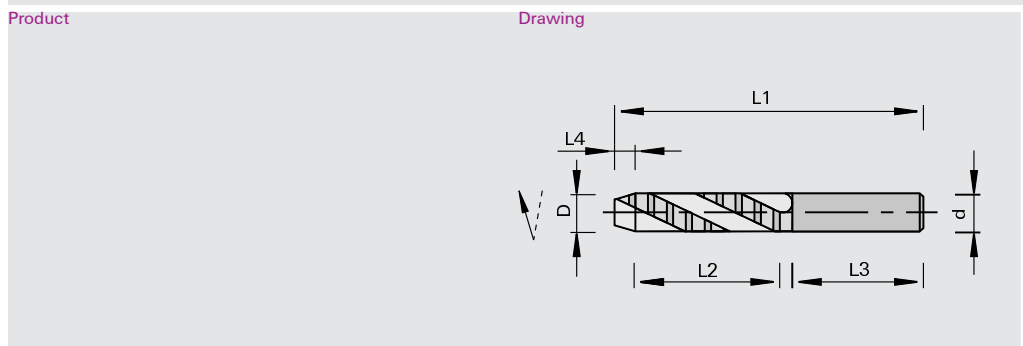
Solid Tungsten Carbide
MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for drilling of peepholes and for through holes 	<ul style="list-style-type: none"> positive spiral n max = 30,000 min-1 		<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	179189
12	10	70	12	50	130	2	179190
14	10	47	14	45	110	2	178359
16	11	52	16	60	130	2	178360
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129460

Plunge Cutters with solid carbide body - door manufacturing



Solid Tungsten Carbide
MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for drilling of latchholes and keyholes 	<ul style="list-style-type: none"> positive spiral n max = 30,000 min-1 		<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck

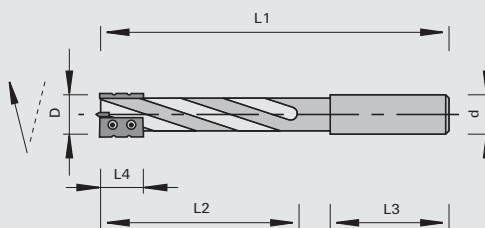
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	5	75	16	60	130	2	178362
20	5	75	20	60	135	3	179191
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

Product

Drawing

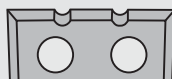
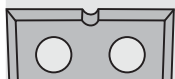


tungsten carbide [HW]

MEC

A

B



Machine / Application

- CNC machining centers
- for cutting of lock-cases and face-plates in doors

Design

- positive spiral
- high-tensile body (heavy metal)
- with HW-tipped (soldered) plunge tip
- knives with chip breaker form A and B
- n max = 18,000 min-1

Advantages

- optimum chip evacuation thanks to positive spiral
- high balance quality thanks to cutting edges with chip breakers
- constant diameter thanks to exchangeable knives

Notes

- clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	16	105	16	55	170	2	183750 o
16	16	105	20	55	170	2	183751 o
18	16	105	20	55	170	2	183752 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

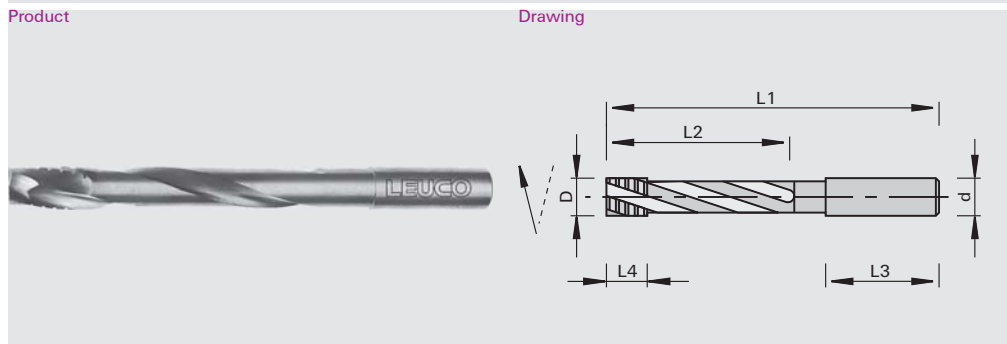
B	H	S	Type	Class-No.	Ident-No.
16	7	1.5	A	150525	183753 o
16	7	1.5	B	150525	183754 o
[mm]	[mm]	[mm]			

Spare parts

Dimension	Class-No.	Ident-No.
Round Head Screws	M3x4,4 T9	995195
Screwdrivers	T9x60	985730
	[mm]	180449
		173796

129460

Lock-Case Roughing Cutters VHW - door manufacturing



LEUCO DUR

Solid Tungsten Carbide

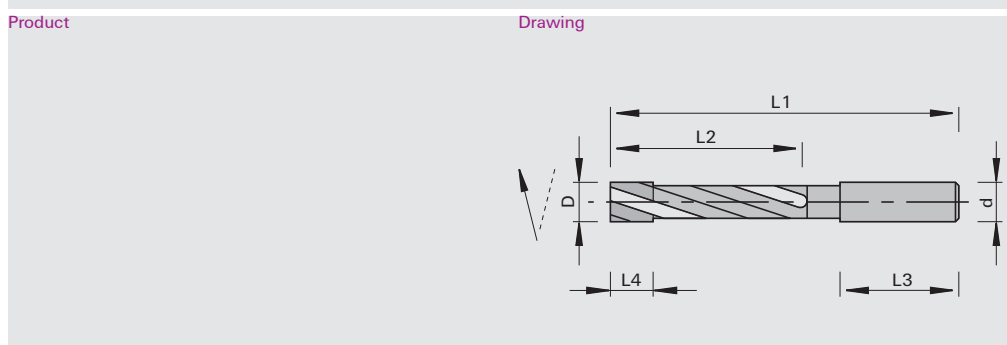
MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for cutting of lock-cases in doors 	<ul style="list-style-type: none"> positive spiral cutting edges with chip breakers roughing cutter 	<ul style="list-style-type: none"> optimum chip evacuation thanks to positive spiral high balance quality thanks to cutting edges with chip breakers 	<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	178839 o
16	25	115	16	50	175	3	24000	178840
18	25	115	18	50	175	3	24000	178841 o
18	25	115	20	50	175	3	24000	178842
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129460

Lock-Case Finishing Cutters VHW - door manufacturing



LEUCO DUR

Solid Tungsten Carbide

MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for cutting of lock-cases and face-plates in doors 	<ul style="list-style-type: none"> positive spiral cutting edges with chip breakers serrated cutting edge with chip breakers 	<ul style="list-style-type: none"> optimum chip evacuation thanks to positive spiral high balance quality thanks to cutting edges with chip breakers 	<ul style="list-style-type: none"> clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	2	24000	178843
16	25	115	16	50	175	2	24000	178958
18	25	115	18	50	175	2	24000	178959 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

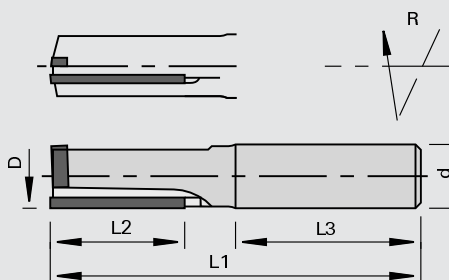
229522

DIAMAX Shank-Type Cutters DP

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

- polished face and high-finish clearance angle
- with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- straight cutter axis
- solid carbide body for $\varnothing 8$ mm and $\varnothing 10$ mm
- resharpening area $\varnothing 8 + \varnothing 10 = 0,5$ mm - $\varnothing 12 + \varnothing 16 = 1,2$ mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge
- increased stability thanks to special design of brazing area

Notes

- Clamping elements: ps-System, Tribos , draw-in collet chuck
- with thread for length adjusting screw

$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	nmax	Ident-No. [L]	Ident-No. [R]
5	12	12	40	60	1	30000		183566 s
6	12	12	40	60	1	30000		183567
8	12	12	35	60	1	30000	178660 s	178659
8	12	12	40	60	2	30000		183568 s
10	22	12	35	70	2	30000	178769	178661
12	25.4	12	35	70	1	24000		181102
16	25.4	16	45	85	1	24000		181104
16	35	16	45	95	1	24000		181106
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

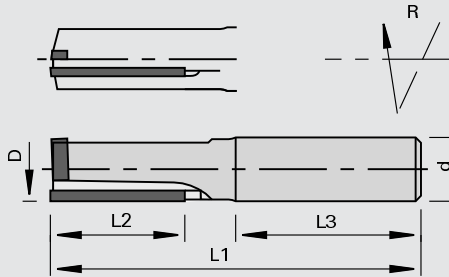
229222

DIAMAX Shank-Type Cutters DP - Z=1

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for jointing and sizing without overlap marks in solid woods and wood-based panels

Design

| polished face and high-finish clearance angle
| with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
| straight cutter axis
| resharpening area 1.5 mm

Advantages

| high quality machining of MDF and hard woods
| no overlap-marks thanks to continuous cutting edge

Notes

| for light millwork only
| Clamping elements: ps-System, Tribos, draw-in collet chuck
| with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	n _{max}	Ident-No. [R]
8	22	12	35	65	1	24000	182664
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

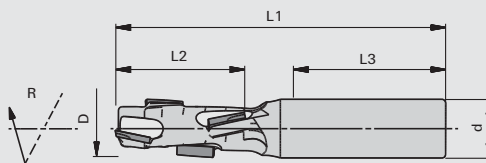
229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with HW plunge tip for diagonal plunge-cutting
| with shear angle
| resharpening area 1.5 mm
| n_{max} = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
| smooth running thanks to spiral cut configuration
| very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

| feed rates up to 12 m/min
| clamping elements: ps-System with reducing sleeves Class-No. 933280, Tribos, draw-in collet chuck
| with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
12	22	12	40	69	1+1		183444
12	28	12	40	75	1+1	183443	183442
12	28	20	55	95	1+1	183441	183440
12	28	25	55	95	1+1	183439	183438
16	22	16	45	78	1+1		183437
16	28	16	45	83	1+1		183435
16	35	16	45	90	1+1	183433	183432
16	22	25	55	90	1+1		183436
16	28	25	55	95	1+1		183434
18	28	16	45	85	1+1		183431
[mm]	[mm]	[mm]	[mm]	[mm]			

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	35	16	45	92	1+1	183427	183428
18	43	16	45	100	1+1	183423	183422
18	35	20	55	102	1+1		183426
18	43	20	55	110	1+1	183421	183420
18	28	25	55	95	1+1	183429	183430
18	35	25	55	102	1+1	183425	183424
18	43	25	55	110	1+1	183419	183418
20	28	20	55	95	1+1		183797 s
20	35	20	55	102	1+1		183798 s
20	52	25	55	120	1+1	183417	183416
[mm]	[mm]	[mm]	[mm]	[mm]			

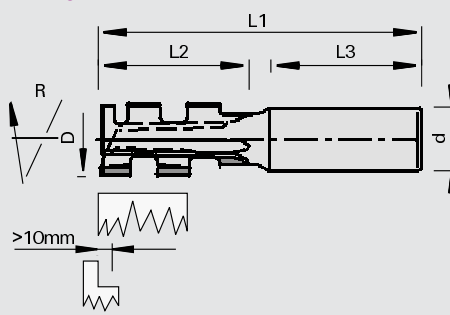
229222

DIAMAX Shank-Type Cutters DP - Z=1+1

Product



Drawing



LEUCO
DIAMAX

polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers "Inch-Program"
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with HW plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 1.5 mm
- n max = 24,000 min⁻¹

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to spiral cut configuration
- very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

- feed rates up to 12 m/min
- Clamping elements: ps-System, Tribos, draw-in collet chuck
- with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
1/2	1	1/2	1 3/8	2 2/3	1+1	183445
[inch]	[inch]	[inch]	[inch]	[inch]		

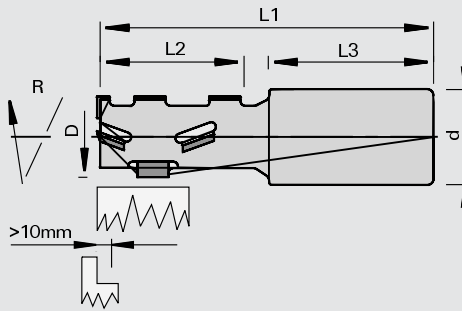
229222

DIAMAX High-Performance Shank-Type Cutters DP - Z=2+2

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

| with HW plunge tip for diagonal plunge-cutting
| with shear angle
| resharpening area 1.5 mm
| n max = 24,000 min-1

Advantages

| optimum cutting quality thanks to shear angle, alternating top and bottom
| smooth running thanks to 4-wing design of cutting edges
| very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

| feed rates up to 20 m/min
| Clamping elements: ps-System, Tribos, draw-in collet chuck
| with thread for length adjusting screw

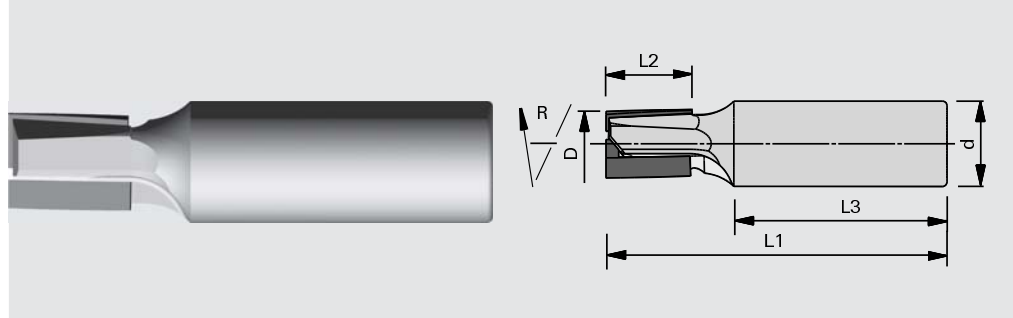
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	28	20	55	95	2+2	183411	183410
20	38	20	55	105	2+2	183413	183412
20	48	20	55	115	2+2	183415	183414
20	28	25	55	95	2+2	183405	183404
20	38	25	55	105	2+2	183407	183406
20	48	25	55	115	2+2	183409	183408
[mm]	[mm]	[mm]	[mm]	[mm]			

229042

High-Performance Shank-Type Cutters DP - for the machining of solid core panels

Product

Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for jointing and sizing without overlap marks in solid woods and wood-based panels
- | especially suited for the machining of plastic solid core panels (e.g. Trespa, Corian, Varicor, LG-HiMacs, etc.)

Design

- | high-performance tool for pre- and finish-milling
- | with face shear angles
- | with DP plunging tip
- | face cutting for diagonal plunge-cutting
- | polished face
- | n max = 24.000 min-1

Advantages

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Resharpening area	Ident-No.
12	15	16	45	75	2+1	1.0	R 184202
12	22	16	45	75	2+1	1.0	R 184203
14	28	16	45	80	2+1	1.5	R 184204
16	20	20	50	80	2+1	2.8	R 182640
16	20	20	50	80	3	1.8	R 184206
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Ø D	B	Ø d	L3	L1	Z	Resharpening area	Ident-No.
1/2	5/8	1/2	45	3	2+1	1.0	R 184205
[inch]	[inch]	[inch]	[mm]	[inch]		[mm]	

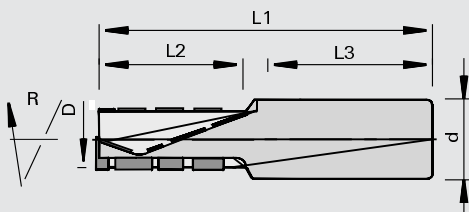
229022

High-Performance Shank-Type Cutters DP - Z=2+1+2

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | high-performance tool for rough and finish milling
- | Z=1 in middle layer and Z=2 in covering layer
- | face cutting for diagonal plunge-cutting
- | with shear angle
- | resharpening area 3.0 mm
- | n max = 30,000 min-1

Advantages

- | good cutting quality on top and bottom edge thanks to opposing shear angle
- | reduced vibrations thanks to variable pitch
- | optimum good chip disposal thanks to open arrangement of cutting edges

Notes

- | feed speed up to 20 m/min when jointing
- | feed speed up to 12 m/min when sizing
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
20	28	25	60	100	2+1+2	12-25		181481
25	35	25	60	110	2+1+2	18-32		181483
25	42	25	60	120	2+1+2	25-40		181485 s
25	48	25	62	120	2+1+2	32-45	181486	181487
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

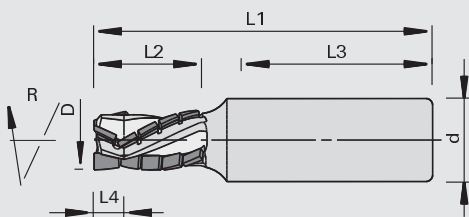
229020

High-Performance Shank-Type Cutters DP - Z=3+3

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for pre- and finish-milling

Design

- | with DP plunge tip for diagonal plunge-cutting
- | with shear angle
- | resharpening area 3.0 mm
- | n max = 24,000 min-1

Advantages

- | optimum cutting quality thanks to shear angle, alternating top and bottom
- | smooth running thanks to spiral cut configuration

Notes

- | feed rates up to 30 m/min
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
18	28	11	25	55	95	3+3	183251 s	183252
20	38	11	20	55	105	3+3	183253 s	183254
25	28	11	25	55	95	3+3	183255	183256
25	38	11	25	55	105	3+3	183257	183258
25	48	11	25	55	115	3+3	183259	183260
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

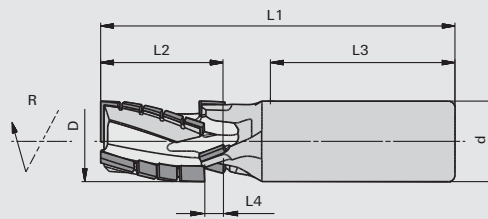
229022

High-Performance Shank-Type Cutters CM DP - Z=3+3

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for rough and finish milling

Design

- | with DP plunge tip for diagonal plunge-cutting
- | with shear angle
- | resharpening area approx. 3 mm
- | n max = 24,000 min-1

Advantages

- | optimum cutting quality thanks to shear angle, alternating top and bottom
- | smooth running thanks to spiral cut configuration
- | optimum chip removal thanks to topward spiral and ChipMeister version

Notes

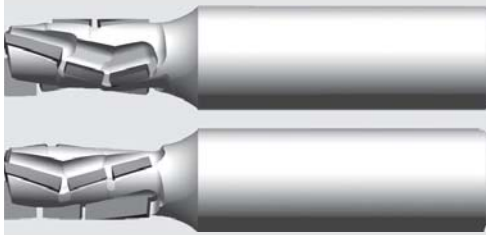
- | feed rates up to 30 m/min
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	L4	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
20	22	6	25	55	90	3+3	183261 s	183262
20	28	6	25	55	95	3+3	183263 s	183264
25	28	8	25	55	95	3+3	183401 s	183400
20	28	6	20	55	95	3+3	183403 s	183402
20	38	6	20	55	105	3+3	183265 s	183266
25	38	8	25	55	105	3+3	183267	183268
25	52	15	25	55	120	3+3	183269	183270
25	65	15	25	55	133	3+3	183271	183272
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

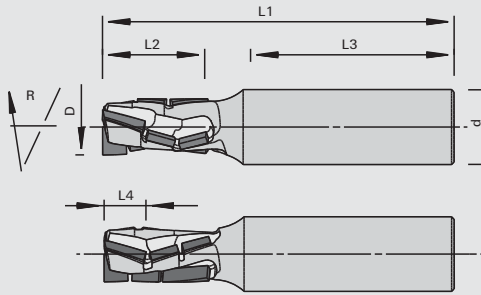
229022

High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for panel sizing with Nesting-Technology
- | for jointing, rabbeting and *grooving (*negative version) in raw and laminated panels

Design

- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | feed rates up to 25 m/min
- | resharpening area 1.6 mm
- | n max = 30,000 min-1

Advantages

- | high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- | positive spiral: optimum upward chip evacuation towards the exhaustion
- | negative spiral: downward chip evacuation and cutting pressure
- | negative spiral especially for smaller or narrow workpieces and for grooving

Notes

- | clamping elements: use in high-precision clamping elements recommended (e.g. Tribos, ps-System)
- | with thread for length adjusting screw
- | in case of higher feed rates and thicker boards choose the higher diameter
- | adapt the cutting length to the panel thickness (H)
- | * indicate "H" in case of Nesting with protection board

Ø D	L2	L4	Ø d	L3	L1	Z	H	Helical sense	Ident-No. [R]
12	22		16	45	75	3+3	16-19 *	positive	184185
12	28		16	45	80	3+3	22-25 *	positive	184186
16	22		16	45	75	3+3	16-19 *	positive	184303
16	28		16	45	80	3+3	22-25 *	positive	184187
12	22	10	16	45	75	3+3	-19	negative	184188
16	28	10	16	45	80	3+3	-25	negative	184189
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

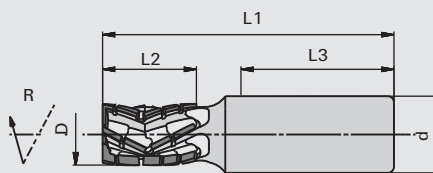
229022

High-Performance Shank-Type Cutters DP - Z=5+5

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for rough and finish milling

Design

- | arrow-shaped toothing
- | with DP plunge tip for diagonal plunge-cutting
- | with shear angle
- | resharping area approx. 2 mm
- | n max = 24,000 min-1

Advantages

- | optimum cutting quality thanks to shear angle, alternating top and bottom
- | very long edge lives and continuous high cutting quality
- | smooth running thanks to spiral cut configuration

Notes

- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
20	30	25	55	95	5+5	183172 s
20	35	25	55	100	5+5	183173 s
[mm]	[mm]	[mm]	[mm]	[mm]		

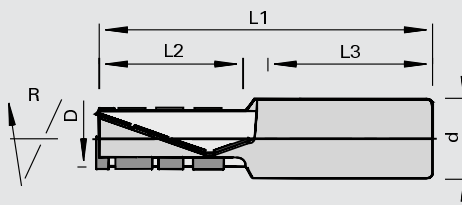
229022

High-Performance Shank-Type Cutters with solid carbide body DP - Z=3

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | high-performance tool for rough and finish milling, as well as panel sizing with Nesting-Technology
- | with DP plunging tip
- | face cutting for diagonal plunge-cutting
- | feed speeds up to 25 m/min
- | resharpenable area 2.0 mm
- | n max = 24,000 min-1

Advantages

- | high cutting quality and smooth running thanks to spiral design of cutting edges
- | optimum good chip disposal thanks to open arrangement of cutting edges
- | optimum cutting lengths suitable for most popular panel thicknesses

Notes

- | clamping elements: ps-System, Tribos , draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No.
12	21	16	45	73	3	16-19	181935
12	28	16	45	80	3	22-25	181936
12	30	16	45	82	3	28	181937
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

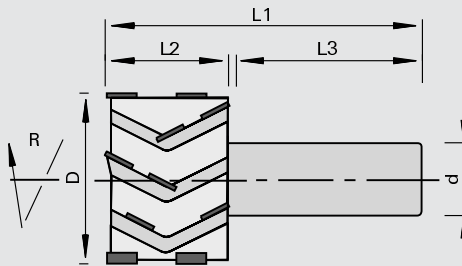
229320

High-Performance Trimming Router Bits DP - Z=4+2+4

Product



Drawing



LEUCO
topline

LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | high-performance tool for finish cuts
- | with shear angle
- | resharpening area 3.0 mm

Advantages

- | high feed rates (up to 35 m/min) and good edge quality thanks to 4 cutting edges working in top layer
- | minimized formation of dust thanks to 2 cutting edges working in core of board
- | very good surface thanks to large cutting circle diameter
- | good cutting quality on top and bottom edge thanks to opposing shear angle

Notes

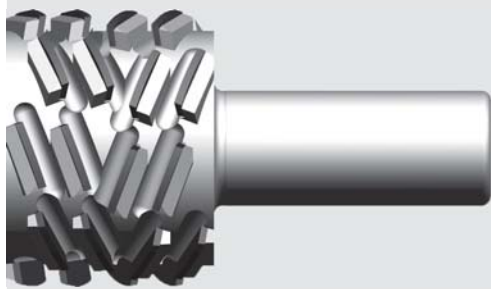
- | preferably for finish-cut operations on pre-sized workpieces
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	Ø d	L3	L1	Z	H	Ident-No. [L]	Ident-No. [R]
48	22	25	62	85	4+2+4	16-19	181498 s	181499
48	28	25	62	91	4+2+4	22-25	181500 s	181501
48	35	25	62	98	4+2+4	28-32	181502 s	181503
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

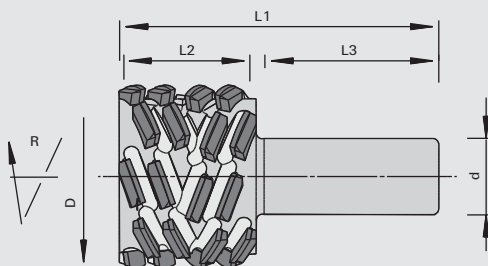
229324

p-System High-Performance Jointing Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing of solid woods (free of knots) along and across the grain
- | for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | symmetrical and asymmetrical design
- | non-convex design
- | extremely scoring cut
- | resharpening area 4 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | with thread for length adjusting screw
- | recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- | crowned design on request
- | clamping element: precision clamping element e.g. ps-System, Tribos
- | sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	Shear∠	Ident-No. [R]
48	28,2	25	62.2	100	3+3	70	184081
48	38	25	57.4	105	3+3	70	184082
60	38	25	57.4	105	3+3	70	184083 s
60	38	25	57.4	105	4+4	70	184084
60	67,4	25	56.8	135	3+3	70	184080 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

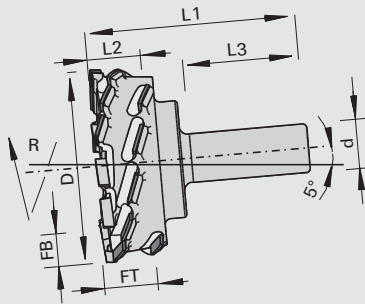
229324

p-System High-Performance Rabbeting Shank-Type Cutter CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | 5-axis machining centers
- | for chip-free high-performance rabbeting of solid woods (free of knots) along and across the grain
- | for high-performance rabbeting of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | tool to be used on spindle tilted by 5°
- | resharpening area front 2.5 mm, peripheral side 3 mm

Advantages

- | maximum cutting quality on both rabbeting sides and maximum edge lives
- | chip-free cuts even on the exit side

Notes

- | recommended feed rate per tooth: wood-based panels 0.5 - 0.8 mm, solid wood 0.25 - 0.4 mm
- | clamping element: precision clamping element e.g. ps-System, Tribos, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

∅ D	L2	∅ d	L3	L1	Z	FB	FT	Shear∠	Ident-No. [R]
100	18,6	25	65	99	3+3	10	15	70	184731
100	28,3	25	65	110	3+3	16	25	70	184732 s
100	43	25	65	120	3+3	16	38	70	184733 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[°]	

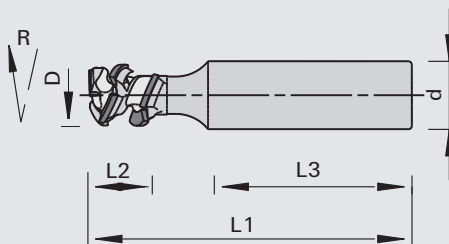
229324

p-System High-Performance Grooving Shank-Type Cutters CM DP

Product



Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for grooves, cut outs, pockets and as forend cutter
- | for chip-free high-performance grooving of solid woods (free of knots) along and across the grain
- | for high-performance grooving of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | resharpening area front 1.8 mm, peripheral side 2.4 mm

Advantages

- | maximum cutting quality and edge lives
- | chip-free cuts even on the exit side

Notes

- | minimal grooving depth 0.5 mm
- | as from 25 mm Z=2 is possible, bottom cutting edge is Z=1 always
- | convex bottom cutting edge for better bottom quality of rabbet, however corner of rabbet not absolutely sharp
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, Tribos, heat shrink-fit chuck
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

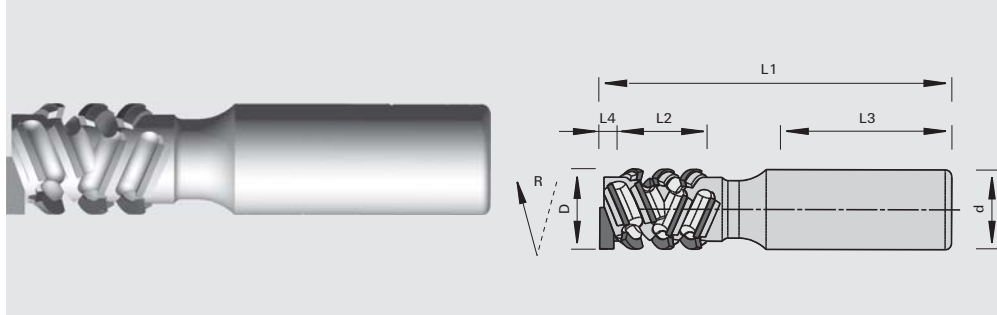
Ø D	L2	Ø d	L3	L1	Z	Shear◁	Ident-No. [R]
18	7	20	53	90	1+1	70	184772
18	19	20	53	95	1+1	70	184773
25	9	25	51	95	1+1	70	184774 s
25	18	25	51	100	1+1	70	184775 s
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

229324

p-System High-Performance Shank-Type Cutters CM DP

Product

Drawing



LEUCO
topline

LEUCO
p-system

polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC stationary machines
- | for chip-free high-performance jointing and dividing of solid woods (free of knots) along and across the grain
- | for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- | Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- | extremely scoring cut
- | DP plunge tip
- | resharpening area 2.5 mm

Advantages

- | maximum cutting quality and edge lives
- | large depth of cut possible
- | chip-free cuts even on the exit side
- | perfectly suitable for laser-edge-technology

Notes

- | adjust the tool to run centrally to the workpiece
- | Tools with plunge tip must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- | for ramping or circular plunging only
- | recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- | clamping element: precision clamping element e.g. ps-System, Tribos
- | with thread for length adjusting screw
- | sense of rotation according to DIN-EN 50144

Ø D	L4	L2	Ø d	L3	L1	Z	H	Shear∠	Ident-No. [R]
20	3.8	25,9	25	55	105	1+1+1	22,9	70	184379
20	3.8	29,5	25	55	110	1+1+1	26,5	70	184380
20	3.8	33,1	25	55	115	1+1+1	30,1	70	184381
25	3.8	26,5	25	55	105	2+2+1	23,5	70	184382
25	3.8	30,8	25	55	110	2+2+1	27,8	70	184383
25	3.8	48,0	25	55	130	2+2+1	45,0	70	184384
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[°]	

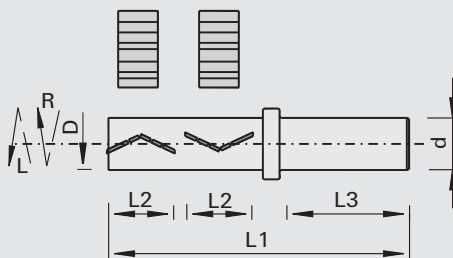
229020

Combination Shank-Type Router Bits RH-LH DP - Z=3/1

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- | high-performance tool for pre- and finish-milling

Design

- | Z=3 on right hand cutting section for highest feed rates
- | Z=1 on left hand cutting section
- | resharpenable area 3.2 mm

Advantages

- | lower part of the cutter can be run in left hand rotation by adjusting the Z-axis and changing the direction of rotation; this allows optimum machining of frail edges utilizing only one spindle

Notes

- | L2 eff. = L2 eff. = real cutting length; this tool has Z=3 the difference to L2 is Z=2; this allows the machining of all current panel boards
- | workpiece secured on clamping blocks
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

Ø D	L2	L2 eff.	Ø d	L3	L1	Z	Ident-No.
25	2x22	L2 eff. 19.5 mm	25	62	129	3/1	179497 s
25	2x26	L2 eff. 23.3 mm	25	62	137	3/1	179498 s
25	2x30	L2 eff. 27 mm	25	62	145	3/1	179499
25	2x34	L2 eff. 31 mm	25	62	153	3/1	179500 s
[mm]	[mm]		[mm]	[mm]	[mm]		

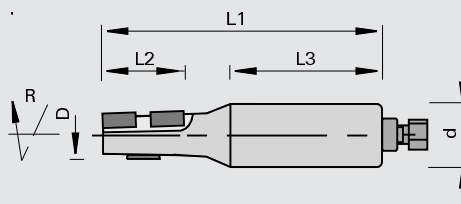
229021

Conical Shank-Type Cutters DP - Z=1+1

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | counter edge banding machines
- | CNC routers
- | for dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- | max. feed speed 30m/min
- | resharpenable area 2.2 mm
- | n max = 18,000 min⁻¹

Advantages

- | high feed speed possible

Notes

- | the finishing of the contour requires further operations
- | Clamping elements: ps-System, Tribos , draw-in collet chuck
- | with thread for length adjusting screw

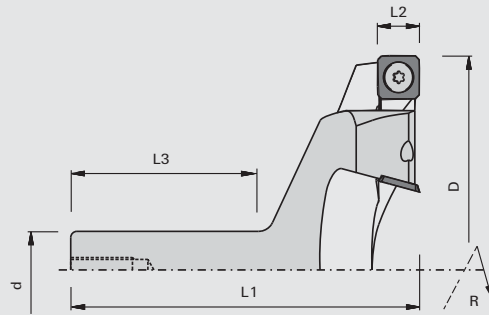
Ø D	L2	Ø d	L3	L1	Z	Tmax	Ident-No. [L]	Ident-No. [R]
18	36	25	65	120	1+1	32	182111 s	179024 s
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

128200

Planing and Rabbeting Shank-Type Cutterheads HW

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design

cutting material: HL Solid 25

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

Notes

- with thread for length adjusting screw
- sense of rotation according to DIN-EN 50144

Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
100	14	20	45	96	4	15200	182619 s
100	14	25	55	96	4	15200	182620
150	14	25	55	113	4	10100	182621 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives

B

H

S

Class-No.

Ident-No.

14	14	2
[mm]	[mm]	[mm]

150558

182441

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M5x6 T20

995125

176199

Screwdrivers

T20x100

985730

[mm]

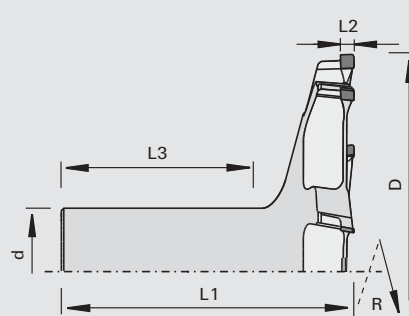
166092

229020

Planing and Rabbeting Shank-Type Cutter DP

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design

resharpening area 3.5 mm

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

Notes

- with thread for length adjusting screw
- sense of rotation according to DIN-EN 50144

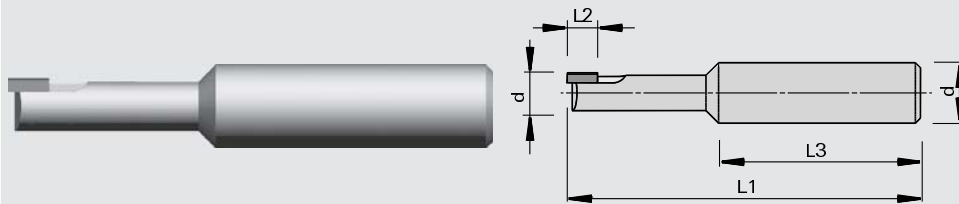
Ø D	L2	Ø d	L3	L1	Z	nmax	Ident-No. [R]
80	5,6	20	61.3	90	6	18000	182660 s
80	5,6	25	62	90	6	24000	182659 s
100	5,6	20	58.6	90	8	18000	182658
100	5,6	25	59.3	90	8	24000	182657 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

829720

MONO-DIA Shank-Type Cutters - Z=1

Product

Drawing



Mono Diamond [DM]

MEC

Machine / Application

| CNC machining centers
 | for cutting of transparent, high-gloss surfaces in plexiglass

Design

| without face cutting edge
 | with face cutting edge
 | resharpening area 1,0 mm
 | n max = 24,000 min-1

Advantages

| high edge quality which requires postprocessing in rare cases only

Notes

| Finish milling (removal of 0.1 - 0.2 mm) at a feed rate of approx. 1 m/min
 | the quality can only be reached in connection with a precision clamping element, optimally with Tribos power shrink-fit chuck

Without face cutting edge

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	5	12	40	70	1	182522 s
8	6	12	40	70	1	182523
8	8	12	40	70	1	182524 s
20	5	25	55	80	1	182528 s
20	6	25	55	80	1	182529 s
20	8	25	55	80	1	182530 s
[mm]	[mm]	[mm]	[mm]	[mm]		

With face cutting edge

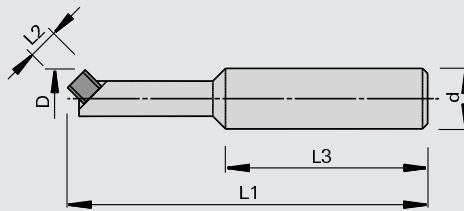
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	5	12	40	70	1	182525 s
8	6	12	40	70	1	182526 s
8	8	12	40	70	1	182527 s
20	5	25	55	80	1	182531 s
20	6	25	55	80	1	182532 s
20	8	25	55	80	1	182533 s
[mm]	[mm]	[mm]	[mm]	[mm]		

829730

MONO-DIA Chamfering Cutters - Z=1

Product

Drawing



Mono Diamond [DM]

MEC

Machine / Application

- | CNC machining centers
- | for cutting of transparent, high-gloss surfaces in plexiglass
- | for milling of chamfers on top- and bottom edge

Design

- | resharpenable area 1.0 mm
- | n max = 24,000 min-1

Advantages

Notes

- | Finish milling (removal of 0.1 - 0.2 mm) at a feed rate of approx. 1 m/min
- | the quality can only be reached in connection with a precision clamping element, optimally with Tribos power shrink-fit chuck

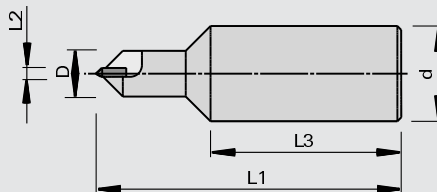
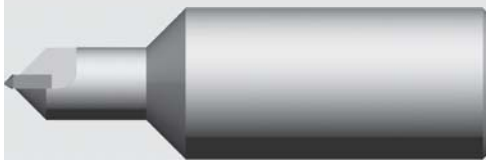
Chamfer	Ø D	L2	Ø d	Z	Ident-No.
45 [°]	16 [mm]	4 [mm]	25 [mm]	1	182535 s

829760

MONO-DIA Engraving Cutters - Z=1

Product

Drawing



Mono Diamond [DM]

MEC

Machine / Application

- | CNC machining centers
- | for V engravings in plexiglass

Design

- | resharpenable area 0.5 mm
- | n max = 24,000 min-1

Advantages

Notes

- | up to max. 1,5 mm engraving depth

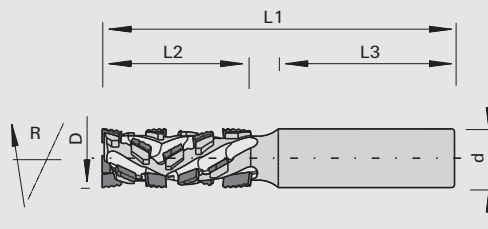
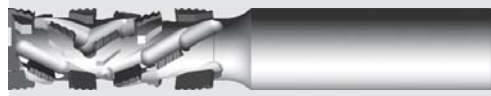
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12 [mm]	3 [mm]	25 [mm]	50 [mm]	80 [mm]	1	182534 s

229042

Shank-Type Roughing Cutter DP

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for sizing in roughing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels or other abrasive materials such as GFK, HPL-compact boards and several sandwich materials
- | for cutting of openings and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | with alternating shear angle
- | with DP plunge tip
- | face cutting for diagonal plunge-cutting
- | resharpening area ≥ 2.0 mm
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | for long edge lives also in abrasive materials
- | chip-free cutting edges on both sides
- | high hogging volume

Notes

- | slightly rough cutting surface due to fine cut division
- | clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", Tribos or heat shrink-fit chucks

$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No. [R]
20	35	20	60	105	2+2	185026
20	50	20	60	120	2+2	185027
[mm]	[mm]	[mm]	[mm]	[mm]		

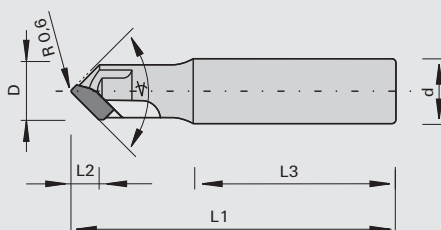
229060

Vektrogramm Cutter DP - 90°

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
| for grooving in Vektrogramm-technique (Grey-scale millings)

Design

| cutting material: DP
| Topline design
| resharpening area 2 mm

Advantages

| very long edge lives particularly in hard panel materials
| optimal cutting quality thanks to polished face and special division of cut

Notes

| the Vektrogramm technique is a computer-based method to transfer image information by milling onto board materials

∅ D	L2	L3	∅ d	L1	Z	∠	Ident-No.
14	7	50	16	80	1	90	185 156
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	

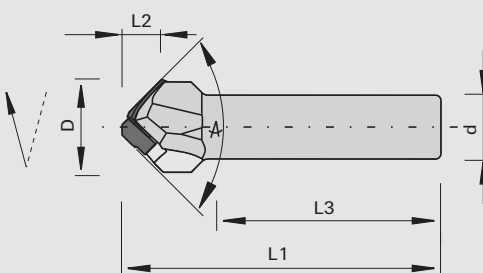
229460

V-Groove Cutter DP for aluminum composite materials

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC machines
| for V-grooves in aluminum composite materials (Aluco-bond, Dibond, etc.)

Design

| cutting material: DP
| Topline design
| resharpening area 2 mm

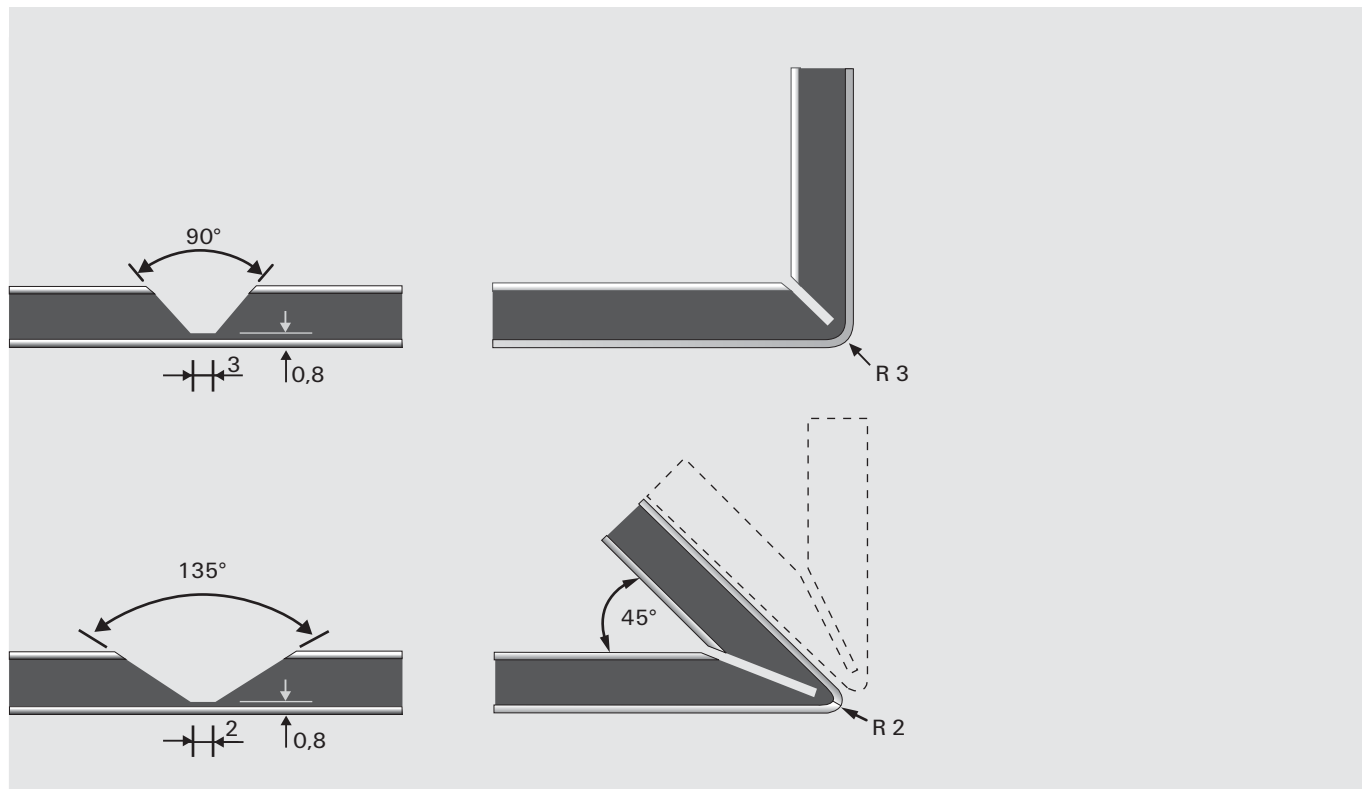
Advantages

| very long edge lives particularly in composite materials with mineral core
| optimal cutting quality thanks to polished face and special division of cut

Notes

| clamping elements: ideal use in precision clamping elements e.g. ps-System, Tribos or heat-shrinking chuck

∅ D	L2	L3	∅ d	L1	Z	∠	Ident-No.
18	7,5	40	12	60	1+1	90	185025
32	6,2	40	12	60	1+1	135	185 196
[mm]	[mm]	[mm]	[mm]	[mm]		[°]	



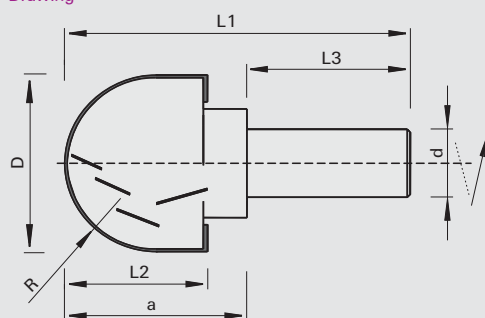
128660

Spherical Cutterhead HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC 5-axis routers
- | for milling shapes and contours in solid wood and wood-based panels
- | ideal for forms

Design

- | with shank
- | n max = 15,000 min-1

Advantages

- | high volume to be removed
- | simple tool change

Notes

- | ideal for the basic equipment of a 5-axis machine
- | please order adapters separately
- | clamping elements: ps-System, Tribos, heat-shrinking chuck, draw-in collet chucks
- | NEW, extra long tool adapters

R	Ø D	L2	Ø d	L3	L1	Z	a	Ident-No.
32,5	65	52	25	60	127	2+2	67	185082
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives

B	H	S	R	Class-No.	Ident-No.
20	12	1.5		150515	003082
20	11.5	1.5	30,7	151521	185083
[mm]	[mm]	[mm]	[mm]		

Spare parts

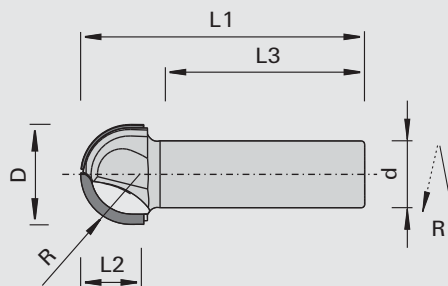
Dimension	Class-No.	Ident-No.
T15x80	985730	171188
SW3x100	985730	166090
[mm]		

229560

DIAMAX PCD Bull-Nose Shank-Type Cutter

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC machines
- | for contour milling and template copying
- | for 3D-milling work, 3D-models, relief-milling work

Design

- | TOPLINE design
- | resharping area 1.5 mm
- | n max = 24,000 min-1

Advantages

- | long edge lives
- | high quality of cut thanks to polished cutting edges and ultra-fine eroding of back of the tooth

Notes

- | clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks "ps-System", Tribos or heat shrink-fit chucks

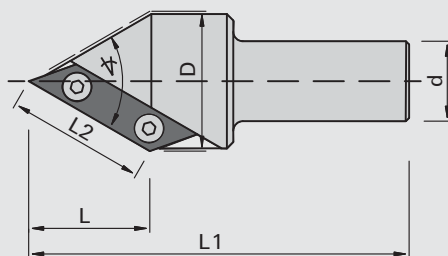
R	Ø D	L2	Ø d	L3	L1	Z	Ident-No.
10	20	14	20	55	85	2	185240
15	30	19	20	55	85	2	185241
20	40	24	20	55	85	2	185242
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

128410

Folding Chamfering Cutterheads HW - Z1

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- | CNC 5-axis routers
- | for picking of internal corners and for chamfering, for the cutting of ornamental grooves and folding cuts in solid wood and wood-based panels

Design

- | with shank
- | n max = 15,000 min-1

Advantages

Notes

- | please order adapters separately
- | clamping elements: ps-System, Tribos, heat-shrinking chuck, draw-in collet chucks

Wedge<	Ø D	L2	L	Ø d	L1	Z	Ident-No.
60	41.5	41,5	35.5	25	118	1	185138
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	50	12	1.5	150515	185140
	[mm]	[mm]	[mm]		

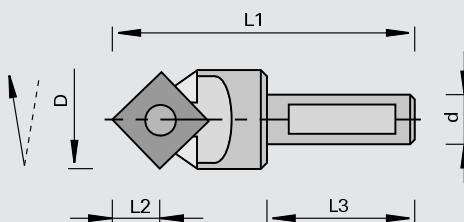
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M3,5x4 T15	995195	168893
Screwdrivers	T15	985730	163161
	[mm]		

128415

Ornamental Groove Cutters with HW TOK

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | CNC routers
- | for cutting of ornamental grooves, inscriptions and engravings in solid woods and wood-based panels

Design

- | with negative shear angle

Advantages

- | combination with other shank-type tools allows 2 processes on one spindle
- | chip-free cutting of laminated panels thanks to negative shear angle

Notes

- | clamping elements: ps-System with reducing sleeves Class-No. 933280, draw-in collet chuck for combination with cutterheads as tool set
- | included in delivery: Ident-No. 171169 SP16 cutter assembly with TOK Ident-No. 003080 or set Ident-No. 171217 see profile drawings

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No.
17	8,3	10	21	48	1	SP 16	171169
						Set	171217 &
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

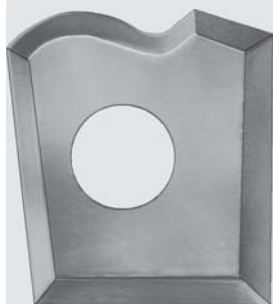
Turnover Knives	B	H	S	Drawing/Foil	Class-No.	Ident-No.
	12	12	1.5	SP 16	150515	003080
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3,5x6,5 T15	995115	163223
Screwdrivers	T15	985730	163161
	[mm]		

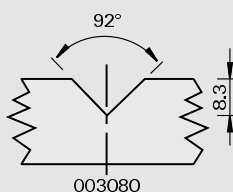
150514 / 151521

Profile Knives HW for ornamental groove cutterheads

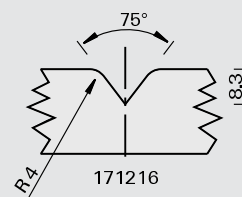
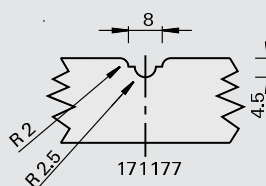
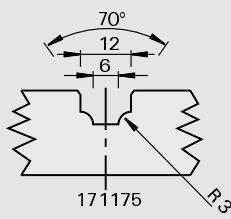
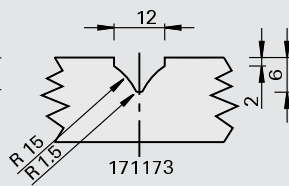
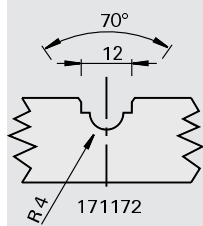
Product



Drawing



tungsten carbide [HW]



Machine / Application

Design

Advantages

Notes

included in delivery of set
 Ident-No.171217: 1 piece
 ornamental groove cutter with
 shank (Ident-No.171169)
 / 1 piece turnover
 knife 12x12x1.5 (Ident-
 No.003080) / 2 pieces each
 double-sided profile knives
 Class-No. 151521 (Ident- No.
 and drawing as shown)

B	H	S	Drawing	Ident-No.
12	12	1.5	SP 16	003080
11	12	1.5		171172
11	12	1.5		171173
11	12	1.5		171175 #
12	12	1.5		171177 #
12	12	1.5		171216
[mm]	[mm]	[mm]	[Foil]	

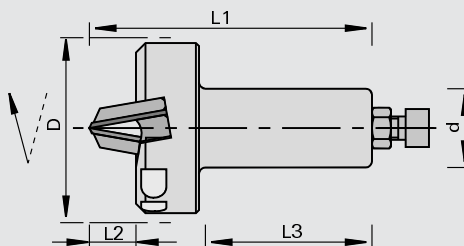
128612

Ornamental Groove SuperProfiler Shank-Type Cutterheads HW

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for cutting of ornamental grooves in solid woods and wood-based panels

Design

- l with positive shear angle
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l n max = 18,000 min-1

Advantages

- l cutterhead for mounting of several profile knives

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, Tribos, draw-in collet chuck
- l included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Z	Drawing	Ident-No. unprofiled
59	13	25	62	97	2	SP 17	173268
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 17	152526	179114
SP blanks	30,6	25.5	HL Solid 60	SP 17	152529	177369
support plates				SP 17	925402	178017
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	B=24	925300	173276
Set Screws	M6x10 DIN EN ISO 4028	995161	180002
Screwdrivers	SW3x100	985730	166090
	[mm]		

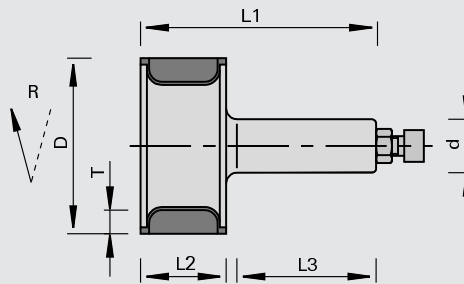
128612

SuperProfiler Shank-Type Cutterheads HW

Product



Drawing


**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for profiling of solid woods and wood materials

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | profile knife can be profiled according to customer specifications
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
82	40	20	55	110	11	2	12000	SP 19		167479
82	40	25	55	110	11	2	18000	SP 19	167835 s	167834
82	40	MK 2	55	127	11	2	18000	SP 19		167483 s
86	60	25	55	130	13	2	10000	SP 31		176241
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28,2	HL Board 06	SP 19	152526	179112
SP blanks	40,6	28,2	HL Solid 60	SP 19	152529	177367
SP blanks	60,8	30,2	HL Board 06	SP 31	152526	179113
SP blanks	60,8	30,2	HL Solid 60	SP 31	152529	177368
support plates	40	28		SP 19	925402	178007
support plates	60	30		SP 31	925402	178008
	[mm]	[mm]				

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	36x12x8	167835	925300	166736
Clamping Bars	36x12x8	167483, 167834, 167479	925300	166737
Clamping Bars	58x12x8	176241	925300	166738
Set Screws	M8x16 DIN EN ISO 4028		995161	164422
Screwdrivers	SW4x100		985730	166091
	[mm]			

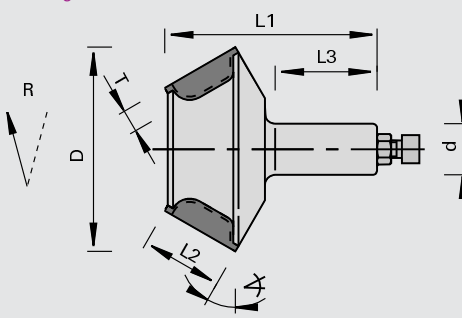
128612

SuperProfiler Shank-Type Cutterheads HW - cranked

Product



Drawing



**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- l CNC routers
- l for profiling of solid woods and wood materials

Design

- l cranked body
- l cutting edges parallel to cutter axis
- l cutting material: HW HL Board 06 for hard woods and wood-based panels
- l cutting material: HW HL Solid 60 for soft woods
- l Ø 100 mm and 110 mm: n max = 12,000 min-1
- l Ø 125 mm: n max = 8,000 min-1

Advantages

- l for deep profiles

Notes

- l profile knife can be profiled according to customer specifications
- l Clamping elements: ps-System, Tribos , draw-in collet chuck
- l included in delivery: cutter-head body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	Drawing	Ident-No. unprofiled
100	40	25	55	119	11	2	SP 18	168184 s
110	40	25	55	120	11	2	SP 27	176235 s
125	60	25	55	140	13	2	SP 28	176237 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 18 / 27	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 18 / 27	152529	177367
SP blanks	60,8	30.2	HL Board 06	SP 28	152526	179113
SP blanks	60,8	30.2	HL Solid 60	SP 28	152529	177368
support plates	40	28		SP 18 / 27	925402	178007
support plates	60	30		SP 28	925402	178008
	[mm]	[mm]				

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	36x12x8	176235, 168184	925300	166737
Clamping Bars	58x12x8	176237	925300	166738
Set Screws	M8x16 DIN EN ISO 4028		995161	164422
Screwdrivers	SW4x100		985730	166091
	[mm]			

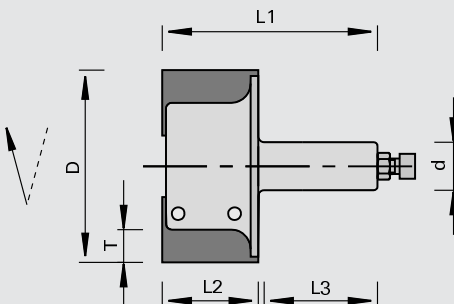
128612

SuperProfiler Shank-Type Cutterheads HW - open on one side

Product



Drawing


**SUPER
PROFILER**

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for profiling of solid woods and wood materials

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | for profiles requiring a cutter body which is open on one side
- | profile knife can be profiled according to customer specifications
- | Clamping elements: ps-System, Tribos, draw-in collet chuck
- | included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [R] unprofild
60	30	16	43	89.6	11	2	12000	SP 23	171033
100	50	25	55	112	16	2	9500	SP 21	171143
120	50	25	55	109	22	2	6500	SP 20	173271
120	60	25	55	118	22	2	6000	SP 22	173270
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	30,6	25.5	HL Board 06	SP 23	152526	179114
SP blanks	30,6	25.5	HL Solid 60	SP 23	152529	177369
SP blanks	49,3	33.7	HL Board 06	SP 21	152526	180199
SP blanks	49,4	44.5	HL Board 06	SP 20	152526	180218
SP blanks	60,6	45.6	HL Board 06	SP 22	152526	179999
SP blanks	60,6	45.6	HL Solid 60	SP 22	152529	178845
support plates	30	25		SP 23	925402	178016
support plates	50	34		SP 21	925402	178015
support plates	50	45		SP 20	925402	178014
support plates	60	45		SP 22	925402	178010
	[mm]	[mm]				

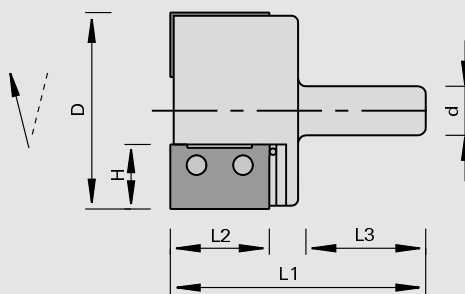
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Bars	28x10x7	171033	925300	171035
Clamping Bars	48x12x8	171143	925300	171147
Clamping Bars	47x14x8	173271	925300	171140
Clamping Bars	56x12x8	173270	925300	167055
Set Screws	M6x10 DIN EN ISO 4028	171033	995161	180002
Set Screws	M8x16 DIN EN ISO 4028	171143, 173270, 173271	995161	164422
Screwdrivers	SW3x100	171033	985730	166090
Screwdrivers	SW4x100	171143, 173270, 173271	985730	166091
	[mm]			

128613

EcoPro-Shank-Type Cutterheads HW

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
62	30	25	25	60	107	2	18000	EP 375	178594 s	178375 s
75	30	30	25	60	107	2	16000	EP 376	178597 s	178376 s
62	40	20	25	60	117	2	18000	EP 377	178592 s	178377 s
75	40	30	25	60	117	2	14000	EP 378	178598 s	178378 s
62	50	20	25	60	127	2	16000	EP 379	178593 s	178379 s
75	50	33	25	60	127	2	12000	EP 380	178600 s	178380 s
85	50	33	25	60	127	2	12000	EP 386	178603 s	178386 s
75	40	32.5	25	60	118	2	12300	EP 478	180332 s	180328 s
85	60	34	25	60	137	2	10000	EP 405	181247 s	181246 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178375, 178594	30,2	25.5	HL Board 06	152586		178527
178375, 178594	30,2	25.5	HL Solid 60	152589		179527
178376, 178597	30,2	30.4	HL Board 06	152586		178528
178376, 178597	30,2	30.4	HL Solid 60	152589		179528
178377, 178592	40,1	20.9	HL Board 06	152586		178533
178377, 178592	40,1	20.9	HL Solid 60	152589		179533
180328, 180332	41	32.5	HL Board 06	152536		180197
178378, 178598	40,1	30.4	HL Board 06	152586		178534
178378, 178598	40,1	30.4	HL Solid 60	152589		179534
178379, 178593	49,9	20.9	HL Board 06	152586		178539
178379, 178593	49,9	20.9	HL Solid 60	152589		179539
178380, 178386, 178600, 178603	49,9	33	HL Board 06	152586		178540
178380, 178386, 178600, 178603	49,9	33	HL Solid 60	152589		179540
181246, 181247	61	34	HL Board 06	152536		180198
178375, 178594	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
178375, 178594	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
178376, 178597	30,2	30.4	HL Board 06 Topline	152786	179585 &	179586 &
178376, 178597	30,2	30.4	HL Solid 60 Topline	152789	179659 &	179660 &
178377, 178592	40,1	20.9	HL Board 06 Topline	152786	179595 &	179596 &
178377, 178592	40,1	20.9	HL Solid 60 Topline	152789	179669 &	179670 &
178378, 178598	40,1	30.4	HL Board 06 Topline	152786	179597 &	179598 &
178378, 178598	40,1	30.4	HL Solid 60 Topline	152789	179671 &	179672 &
178379, 178593	49,9	20.9	HL Board 06 Topline	152786	179607 &	179608 &
178379, 178593	49,9	20.9	HL Solid 60 Topline	152789	179681 &	179682 &
178380, 178386, 178600, 178603	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
	[mm]	[mm]				

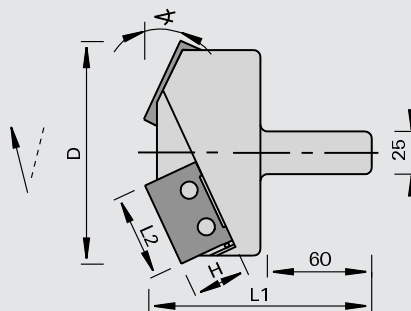
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178380, 178386, 178600, 178603	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181246, 181247	61 [mm]	34 [mm]	HL Board 06 Topline	152736	181259	181258
Spare parts			Dimension	Class-No.	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	178239	
Screwdrivers			T15x80 [mm]	985730	171188	

128663

EcoPro-Shank-Type Cutterheads HW - cranked

Product

Drawing



LEUCODUR

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for profiling of solid woods and wood-based panels

Design

| with shear angle
 | cutting material: HW HL Board 06 for hard woods and wood-based panels
 | cutting material: HW HL Solid 60 for soft woods
 | shank with internal thread M8 for attachment screw

Advantages

| optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
 | cutterhead body and knives will be profiled according to customer specifications

Notes

| profile knives can be profiled according to customer specifications
 | cutterhead body can be used only for one profile
 | please order stop screw separately

Crank∠	∅ D	L2	H	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
60	100	30	25	104	2	11000	EP 387	178604 s	178387 s
60	100	30	30	107	2	9500	EP 388	178606 s	178388 s
60	100	40	20	110	2	13000	EP 389	178605 s	178389 s
60	100	50	20	119	2	11000	EP 391	178607 s	178391 s
60	125	50	33	127	2	7500	EP 392	178609 s	178392 s
45	100	30	25	104	2	10000	EP 393	178610 s	178393 s
45	100	30	30	107	2	9000	EP 394	178611 s	178394 s
45	100	40	20	110	2	13000	EP 395	178612 s	178395 s
45	125	50	20	114	2	10000	EP 397	178614 s	178397 s
45	125	50	33	121	2	7500	EP 398	178615 s	178398 s
45	125	40	32.5	115	2	11000	EP 496	180335 s	180331 s
45	145	60	34	132	2	10000	EP 408	181251 s	181250 s
60	145	60	34	137	2	10000	EP 407	181253 s	181252 s
75	125	60	34	133	2	10000	EP 406	181255 s	181254 s
[°]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178387, 178393, 178604, 178610	30,2	25.5	HL Board 06	152586		178527
178387, 178393, 178604, 178610	30,2	25.5	HL Solid 60	152589		179527
178388, 178394, 178606, 178611	30,2	30.4	HL Board 06	152586		178528
178388, 178394, 178606, 178611	30,2	30.4	HL Solid 60	152589		179528
178389, 178395, 178605, 178612	40,1 [mm]	20.9 [mm]	HL Board 06	152586		178533

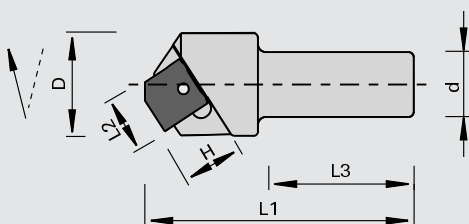
Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178389, 178395, 178605, 178612	40,1	20,9	HL Solid 60	152589		179533
180331, 180335	41	32,5	HL Board 06	152536		180197
178391, 178397, 178607, 178614	49,9	20,9	HL Board 06	152586		178539
178391, 178397, 178607, 178614	49,9	20,9	HL Solid 60	152589		179539
178392, 178398, 178609, 178615	49,9	33	HL Board 06	152586		178540
178392, 178398, 178609, 178615	49,9	33	HL Solid 60	152589		179540
181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06	152536		180198
178387, 178393, 178604, 178610	30,2	25,5	HL Board 06 Topline	152786	179583 &	179584 &
178387, 178393, 178604, 178610	30,2	25,5	HL Solid 60 Topline	152789	179657 &	179658 &
178388, 178394, 178606, 178611	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
178388, 178394, 178606, 178611	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178389, 178395, 178605, 178612	40,1	20,9	HL Board 06 Topline	152786	179595 &	179596 &
178389, 178395, 178605, 178612	40,1	20,9	HL Solid 60 Topline	152789	179669 &	179670 &
178391, 178397, 178607, 178614	49,9	20,9	HL Board 06 Topline	152786	179607 &	179608 &
178391, 178397, 178607, 178614	49,9	20,9	HL Solid 60 Topline	152789	179681 &	179682 &
178392, 178398, 178609, 178615	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
178392, 178398, 178609, 178615	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181250, 181251, 181252, 181253, 181254, 181255	61	34	HL Board 06 Topline	152736	181259	181258
	[mm]	[mm]				
Spare parts			Dimension	Class-No.	Ident-No.	
Screws			M4,5x4,6x9 T15	995195	178239	
Screwdrivers			T15x80	985730	171188	
			[mm]			

128663

EcoPro-Shank-Type Cutterheads HW for ornamental grooves - Z1

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

CNC routers
for cutting of ornamental grooves in solid woods and wood-based panels

Design

cutting material: HW HL Board 06 for hard woods and wood-based panels
cutting material: HW HL Solid 60 for soft woods
shank with internal thread M8 for attachment screw
with shear angle

Advantages

optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
cutterhead body and knives will be profiled according to customer specifications

Notes

profile knives can be profiled according to customer specifications
cutterhead body can be used only for one profile
please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [R] unprofiled
35	20	20	25	60	98.5	1	24000	EP 400	180539 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	20,3	20,5	HL Board 06	152586		178517
	20,3	20,5	HL Solid 60	152589		179517
	20,3	20,5	HL Board 06 Topline	152786	179563 &	179564 &
	20,3	20,5	HL Solid 60 Topline	152789	179637 &	179638 &
	[mm]	[mm]				

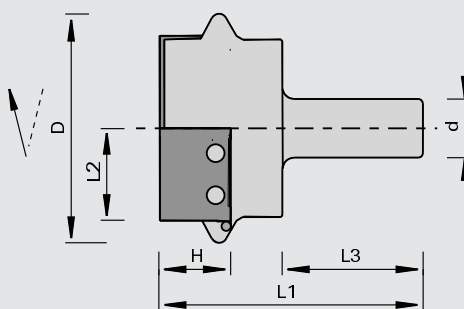
Spare parts	Dimension	Class-No.	Ident-No.
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128663

EcoPro-Shank-Type Cutterheads HW for large ornamental grooves - Z2

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for cutting of big ornamental grooves in solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw
- with shear angle

Advantages

- optimum cutting quality even when cutting across the grain of solid woods thanks to shear angle
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
76	30	25	25	60	101	2	18000	EP 401	180298 s	180299 s
76	30	30	25	60	109	2	18000	EP 403	180296 s	180297 s
100	40	30	25	60	112	2	14000	EP 402	178401 s	178402 s
120	50	33	25	60	122	2	9000	EP 404	178403 s	178404 s
143	60	34	25	60	122	2	12000	EP 409	181257 s	181256 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
180298, 180299	30,2	25,5	HL Board 06	152586		178527
180298, 180299	30,2	25,5	HL Solid 60	152589		179527
180296, 180297	30,2	30,4	HL Solid 60	152589		179528
180296, 180297	30,2	30,4	HL Board 06	152586		178528
178401, 178402	40,1	30,4	HL Board 06	152586		178534
178401, 178402	40,1	30,4	HL Solid 60	152589		179534
178403, 178404	49,9	33	HL Board 06	152586		178540
178403, 178404	49,9	33	HL Solid 60	152589		179540
181256, 181257	61	34	HL Board 06	152536		180198
180298, 180299	30,2	25,5	HL Board 06 Topline	152786	179583 &	179584 &
180298, 180299	30,2	25,5	HL Solid 60 Topline	152789	179657 &	179658 &
180296, 180297	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
180296, 180297	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178401, 178402	40,1	30,4	HL Board 06 Topline	152786	179597 &	179598 &
178401, 178402	40,1	30,4	HL Solid 60 Topline	152789	179671 &	179672 &
178403, 178404	49,9	33	HL Board 06 Topline	152786	179609 &	179610 &
178403, 178404	49,9	33	HL Solid 60 Topline	152789	179683 &	179684 &
181256, 181257	61	34	HL Board 06 Topline	152736	181259	181258
	[mm]	[mm]				

Spare parts

Dimension

Class-No.

Ident-No.

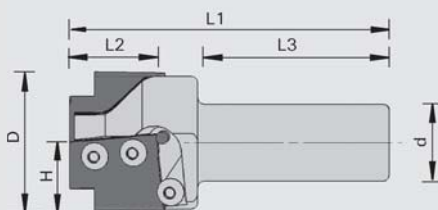
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128663

EcoPro-Shank-Type Cutterheads HW - Z2

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for cutting of ornamental grooves in solid woods and wood-based panels

Design

| cutting material: HW HL Board 06 for hard woods and wood-based panels
| cutting material: HW HL Solid 60 for soft woods
| shank with internal thread M8 for attachment screw

Advantages

| cutterhead body and knives will be profiled according to customer specifications
| inserts cutting beyond center

Notes

| profile knives can be profiled according to customer specifications
| cutterhead body can be used only for one profile
| please order stop screw separately

Ø D	L2	H	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
44	28	25	25	60	103.5	2	24000	EP 399	181839 s	181838 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	30,2	25.5	HL Board 06	152586		178527
	30,2	25.5	HL Solid 60	152589		179527
	30,2	25.5	HL Board 06 Topline	152786	179583 &	179584 &
	30,2	25.5	HL Solid 60 Topline	152789	179657 &	179658 &
	[mm]	[mm]				

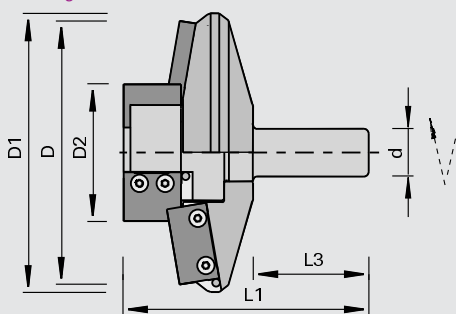
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15x80	985730	171188
	[mm]		

128913

EcoPro-Shank-Type Cutterheads HW for panel raising top side

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods
- for panel raising profiles
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
150	140	82	25	60	122	2+2	7600	EP 751 (EP 754+757)	179369 s	178751 s
137	145	71.6	25	60	122	2+2	11500	EP 752 (EP 755+758)	179370 s	178752 s
137	145	71.2	25	60	127	2+2	11500	EP 753 (EP 756+758)	179371 s	178753 s
142	144	82	25	60	123	2+2	10000	EP 849 (EP 754+855)	179372 s	178849 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
178753, 179371	30,2	25,5	HL Board 06	152586		178527
178753, 179371	30,2	25,5	HL Solid 60	152589		179527
178751, 178752, 178849, 179369, 179370	30,2	30,4	HL Board 06	152586		178528
178751, 178752, 178849, 179369, 179370	30,2	30,4	HL Solid 60	152589		179528
178752, 178753, 179370, 179371	40,1	20,9	HL Board 06	152586		178533
178752, 178753, 179370, 179371	40,1	20,9	HL Solid 60	152589		179533
178751, 179369	40,1	30,4	HL Board 06	152586		178534
178751, 179369	40,1	30,4	HL Solid 60	152589		179534
178849, 179372	49,9	20,9	HL Board 06	152586		178539
178849, 179372	49,9	20,9	HL Solid 60	152589		179539
178753	30,2	25,5	HL Board 06 Topline	152786	179583 &	179584 &
178753	30,2	25,5	HL Solid 60 Topline	152789	179657 &	179658 &
178751, 178752, 178849	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
178751, 178752, 178849	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178752, 178753	40,1	20,9	HL Board 06 Topline	152786	179595 &	179596 &
178752, 178753	40,1	20,9	HL Solid 60 Topline	152789	179669 &	179670 &
178751	40,1	30,4	HL Board 06 Topline	152786	179597 &	179598 &
178751	40,1	30,4	HL Solid 60 Topline	152789	179671 &	179672 &
178849, 179372	49,9	20,9	HL Board 06 Topline	152786	179607 &	179608 &
178849, 179372	49,9	20,9	HL Solid 60 Topline	152789	179681 &	179682 &
	[mm]	[mm]				

Spare parts

Dimension

Class-No.

Ident-No.

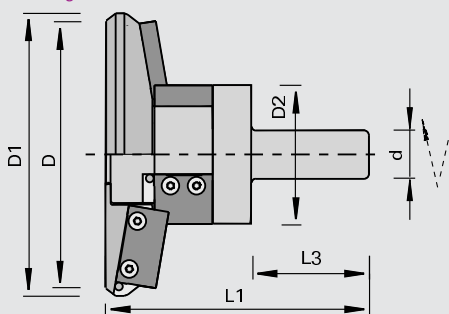
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

128913

EcoPro-Shank-Type Cutterheads HW for panel raising bottom side

Product

Drawing



tungsten carbide [HW]

MEC

Machine / Application

- CNC routers
- for profiling of solid woods and wood-based panels

Design

- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods
- shank with internal thread M8 for attachment screw

Advantages

- optimum cutting quality even when cutting across the grain of solid woods
- for panel raising profiles
- cutterhead body and knives will be profiled according to customer specifications

Notes

- profile knives can be profiled according to customer specifications
- cutterhead body can be used only for one profile
- please order stop screw separately

Ø D	Ø D1	Ø D2	Ø d	L3	L1	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
142	144	82	25	60	143	2+2	10000	EP 853 (EP 854+855)	178853 s	179373 s
150	140	82	25	60	143	2+2	7600	EP 848 (EP 854+757)	178848 s	179374 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

Blanks for Ident-No.	B	H	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	30,2	30,4	HL Board 06	152586		178528
	30,2	30,4	HL Solid 60	152589		179528
178848, 179374	40,1	30,4	HL Board 06	152586		178534
178848, 179374	40,1	30,4	HL Solid 60	152589		179534
178853, 179373	49,9	20,9	HL Board 06	152586		178539
178853, 179373	49,9	20,9	HL Solid 60	152589		179539
	30,2	30,4	HL Board 06 Topline	152786	179585 &	179586 &
	30,2	30,4	HL Solid 60 Topline	152789	179659 &	179660 &
178848, 179374	40,1	30,4	HL Board 06 Topline	152786	179597 &	179598 &
178848, 179374	40,1	30,4	HL Solid 60 Topline	152789	179671 &	179672 &
178853, 179373	49,9	20,9	HL Board 06 Topline	152786	179607 &	179608 &
178853, 179373	49,9	20,9	HL Solid 60 Topline	152789	179681 &	179682 &
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M4,5x4,6x9 T15	995195	178239
Screwdrivers	T15x80	985730	171188
	[mm]		

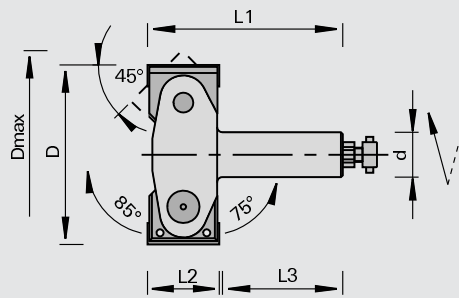
128715

Chamfering Cutterheads HW - pivoting from 0-85 degrees

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | CNC routers
- | routers
- | for jointing, chamfering and panel raising in solid woods and wood-based panels
- | for rabbeting with turnover knife Ident-No. 171149

Design

- | cutting edges parallel to cutter axis
- | n max = 12,000 min-1

Advantages

- | universal application

Notes

- | chamfer angle adjustable from 0-85 degrees on high-precision scale
- | for manual feed
- | clamping elements: ps-System, Tribos, draw-in collet chuck, MK2 directly into the spindle

Ø D	Ø Dmax	L2	Ø d	L3	L1	Z	Ident-No.
100	117	40	25	55	110	2	172271
100	117	40	MK 2		125	2	172429 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

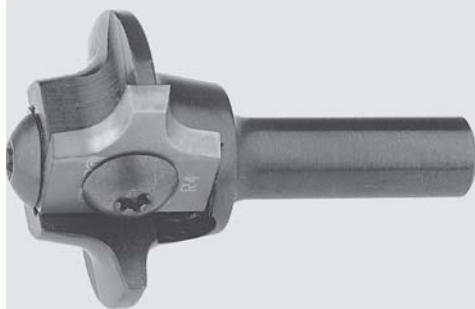
Turnover Knives	B	H	S	Class-No.	Ident-No.
	40	12	1.5	150515	164078
	39,5	12	1.5	150515	171149
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	38x10,5x6	925300	172272
Safety Screws	M8x25	997870	172113
Safety Screws	M8x19	997870	172921
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100	985730	166090
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	009677
Special Nuts	M8x11,5	995290	173450
	[mm]		

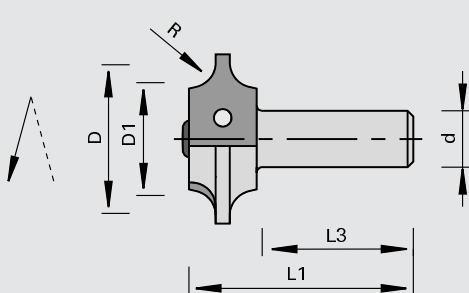
128310

Rounding Cutterheads HW - HOLZ-HER

Product



Drawing



tungsten carbide [HW]

MEC

Machine / Application

edgebanders HOLZ-HER
for rounding and chamfering of solid wood, veneer and plastic edge bands

Design

cutting edges parallel to cutter axis
cutting material: HW HL Board 05
n max = 30,000 min-1

Advantages

same cutter head body for radius 2-5 mm and chamfer

Notes

clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
2	30.8	18,85	8	22	43	2	170315	170316
3	30.8	18,85	8	22	43	2	170317	170318
4	30.8	18,85	8	22	43	2		170320 &
5	30.8	18,85	8	22	43	2		170322 &
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Knives	Chamfer	R	B	H	S	Class-No.	Ident-No.
		2	16	17.5	2	151545	163489
		3	16	17.5	2	151545	163490
		4	16	17.5	2	151545	163491
		5	16	17.5	2	151545	163492
	45		16	17.5	2	151545	170329
	[°]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

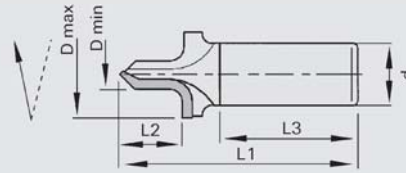
229063 / 229363

LEUCODIA Profiler

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	25	12	45	85	1	18000	DP1A
35	12	25	16	45	85	1	24000	DP1A
35	12	25	20	45	95	1	24000	DP1A
35	12	25	25	55	95	1	24000	DP1A
26	10	25	12	35	75	1	24000	DP1AK
26	10	25	16	45	85	1	24000	DP1AK
26	10	25	20	45	85	1	24000	DP1AK
26	10	25	25	55	95	1	24000	DP1AK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	12	12.5	25	55	90	1	24000	DP1M
35	12	12.5	20	45	90	1	24000	DP1M
35	12	12.5	16	45	80	1	24000	DP1M
35	12	12.5	12	45	70	1	24000	DP1M
26	10	12.5	25	55	90	1	24000	DP1MK
26	10	12.5	20	45	80	1	24000	DP1MK
26	10	12.5	16	45	80	1	24000	DP1MK
26	10	12.5	12	35	70	1	24000	DP1MK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

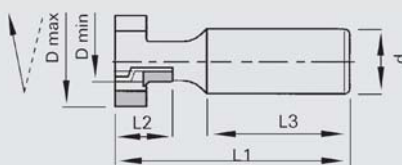
229063 / 229363

LEUCODIA Profiler - T-groove profiles

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for profiling of raw and laminated panels

Design

| resharpenable area 2.0 mm
| with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
| optimum cutting quality in MDF thanks to polished cutting edge face
| optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
| further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
35	10	22	25	55	90	2+1	24000	DP1B
35	10	22	20	45	80	2+1	24000	DP1B
35	10	22	16	45	80	2+1	24000	DP1B
35	10	22	12	35	70	2+1	15700	DP1B
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

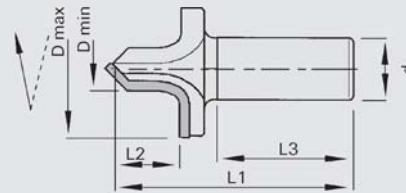
229063 / 229363

LEUCODIA Profiler - large profile depth

Product



Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | CNC routers
- | for profiling of raw and laminated panels

Design

- | resharpenable area 2.0 mm
- | with shear angle

Advantages

- | overlap-free cut thanks to continuous PCD tablets
- | optimum cutting quality in MDF thanks to polished cutting edge face
- | optimum edge quality thanks to shear angle

Notes

- | tool can be delivered according to customer specification within the shortest possible time
- | further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, Topline with ultra fine eroded cutting edge

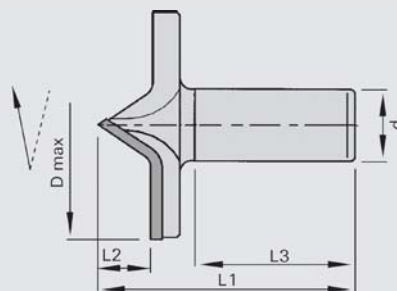
Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	16	15	25	55	100	1	24000	DP1CK
55	16	15	20	45	90	1	24000	DP1CK
55	16	15	16	45	90	1	24000	DP1CK
75	18	30	25	55	120	1	24000	DP1D
75	18	30	20	45	110	1	20500	DP1D
75	18	30	16	45	110	1	11200	DP1D
75	18	15	25	55	100	1	17000	DP1DK
75	18	15	20	45	90	1	12900	DP1DK
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

229063 / 229363

LEUCODIA Profiler - panel raising profiles

Product

Drawing



LEUCO
DIA

polycrystalline diamond [DP]

MEC

Machine / Application

| CNC routers
| for profiling of raw and laminated panels

Design

| resharpenable area 2.0 mm
| with shear angle

Advantages

| overlap-free cut thanks to continuous PCD tablets
| optimum cutting quality in MDF thanks to polished cutting edge face
| optimum edge quality thanks to shear angle

Notes

| tool can be delivered according to customer specification within the shortest possible time
| further options are possible at a surcharge: opposing shear angle version (Z = 1+1), Z = 2 version, different shank length, Topline with ultra fine eroded cutting edge

Ø Dmax	Ø Dmin	L2	Ø d	L3	L1	Z	nmax	Drawing
55	18	25	25	55	110	1	24000	DP1F
55	18	25	20	45	100	1	22000	DP1F
55	18	25	16	45	100	1	12000	DP1F
79		18	25	55	88	1	22000	DP1G
79		18	20	45	78	1	22000	DP1G
79		18	16	45	78	1	15000	DP1G
99		13	25	55	98	1	18000	DP1H
99		13	20	45	88	1	16300	DP1H
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]

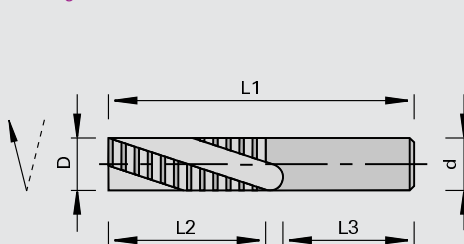
129460

Roughing Cutter with solid carbide body - ECO-disposable

Product



Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- portable routers
- for cutting of openings in countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- positive spiral

Advantages

- optimum chip evacuation thanks to positive spiral
- high hogging volume thanks to rough cutting

Notes

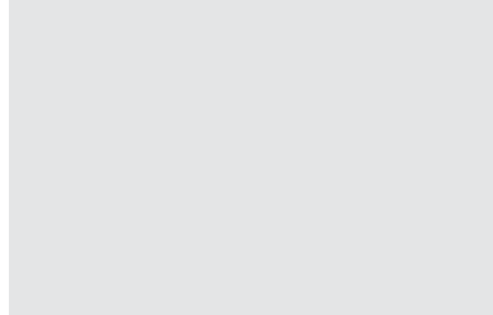
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12	45	12	35	90	2	178325 o
[mm]	[mm]	[mm]	[mm]	[mm]		

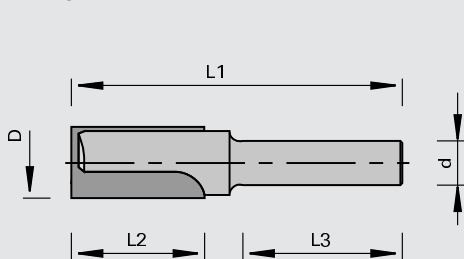
129415

Grooving Cutters HW-tipped - Z=2

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods

Design

- cutting edges parallel to cutter axis
- HW-tipped

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
3	6	6	39	2	172430 o
4	8	6	40	2	164193 o
4	8	8	40	2	172431 o
5	12	6	42	2	164194 o
5	12	8	42	2	172432
6	14	6	49	2	160364
6	16	8	46	2	167521
8	20	6	50	2	160365
8	20	8	48	2	167522
10	20	6	50	2	160366
10	20	8	48	2	167523
12	20	8	48	2	167524
14	20	6	48	2	160368 o
14	20	8	48	2	167525
15	20	6	48	2	167492 o
16	20	6	48	2	160370 o
[mm]	[mm]	[mm]	[mm]		

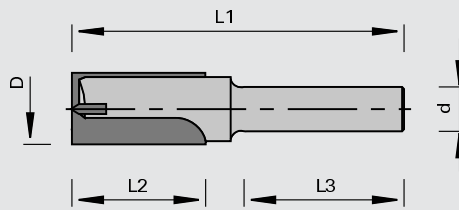
Ø D	L2	Ø d	L1	Z	Ident-No.
16	20	8	48	2	167526
18	20	6	48	2	160371 s
18	20	8	48	2	167527 o
20	20	6	48	2	160372 o
20	20	8	48	2	167528
[mm]	[mm]	[mm]	[mm]		

129415

Grooving Cutters HW-tipped - Z=2 with plunge tip

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for jointing, rabbeting and grooving in solid woods

Design

- brazed VHW cutting edge for $\varnothing D < 8$ mm
- cutting edges parallel to cutter axis
- HW-tipped

Advantages

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck

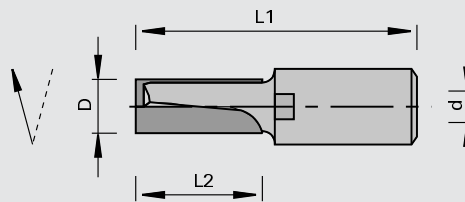
Ø D	L2	Ø d	L1	Z	Ident-No.
3	8	8	55	2	167529
4	10	8	55	2	167530
5	12	8	55	2	167531
6	14	8	55	2	167532
8	20	8	55	2	167533
8	30	8	90	2	180823
9	20	8	55	2	167534 o
10	20	8	60	2	167535
10	40	10	97	2	167552
12	20	6	48	2	160367 o
12	20	8	60	2	167536
12	40	10	97	2	167553
14	20	8	60	2	167537 o
14	40	10	97	2	167554 o
16	20	8	70	2	167538 o
16	45	10	97	2	167555 o
18	20	8	70	2	167539
18	45	10	97	2	167556 o
20	45	10	97	2	167557 o
22	16	8	70	2	167540 o
22	25	10	70	2	172433 o
24	16	8	70	2	172434 o
25	16	8	70	2	172435 o
26	16	8	70	2	172436 o
28	16	8	70	2	172437 o
30	16	8	70	2	172438 o
[mm]	[mm]	[mm]	[mm]		

129425

Grooving Cutters HW-tipped - Z=2 with internal thread

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for jointing, rabbeting and grooving in solid woods

Design

l cutting edges parallel to cutter axis
l internal thread allows direct attachment on the machine spindle

Advantages

Notes

l face cutting design allows plunge-cuts

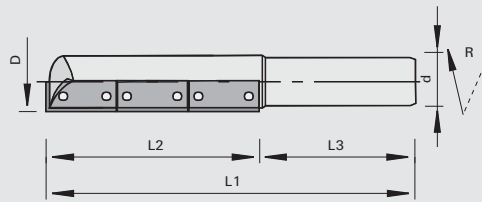
Ø D	L2	Ø d	L1	Z		Ident-No.
8	20	M10	55	2	Scheer	006414 o
10	22	M10	55	2	Scheer	006415 o
16	25	M10	55	2	Scheer	006417 o
16	45	M10	75	2	Scheer	161204
20	25	M10	55	2	Scheer	006418 o
20	45	M10	75	2	Scheer	161205
8	20	M12x1	60	2	ELU, Striffler	167558 o
10	23	M12x1	60	2	ELU, Striffler	167559 o
10	35	M12x1	67	2	ELU, Striffler	161200
12	23	M12x1	60	2	ELU, Striffler	006423 o
14	23	M12x1	60	2	ELU, Striffler	167560 o
14	35	M12x1	67	2	ELU, Striffler	167569 o
15	25	M12x1	60	2	ELU, Striffler	167561 o
16	25	M12x1	60	2	ELU, Striffler	006424
16	45	M12x1	77	2	ELU, Striffler	161201
18	25	M12x1	60	2	ELU, Striffler	167563 o
18	45	M12x1	75	2	ELU, Striffler	167571 o
18	60	M12x1	92	2	ELU, Striffler	178968
20	25	M12x1	60	2	ELU, Striffler	006425
22	25	M12x1	60	2	ELU, Striffler	167564 o
24	25	M12x1	60	2	ELU, Striffler	167565 o
25	25	M12x1	60	2	ELU, Striffler	167566 o
[mm]	[mm]	[mm]	[mm]			

128210

Shank-Type Cutters with HW Turnover Knives for lightweight panels

Product

Drawing



LEUCO DUR
 tungsten carbide [HW]
 MAN

Machine / Application

- | portable routers
- | for jointing, rabbeting and grooving especially in lightweight panels
- | for cutting of openings and contours
- | dividing cuts can be made in different steps

Design

- | suitable for lightweight panels up to a thickness of max. 65 mm
- | cutting edge parallel to cutter axis and face cutting
- | cutting material: HW HL Board 05

Advantages

- | several times a new cutting edge in cover layer possible thanks to interchange of knife inserts among each other
- | applicable with all common milling templates

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
14	69	12	40	110	1	182695
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [R]
14	69	1/2	40	110	1	182696
[mm]	[mm]	[inch]	[mm]	[mm]		

Knives	B	H	S	Class-No.	Ident-No.
	23	7	1.5	150525	182697
	[mm]	[mm]	[mm]		

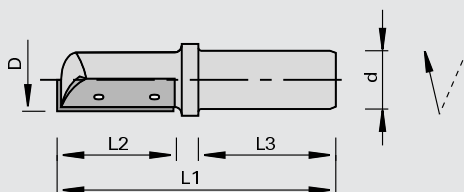
Spare parts	Dimension	Class-No.	Ident-No.
Head Cap Screws	M3x5,5 T8	995115	168239
Screwdrivers	T8	985720	182698
Screwdriver with flag	T8	985730	166499
	[mm]		

128415

Grooving Cutters with HW Turnover Knives - Z=1

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for jointing, rabbeting and grooving in solid woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts to Ø 12.7 mm
l clamping elements: draw-in collet chuck

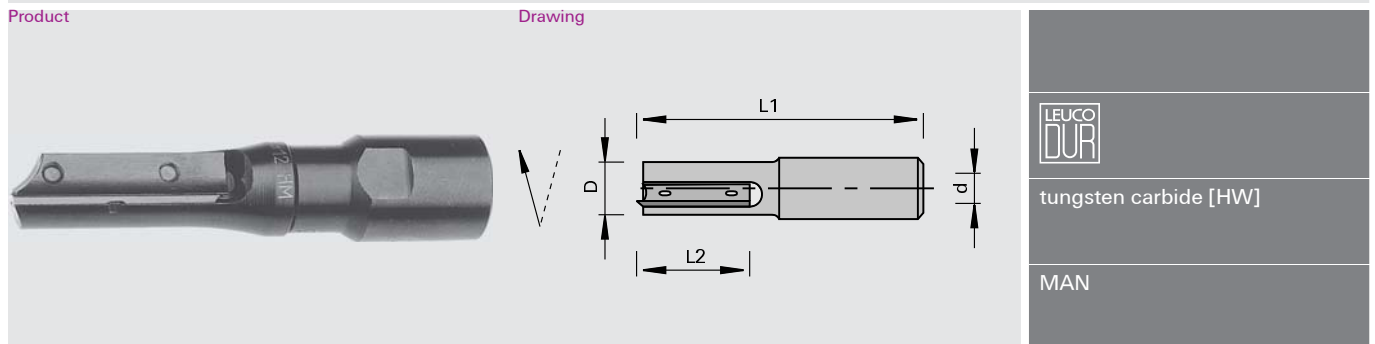
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
8	20	8	30	60	1	175673
10	20	8	30	60	1	175674 o
12	20	8	30	60	1	175675 o
14	30	8	30	70	1	175676 o
10	25	10	40	75	1	175678
12	30	10	40	80	1	175679
12.7	30	12,7	40	80	1	175672 o
14	30	10	40	80	1	175680 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10+12	20	5.5	1.1	150535	173481
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+12,7+14	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175673	925500	175722 o
Clamping Wedges	B=20	175674	925500	175723 o
Clamping Wedges	B=25	175678	925500	175724 o
Clamping Wedges	B=20	175675	925500	175725 o
Clamping Wedges	B=30	175672	925500	175727 o
Clamping Wedges	B=30	175679	925500	175726 o
Clamping Wedges	B=30	175676, 175680	925500	175728 o
Head Cap Screws	M2,5x3 T8	175673	995115	168237
Head Cap Screws	M2,5x4 T8	175674, 175678	995115	168238
Head Cap Screws	M3x5,5 T8	175672, 175675, 175676, 175679, 175680	995115	168239
Screwdriver with flag	T8	For all	985730	166499
	[mm]			

128425

Grooving Cutters with HW Turnover Knives - Z=1 with internal thread



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis internal thread allows direct attachment on the machine spindle 		<ul style="list-style-type: none"> face cutting design allows plunge-cuts to Ø 12 mm

Ø D	L2	Ø d	L1	Z	Ident-No.
8	20	M10	60	1	175681 o
10	25	M10	65	1	175682 o
12	30	M10	72	1	175683 o
14	30	M10	72	1	175684 o
8	20	M12x1	60	1	175685 o
10	25	M12x1	65	1	175686 o
12	30	M12x1	72	1	175687 o
14	30	M12x1	72	1	175688 o
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
for Ø D = 8	20	4.1	1.1	150535	173480
for Ø D = 10	25	5.5	1.1	150535	173793
for Ø D = 12+14	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

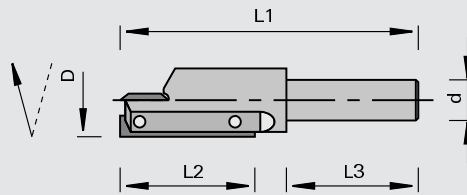
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=20	175681, 175685	925500	175722 o
Clamping Wedges	B=25	175682, 175686	925500	175724 o
Clamping Wedges	B=30	175683, 175687	925500	175726 o
Clamping Wedges	B=30	175684, 175688	925500	175728 o
Head Cap Screws	M2,5x3 T8	175681, 175685	995115	168237
Head Cap Screws	M2,5x4 T8	175682, 175686	995115	168238
Head Cap Screws	M3x5,5 T8	175683, 175684, 175687, 175688	995115	168239
Screwdriver with flag	T8	For all	985730	166499
	[mm]			

128415

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

l portable routers
l for jointing, rabbeting and grooving in solid woods and wood-based panels

Design

l cutting edges parallel to cutter axis

Advantages

Notes

l face cutting design allows plunge-cuts
l clamping elements: draw-in collet chuck

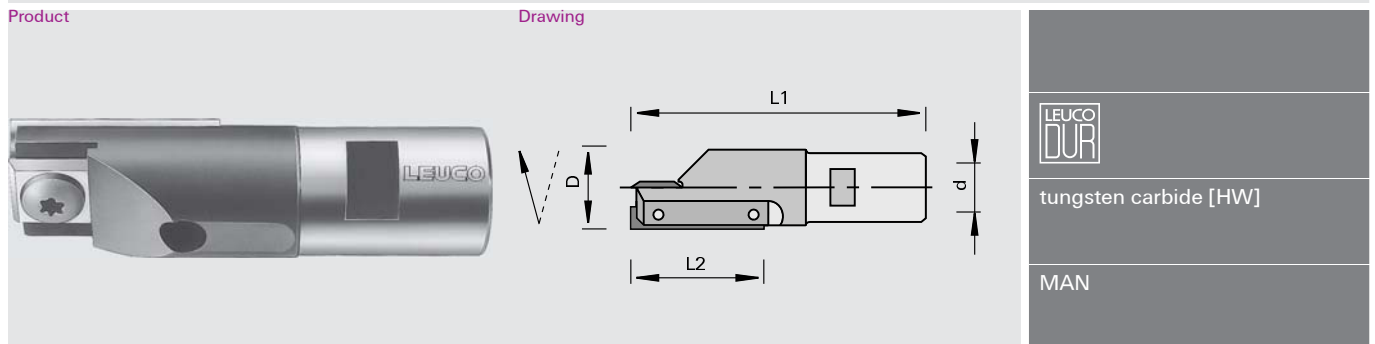
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
16	30	8	30	71	1+1	175689 o
18	30	8	30	71	1+1	175690 o
20	30	8	30	71	1+1	175691 o
22	30	8	30	71	1+1	175692 o
16	30	10	30	71	1+1	175693 o
18	30	10	30	71	1+1	175694 o
20	30	10	30	71	1+1	175695 o
22	30	10	30	71	1+1	175696 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175689, 175693	925500	169280 o
Clamping Wedges	B=30	175690, 175694	925500	169281 o
Clamping Wedges	B=30	175691, 175695	925500	169282 o
Clamping Wedges	B=30	175692, 175696	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175689, 175690, 175693, 175694	995115	168236
Head Cap Screws	M3,5x6,5 T15	175691, 175692, 175695, 175696	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
Screwdrivers	T15		985730	163161
	[mm]			

128425

Grooving Cutters with HW Turnover Knives - Z=1 with plunge tip and internal thread



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for jointing, rabbeting and grooving in solid woods and wood-based panels 	<ul style="list-style-type: none"> cutting edges parallel to cutter axis internal thread allows direct attachment on the machine spindle 		<ul style="list-style-type: none"> face cutting design allows plunge-cuts

Ø D	L2	Ø d	L1	Z	Ident-No.
16	30	M10	65	1+1	175697 o
18	30	M10	65	1+1	175698 o
20	30	M10	65	1+1	175699 o
22	30	M10	65	1+1	175700 o
16	30	M12x1	65	1+1	175701
18	30	M12x1	65	1+1	175702 o
20	30	M12x1	65	1+1	175703
22	30	M12x1	65	1+1	175704 o
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	150515	003080
Mini Turnover Knives	30	5.5	1.1	150535	173482
	[mm]	[mm]	[mm]		

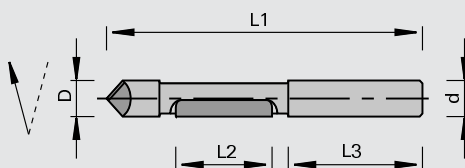
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Clamping Wedges	B=30	175697, 175701	925500	169280 o
Clamping Wedges	B=30	175698, 175702	925500	169281 o
Clamping Wedges	B=30	175699, 175703	925500	169282 o
Clamping Wedges	B=30	175700, 175704	925500	169283 o
Head Cap Screws	M3,5x5,5 T15	175697, 175698, 175701, 175702	995115	168236
Head Cap Screws	M3,5x6,5 T15	175699, 175700, 175703, 175704	995115	163223
Round Head Screws	M4x5,9 T15		995195	167966
Screwdrivers	T15		985730	163161
	[mm]			

129417

Plunge Cutters HW-tipped

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- l portable routers
- l for cutting of openings in solid woods

Design

- l cutting edges parallel to cutter axis

Advantages

Notes

- l face cutting design allows plunge-cuts
- l clamping elements: draw-in collet chuck

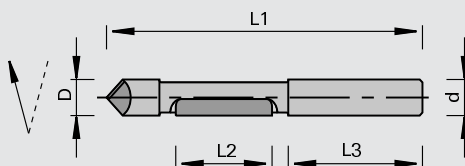
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
6	19	6	25	65	1+1	006453
6.35	20	6,35	25	63	1+1	167661 o
[mm]	[mm]	[mm]	[mm]	[mm]		

329417

Plunge Cutters HS-tipped

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

- l portable routers
- l for cutting of openings in solid woods

Design

- l cutting edges parallel to cutter axis

Advantages

Notes

- l face cutting design allows plunge-cuts
- l clamping elements: draw-in collet chuck

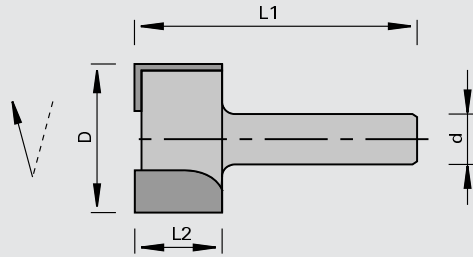
Ø D	L2	Ø d	L3	L1	Z	Ident-No.
6.4	15	6	25	56	1+1	170757
6.4	15	6	25	70	1+1	170758
[mm]	[mm]	[mm]	[mm]	[mm]		

129215

Edge Trimming Cutters HW-tipped

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

portable routers
for jointing and rabbeting in solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
face cutting and peripheral cutting

Advantages

Notes

clamping elements: draw-in collet chuck

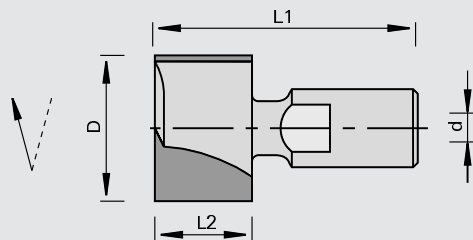
Ø D	L2	Ø d	L1	Z	Ident-No.
18	12	6	37	2	164307 o
20	16	6	41	2	006146 o
24	16	6	41	2	167573 o
31	16	6	41	2	167574 o
18	12	8	37	2	164308 o
20	16	8	41	2	160357 o
24	16	8	41	2	167575 o
31	16	8	41	2	167576 o
24	16	10	41	2	167577 o
31	16	10	41	2	167578 o
24	16	12	41	2	167579 o
31	16	12	41	2	167580 o
[mm]	[mm]	[mm]	[mm]		

129225

Edge Trimming Cutters HW-tipped with internal thread

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

portable routers
for jointing and rabbeting in solid woods and wood-based panels

Design

cutting edges parallel to cutter axis
face cutting and peripheral cutting
shank with internal thread

Advantages

Notes

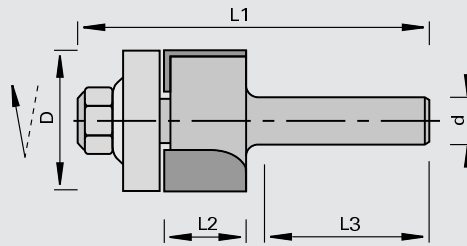
Ø D	L2	Ø d	L1	Z	Ident-No.
24	16	M10	41	2	167581 o
31	16	M10	41	2	167582 o
24	16	M12x1	41	2	167583 o
31	16	M12x1	41	2	167584 o
[mm]	[mm]	[mm]	[mm]		

129216

Edge Trimming Cutters HW-tipped with thrust ring

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No.
12.7	25	8	25	58	2	180822
22	16	6	25	58	2	006152
22	16	6,35	25	58	2	167585 o
22	16	8	25	58	2	164215
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

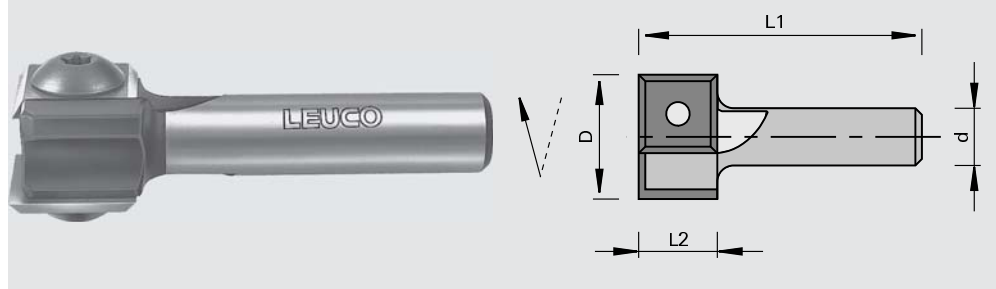
Ball Bearings	12,7x5x4,76	997500	164920
Ball Bearings	22x7,5x6,35	997500	164228
Ball Bearings	22x7,5x8	997500	180838
Hexagon Nuts	M4 DIN EN ISO 4032	995210	009631
Hexagon Nuts	M6 DIN EN ISO 4032	995210	009633
	[mm]		

128215

Edge Trimming Cutters with HW TOK

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | face cutting
- | cutting edges parallel to cutter axis
- | n max = 27,000 min-1

Advantages

Notes

- | clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z		Ident-No. [L]	Ident-No. [R]
19	12	6	42	2			164897 o
19	12	6,35	42	2			164901 o
19	12	8	46	2	Brandt	833907 s	164905 o
[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

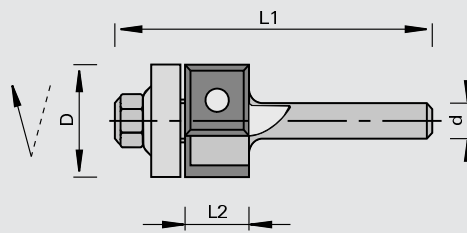
Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

128216

Edge Trimming Cutters with HW Turnover Knives with thrust ring

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for flush-cutting of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

Ø D	L2	Ø d	L1	Z	Ident-No.
19	12	6,35	56	2	164912 o
19	12	8	56	2	164916
19	30	8	74	2	183398
19	50	12	112	2	183399
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	30	12	1.5	150515	003083
	50	12	1.5	150515	003085
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Ball Bearings	19x6x6	997500	164922
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

129315

Edge Chamfering Cutters HW-tipped

Product		Drawing			Notes		
					tungsten carbide [HW]		
					MAN		
Machine / Application		Design		Advantages		Notes	
portable routers for chamfering in solid woods and wood-based panels		cutting edges parallel to cutter axis				clamping elements: draw-in collet chuck	
Chamfer	Ø D	L2	Ø d	Z	Ident-No.		
15	24	12	6	2	006160 o		
15	24	12	6,35	2	167586 o		
15	24	12	8	2	164220 o		
22	24	12	6,35	2	167587 o		
30	24	12	6	2	006161 o		
30	24	12	6,35	2	167588 o		
30	24	12	8	2	164221 o		
[°]	[mm]	[mm]	[mm]				

129315

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, shank can be exchanged

Product		Drawing				Notes	
						tungsten carbide [HW]	
						MAN	
Machine / Application		Design		Advantages		Notes	
portable routers for chamfering in solid woods and wood-based panels		cutting edges parallel to cutter axis shank can be exchanged				clamping elements: draw-in collet chuck	
Chamfer	Ø D	L2	L	Ø d	Z	Ident-No.	
45	31	15	10	6	2	167589 o	
45	31	15	10	6,35	2	167590 o	
45	31	15	10	8	2	167591 o	
45	31	15	10	10	2	167592 o	
45	31	15	10	12	2	167593 o	
[°]	[mm]	[mm]	[mm]	[mm]			

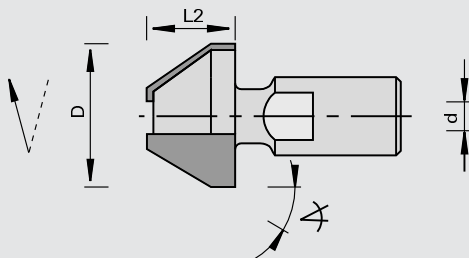
129325

Edge Chamfering Cutters HW-tipped - chamfer angle 45°, with internal thread

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for chamfering in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- shank with internal thread

Advantages

Notes

Chamfer \angle	$\varnothing D$	L2	$\varnothing d$	Z	Ident-No.
45	31	15	M10	2	167594 o
45	31	15	M12	2	167595 o
[°]	[mm]	[mm]	[mm]		

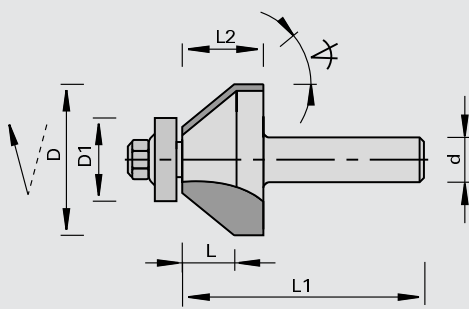
129316

Edge Chamfering Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying with chamfer
- clamping elements: draw-in collet chuck

Chamfer \angle	$\varnothing D$	$\varnothing D1$	L2	L	$\varnothing d$	L1	Z	Ident-No.
45	25	15,9	12	6	6	37	2	160361
45	25	15,9	12	6	8	37	2	167597
30	26	15,9	12	12	6	37	2	160360 o
30	26	15,9	12	12	8	37	2	167596 o
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

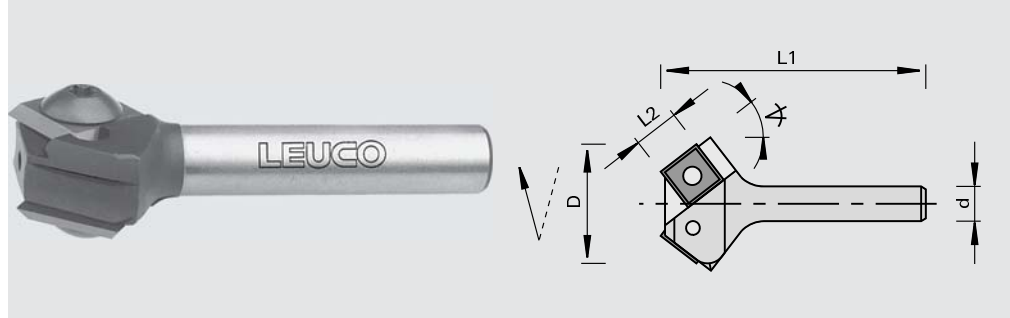
Ball Bearings	15,9x5x6,35	997500	164921
Hexagon Nuts	M6 DIN EN ISO 4032	995210	009633
	[mm]		

128315

Edge Chamfering Cutters with HW TOK

Product

Drawing


 LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

| portable routers
 | for chamfering in solid woods
 and wood-based panels

Design

| cutting edges parallel to cutter
 axis

Advantages

Notes

| clamping elements: draw-in
 collet chuck

Chamfer \sphericalangle	$\varnothing D$	L2	$\varnothing d$	L1	Z		Ident-No. [L]	Ident-No. [R]
15	21.96	10.5	8	45	2	Brandt	777160 s	773158 s
22	24	12	6	45	2			164898 o
22	24	12	6,35	45	2			164902 o
30	25	12	6	45	2			164899 o
30	25	12	6,35	45	2			164903 o
30	25	12	8	54	2			164906 o
45	29	12	6	45	2			164900 o
45	29	12	6,35	45	2			164904 o
45	29	12	8	54	2			164907 o
[°]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives

B

H

S

Class-No.

Ident-No.

10,5

10.5

1.5

150518

162316

12

12

1.5

150515

003080

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Round Head Screws

M4x5,9 T15

995195

167966

Screwdrivers

T15

985730

163161

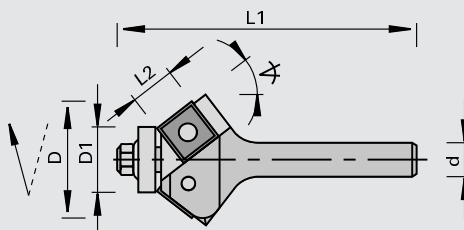
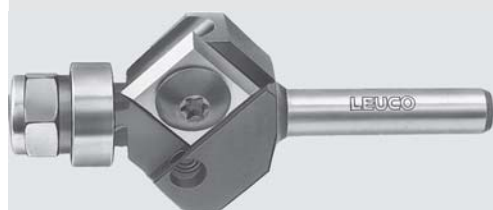
[mm]

128316

Edge Chamfering Cutters with HW Turnover Knives with thrust ring

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for chamfering of solid wood, veneer and plastic edge bands and copying in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- flush-cutting with ball-bearing mounted rub collar

Advantages

Notes

- template copying
- clamping elements: draw-in collet chuck

Chamfer	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
10	22	19	12	6	48	2	164909 o
10	22	19	12	6,35	48	2	164913 o
10	22	19	12	8	56	2	164917 o
45	29	12,7	12	6	56	2	164911
45	29	12,7	12	8	64	2	164918
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Ball Bearings	12,7x5x4,76	997500	164920
Ball Bearings	19x6x6	997500	164922
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
	[mm]		

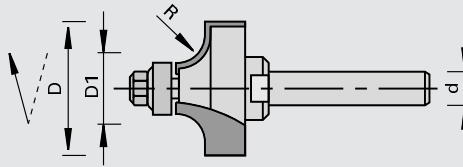
129616

Rounding Cutters HW-tipped with thrust ring

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | rounding with ball-bearing mounted rub collar

Advantages
Notes

- | template copying
- | clamping elements: draw-in collet chuck

R	Ø D	Ø D1	Ø d	Z		Ident-No.
2	16	12	8	2		180824
2	18	12	6	2	EBM	816995
3	18	12	6	2		167598
3	18	12	6,35	2		167599 o
3	18	12	8	2		167600
3	20	12	6	2	EBM	816994 o
4	20	12	6	2		167601 o
4	20	12	6,35	2		167602 o
4	20	12	8	2		167603
5	22	12	6	2		167604
5	22	12	6,35	2		167605 o
5	22	12	8	2		167606
6,3	24	12	6,35	2		167608 o
6,3	24.6	12	6	2		167607 o
6,3	24.6	12	8	2		167609
8	30	14	6	2		167610 o
8	30	14	6,35	2		167611 o
8	30	14	8	2		167612
9,5	33	14	6	2		167613 o
9,5	33	14	6,35	2		167614 o
9,5	33	14	8	2		167615
12,7	39.4	14	6	2		167616 o
12,7	39.4	14	6,35	2		167617 o
12,7	39.4	14	8	2		167618
[mm]	[mm]	[mm]	[mm]			

Spare parts
Dimension
Class-No.
Ident-No.

Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
	[mm]		

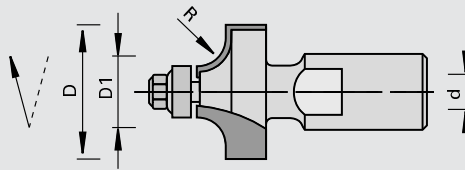
129626

Rounding Cutters HW-tipped with thrust ring and internal thread

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for rounding of solid wood, veneer and plastic edge bands as well as solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- shank with internal thread
- rounding with ball-bearing mounted rub collar

Advantages

Notes

- template copying

R	Ø D	Ø D1	Ø d	Z	Ident-No.
3	18	12	M10	2	167619 o
3	18	12	M12x1	2	167620 o
4	20	12	M10	2	167621 o
4	20	12	M12x1	2	167622 o
5	22	12	M10	2	167623 o
5	22	12	M12x1	2	167624 o
6,3	24.6	12	M10	2	167625 o
6,3	24.6	12	M12x1	2	167626 o
8	30	14	M10	2	167627 o
8	30	14	M12x1	2	167628 o
9,5	33	14	M10	2	167629 o
9,5	33	14	M12x1	2	167630 o
12,7	39.4	14	M10	2	167631 o
12,7	39.4	14	M12x1	2	167632 o
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

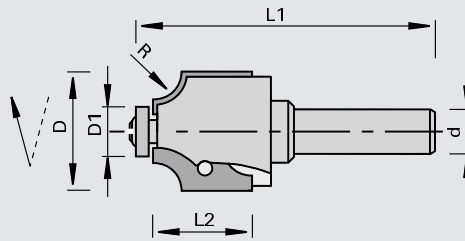
Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
	[mm]		

128616

Rounding and Quarter Round Cutterheads HW

Product

Drawing


 LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable routers
- | for rounding and quarter round cutting in solid woods and wood-based panels

Design

- | with ball-bearing spacer ring
- | profiled turnover knives
- | face cutting and peripheral cutting

Advantages

Notes

- | included in delivery: 2 ball bearing sets (see D1)
- | included in delivery Ident-No. 180947: 1 ball bearing set
- | exchangeable ball bearing sets: 1. with big spacer set / 2. with small spacer set/ 3. without spacer set

R	Ø D	Ø D1	L2	Ø d	L1	Z	Ident-No.
2	26	22	19.5	8	70	2	180947 o
3	26	20/18	19.5	8	70	2	180948 o
4	26	18/14	19.5	8	70	2	180949 o
5	26	16/12	19.5	8	70	2	180950 o
6	32	20/16	26	8	76	2	180951 o
8	32	16/12	26	8	76	2	180952 o
10	36	16/12	30	8	80	2	180953 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Knives

R

B

H

S

Class-No.

Ident-No.

2	19,5	9	1.5	151555	180991 o
3	19,5	9	1.5	151555	180992 o
4	19,5	9	1.5	151555	180993 o
5	19,5	9	1.5	151555	180994 o
6	26	12.5	1.5	151555	180995 o
8	26	12.5	1.5	151555	180996 o
10	30	14.5	1.5	151555	180997 o
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Ball Bearings	Ø12	997500	167923
Ball Bearings	Ø14	997500	169314
Ball Bearings	Ø16	997500	180985 o
Ball Bearings	Ø18	997500	180986 o
Ball Bearings	Ø20	997500	180987 o
Ball Bearings	Ø22	997500	180988 o
Head Cap Screws	M4x6 T15	995195	180989 o
Round Head Screws	M4x5,9 T15	995195	167966
Cover Screws	M3,5	995195	180990 o
Screwdrivers	T15	985730	163161
	[mm]		

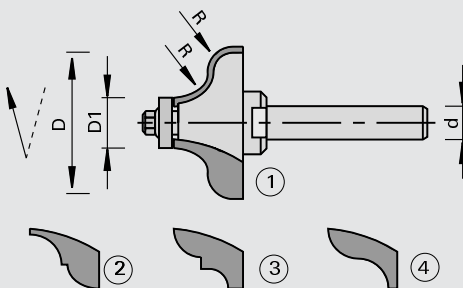
129616

Profile Cutters HW-tipped with thrust ring

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- portable routers
- for profiling of edges and copying in solid woods

Design

- 2 cutting edges parallel to cutter axis
- profiling with ball-bearing mounted rub collar

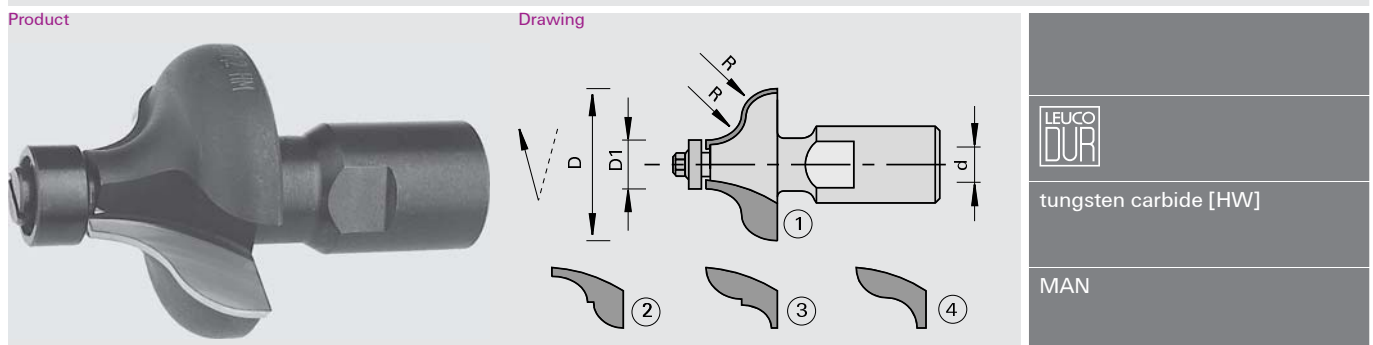
Advantages

Notes

- template copying with profile
- clamping elements: collet chuck

R	Ø D	Ø D1	Ø d	Z	Profile	Ident-No.
7,2 / 7,2	37.4	12	6	2	1	167646 o
7,2 / 7,2	37.4	12	6,35	2	1	167647 o
7,2 / 7,2	37.4	12	8	2	1	167648 o
6,3 / 6,3	37.2	12	6	2	2	167651 o
6,3 / 6,3	37.2	12	6,35	2	2	167652 o
6,3 / 6,3	37.2	12	8	2	2	167653 o
6,3 / 6,3	41.2	12	8	2	3	167658 o
4 / 4	31	12	6	2	4	167636 o
4 / 4	31	12	6,35	2	4	167637 o
4 / 4	31	12	8	2	4	167638 o
6,3/6,3	37	12	6	2	4	167639 o
6,3/6,3	37	12	6,35	2	4	167640 o
6,3/6,3	37	12	8	2	4	167641 o
[mm]	[mm]	[mm]	[mm]			

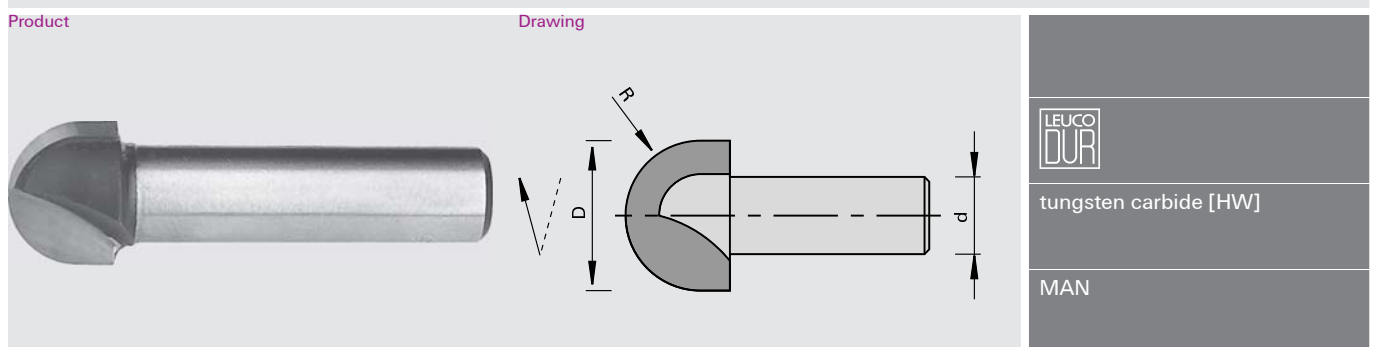
129626

Profile Cutters HW-tipped with thrust ring and internal thread


Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for profiling of edges and copying in solid woods 	<ul style="list-style-type: none"> 2 cutting edges parallel to cutter axis shank with internal thread profiling with ball-bearing mounted rub collar 		<ul style="list-style-type: none"> template copying with profile

R	Ø D	Ø D1	Ø d	Z	Profile	Ident-No.
7,2 / 7,2	37.4	12	M10	2	1	167649 o
7,2 / 7,2	37.4	12	M12x1	2	1	167650 o
6,3 / 6,3	37.2	12	M10	2	2	167654 o
6,3 / 6,3	37.2	12	M12x1	2	2	167655 o
6,3 / 6,3	41.9	12	M10	2	3	167659 o
6,3 / 6,3	41.9	12	M12x1	2	3	167660 o
4 / 4	31	12	M10	2	4	167642 o
4 / 4	31	12	M12x1	2	4	167643 o
6,3 / 6,3	37	12	M10	2	4	167644 o
6,3 / 6,3	37	12	M12x1	2	4	167645 o
[mm]	[mm]	[mm]	[mm]			

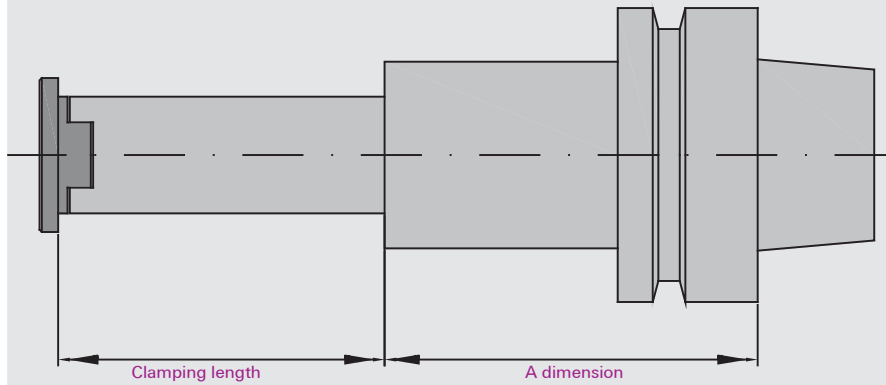
129615

Cove Cutters HW-tipped


Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable routers for cutting of coves and semi-coves in solid woods and wood-based panels 	<ul style="list-style-type: none"> 2 cutting edges parallel to cutter axis 		<ul style="list-style-type: none"> clamping elements: collet chuck

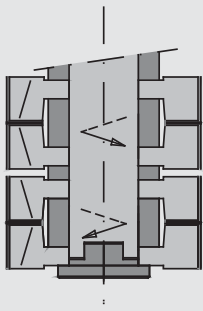
R	Ø D	Ø d	L1	Z	Ident-No.
4,75	9.5	8	60	2	167633 o
5,5	11	8	60	2	167634 o
6,35	12.7	8	60	2	167635
[mm]	[mm]	[mm]	[mm]		

Modula Order Data

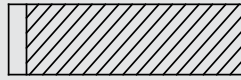


- | The Modula-system is a modern tool-system for CNC-machines
- | Thanks to its modular structure many profile variations can be made up
- | On the following pages please find the most important standard combinations, the individual cutterheads and the holder shanks
- | Note: all combinations do not include drive arbors. Please order separately and indicate dimension „A“ and clamping length required
- | Sets include spacers; tool-cards not included
- | the Modula cutterheads are supplied without adjustment gauges and wrenches; please order separately (mounting set Ident-No. 9210474)
- | For custom combinations please contact your LEUCO representative
- | Tool identification card Ident-No. 171407 EUR 28.30

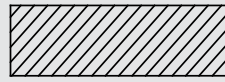
Modula Jointing Sets Application



Section cut lefthand

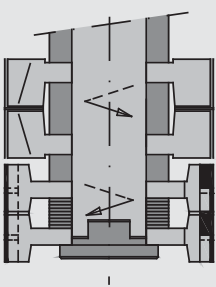


Modula Jointing Cutter with TOK for chamfering on lefthand

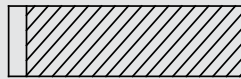


In combination with Modula jointing cutter for finish cutting righthand

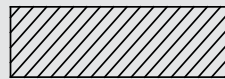
Finish cut righthand



Section cut lefthand

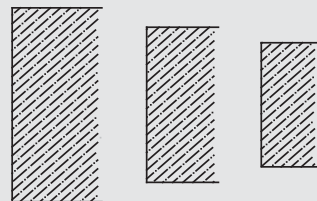
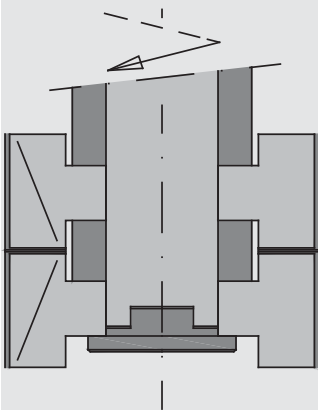


Modula Jointing Cutter with TOK for chamfering on lefthand and for veneer overhangs



In combination with LEUCODIA jointing cutter for finish cutting righthand

Finish cut righthand



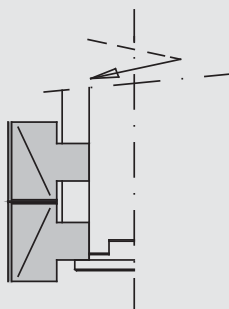
128660

Modula Jointing Sets HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing in laminated panels

Design

- | opposing shear cut
- | tool set 2 parts
- | basis number of wings Z=2
- | n max = 14,500 min-1

Advantages

Notes

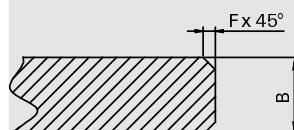
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

Ø D	B	Ø d	Z		Ident-No.
70	28	25	2	O-1, O-2	199377
70	38	25	2	C-1, C-2	199380
70	58	25	2	H-1, H-2	199382
70	78	25	2	J-1, J-2	199383
[mm]	[mm]	[mm]			

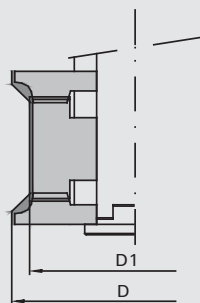
128660

Modula Chamfering Sets HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | jointing cutterheads up to B = 40 mm with shear angle
- | unchanging zero-point
- | n max = 14,500 min-1

Advantages

- | simple adjustment by means of rings
- | high flexibility thanks to modular design

Notes

- | expandable by concave or radius cutterheads
- | for more options see application examples
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

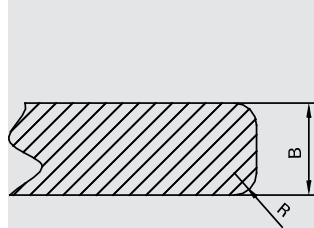
Chamfer	Ø D	Ø D1	B	Ø d	Z		Ident-No.
3x45	78	70	8 - 23	25	2	B, C-1, B	199335
3x45	78	70	14 - 33	25	2	B, H-1, B	199338
3x45	78	70	24 - 43	25	2	B, J-1, B	199341
3x45	78	70	34 - 63	25	2	B, S-1, B	199753
3x45	78	70	54 - 75	25	2	B, M-1, B	199754
[°]	[mm]	[mm]	[mm]	[mm]			

Chamfer	Ø D	Ø D1	B	Ø d	Z		Ident-No.
5x45	82	70	18 - 28	25	2	F-1, C-1, F-2	199344
5x45	82	70	23 - 38	25	2	F-1, H-1, F-2	199348
5x45	82	70	33 - 48	25	2	F-1, J-1, F-2	199352
5x45	82	70	38 - 68	25	2	F-1, S, F-2	199765
5x45	82	70	58 - 74	25	2	F-1, M, F-2	199766
10x45	90	70	22 - 38	25	2	U-1, C-1, U-2	199356
10x45	90	70	22 - 48	25	2	U-1, H-1, U-2	199359
10x45	90	70	29 - 58	25	2	U-1, J-1, U-2	199362
10x45	90	70	38 - 72	25	2	U-1, S, U-2	199767
10x45	90	70	58 - 74	25	2	U-1, M, U-2	199768
[°]	[mm]	[mm]	[mm]	[mm]			

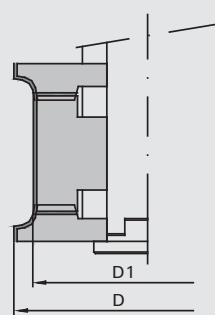
128660

Modula Rounding Sets HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for jointing and rounding in solid woods and wood-based panels

Design

| jointing cutterheads up to B = 40 mm with shear angle
| radius cutterheads from R 4 with shear angle
| unchanging zero-point
| n max = 14,500 min-1

Advantages

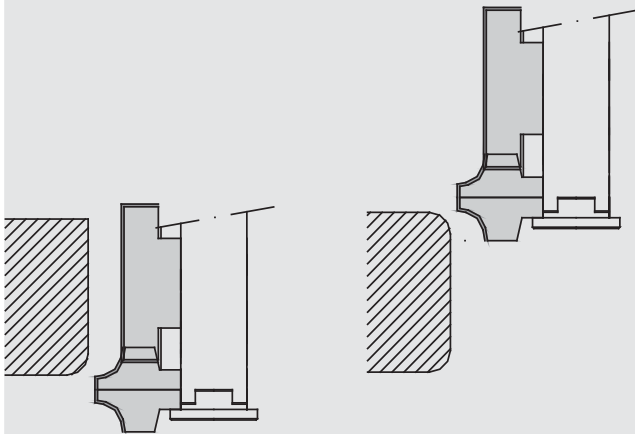
| simple adjustment by means of rings
| high flexibility thanks to modular design

Notes

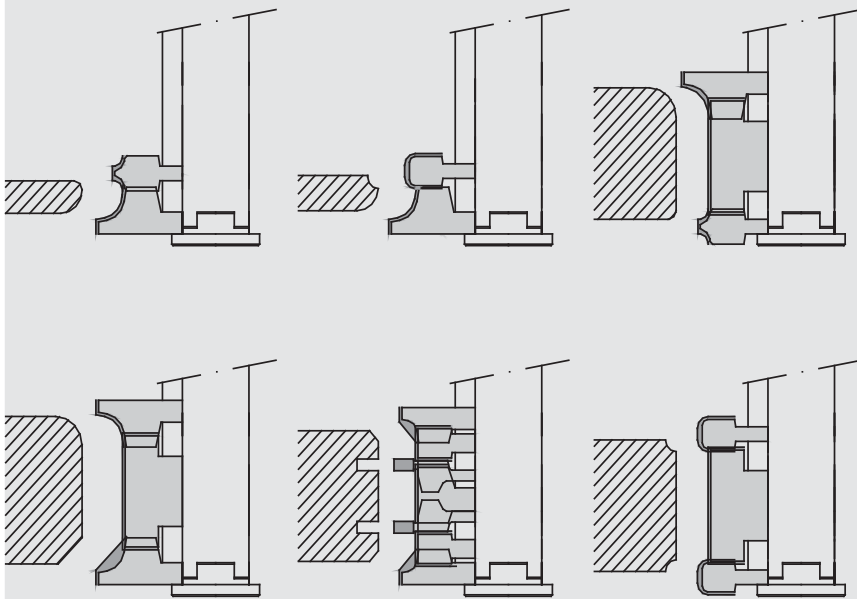
| expandable by concave or chamfering cutterheads
| for more options see application examples
| wrenches are not included in delivery
| mounting-set Ident-No. 198948
| please order shank-tool holder separately

R	Ø D	Ø D1	B	Ø d	Z		Ident-No.
2, 3	78	70	8 - 21	25	2	B, C-1, B	199336
2, 3	78	70	14 - 31	25	2	B, H-1, B	199339
2, 3	78	70	24 - 41	25	2	B, J-1, B	199342
2, 3	78	70	34 - 62	25	2	B, S, B	199749
2, 3	78	70	54 - 75	25	2	B, M, B	199750
4, 5, 6	82	70	16 - 26	25	2	F-1, C-1, F-2	199345
4, 5, 6	82	70	20 - 36	25	2	F-1, H-1, F-2	199349
4, 5, 6	82	70	30 - 46	25	2	F-1, J-1, F-2	199353
4, 5, 6	82	70	40 - 66	25	2	F-1, S, F-2	199755
4, 5, 6	82	70	60 - 74	25	2	F-1, M, F-2	199756
8, 10	90	70	22 - 34	25	2	U-1, C-1, U-2	199357
8, 10	90	70	22 - 44	25	2	U-1, H-1, U-2	199360
8, 10	90	70	29 - 54	25	2	U-1, J-1, U-2	199363
8, 10	90	70	38 - 72	25	2	U-1, S, U-2	199761
8, 10	90	70	58 - 74	25	2	U-1, M, U-2	199762
[mm]	[mm]	[mm]	[mm]	[mm]			

Modula Application Examples



Other combinations



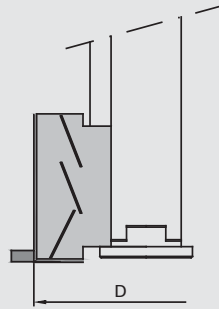
- | If material thicknesses vary considerably, both cutterheads are mounted on the bottom
- | The material-thicknesses are entered into the program and the milling is done in two passes

128660

Modula Jointing / Rabbeting Cutterheads HW

Product

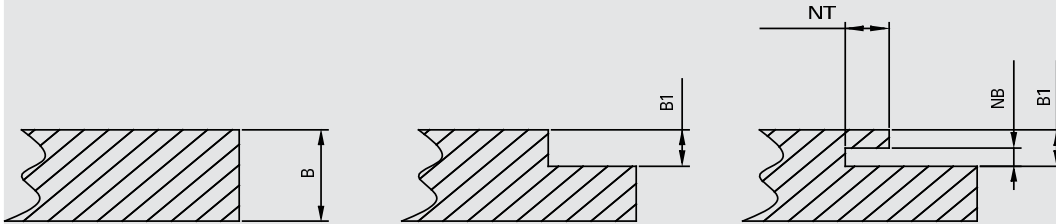
Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

- | CNC routers
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | aluminum body
- | with alternating shear angle
- | spiral cutting edges
- | basis number of wings Z=2
- | n max = 15,000 min-1

Advantages

- | high performance with low cutting pressure

Notes

- | optionally grooving knives can be used
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948
- | please order shank-tool holder separately

Ø D	B	B1	Ø d	Z	Ident-No.
80	71	20-70	25	2+2	9203782
80	91	20-90	25	2+2	9206050
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
turnover knives up to the year 2006	16	12	1.5	150515	876623
Turnover Knives	18	12	1.5	150515	9206316
Turnover Knives	20	12	1.5	150515	9215959
	[mm]	[mm]	[mm]		

Options additional grooving knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888748
	[mm]	[mm]		

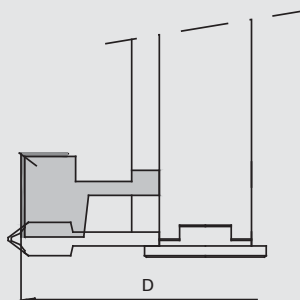
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20	995125	879871
Clamping Bars	6x	925300	872689
Clamping Bars	2x	925300	9203785
Set Screws	M6x16 SW3	995161	001617
Countersunk Flat Headed Screws for spur	M5x7 T15	995125	900512
	[mm]		

128660

Modula Rabbeting Cutterheads HW - Z=2

Product

Drawing

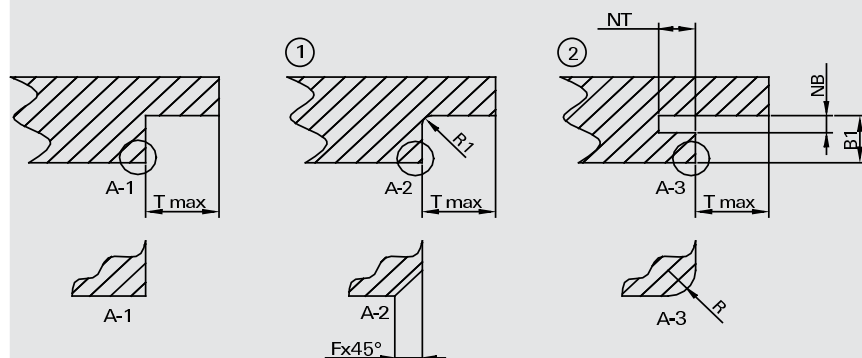


LEUCO
GNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

l CNC routers
l for jointing and rabbeting in solid woods and wood-based panels

Design

l with shear angle
l basis number of wings Z=2
l Ø 100: n max = 14,500 min-1
l / Ø 130: n max = 11,500 min-1

Advantages

l high flexibility thanks to modular design

Notes

l optionally grooving knives can be used
l expandable by radius or chamfering cutterheads
l wrenches are not included in delivery
l mounting-set Ident-No. 198948
l please order shank-tool holder separately

Ø D	B	Ø d	Tmax	Z		Ident-No.
100	30	25	25	2+2V	T-3	888524
100	40	25	25	2+2V	T-10	889428
130	30	25	25	2+2V	T-5	888525
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	R	B	H	S	Class-No.	Ident-No.
Radius Spurs	1	13	15	2	150552	888476
	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888748
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

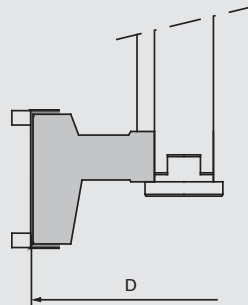
Options	R	Chamfer	Ø D	Cutterhead	Class-No.	Ident-No.
A-2		45	108	A	120610	879845
A-3	2		108	A	120660	881168
A-3	3		108	A	120660	881169
	[mm]	[°]	[mm]			

Options	R	Chamfer	Ø D	Cutterhead	Class-No.	Ident-No.
A-2		45	138	Y	120610	880580
A-3	2		138	Y	120660	880581
A-3	3		138	Y	120660	880582
	[mm]	[°]	[mm]			

120210
Modula Single Rabbeting Cutterheads HW - Z=3

Product

Drawing

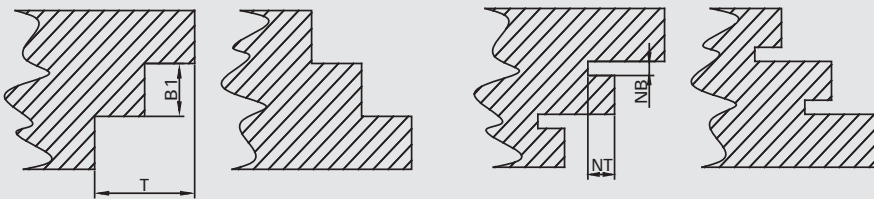


LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
 | for jointing and rabbeting in solid woods and wood-based panels

Design

| number of teeth Z = 3
 | with shear angle
 | body made of aluminum
 | n max = 11,700 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | optionally grooving knives can be used
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Tmax	Z	Ident-No.
140	48	35.6	25	47	3+6+6V	9205912
140	38	25.6	25	47	3+6+6V	9205913
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
grooving knife top/bottom	4	8	150512	879869
grooving knife top	5	8	150512	888747
grooving knife bottom	5	8	150512	888748
	[mm]	[mm]		

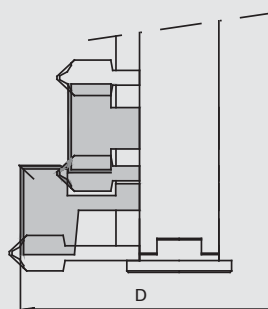
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knives	M5x11 T20 [mm]	995125	879871

128660

Modula Door Rabbeting Sets HW

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for the production of door rabbets

Design

| with shear angle
| basis number of wings Z=2
| Ø 100 mm: n max = 14,500 min-1
| unchanging zero-point

Advantages

| high flexibility thanks to modular design
| simple adjustment by means of rings

Notes

| when running variable door production the single rebate edge is done with bottom cutter in a second pass
| expandable by chamfering, concave or radius cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No. 198948
| please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax	Z	Ident-No.
96	15-28	14-18	25	13	2	199722
96	15-28	24-38	25	13	2	199723
96	22-38	24-38	25	13	2	199724
100	15-28	14-28	25	15	2	199725
100	15-28	24-38	25	15	2	199726
100	22-38	24-38	25	15	2	199727
[mm]	[mm]	[mm]	[mm]	[mm]		

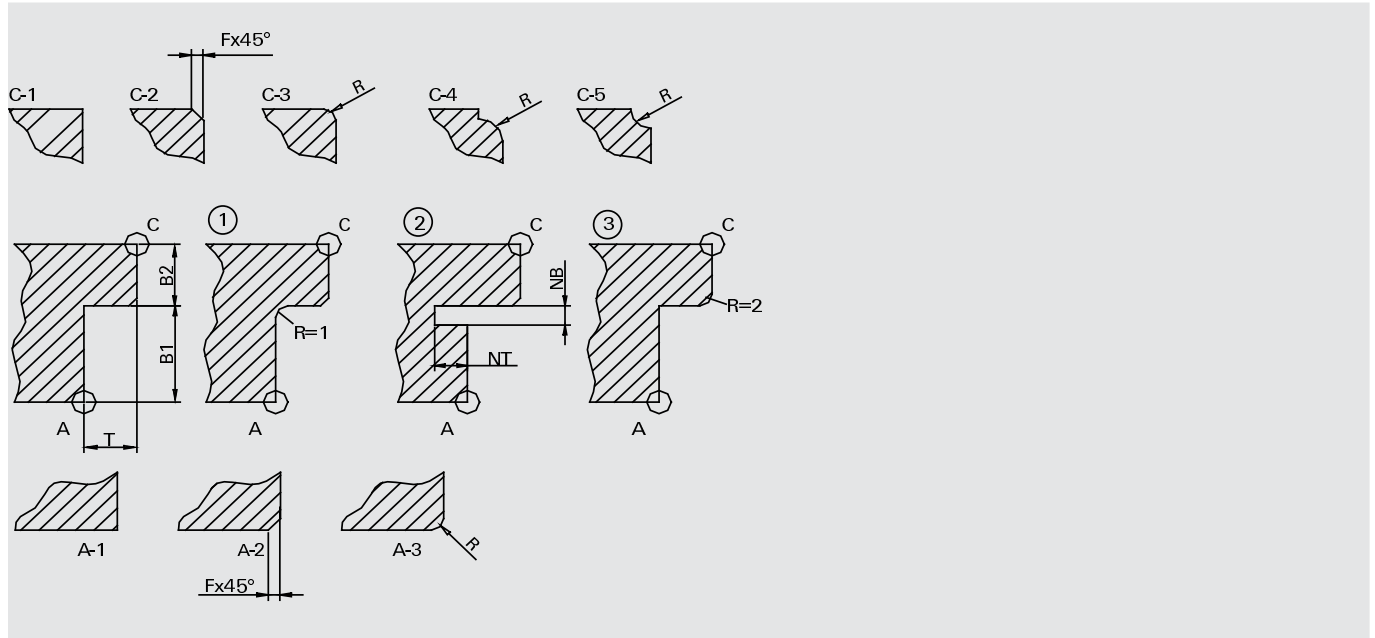
Options 1	R	B	H	S	Class-No.	Ident-No.
Radius Spurs	1	13	15	2	150552	888476
	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888747
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20 [mm]	995125	879871

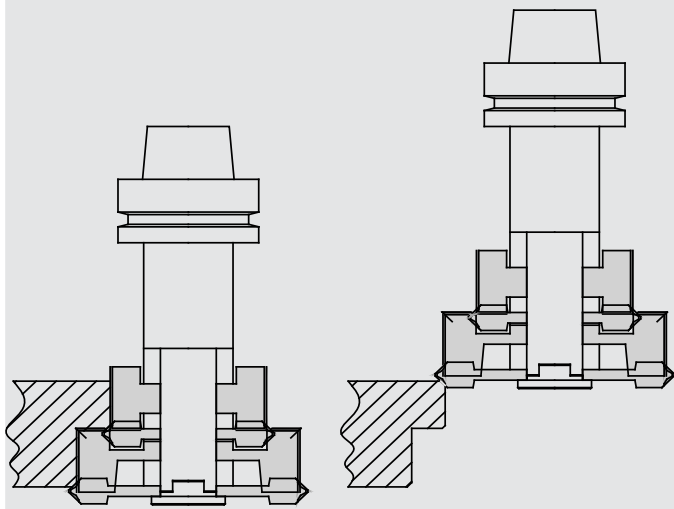
Options 2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
A-2		45	13	E	120610	888737
A-3	2		13	E	120610	888738
A-3	3		13	E	120610	888739
A-2		45	15	A	120610	879845
A-3	2		15	A	120660	881168
A-3	3		15	A	120660	881169
C-2		45		B	120610	879830
C-3	2			B	120610	881166
C-3/4	3			B	120610	881167
C-3	4			F-1	120610	879984
C-3	5			F-1	120610	881170
C-3/4	6			F-1	120610	881171
C-3	8			U-1	120610	881880
	[mm]	[°]	[mm]			

Options2	R	Chamfer	Tmax	Cutterhead	Class-No.	Ident-No.
C-3/4	10			U-1	120610	881881
C-5	3			N	120610	879859
C-5	4			N	120610	881164
C-5	5			K	120610	879858
C-5	6			K	120610	881165
	[mm]	[°]	[mm]			



Modula Door Set Application

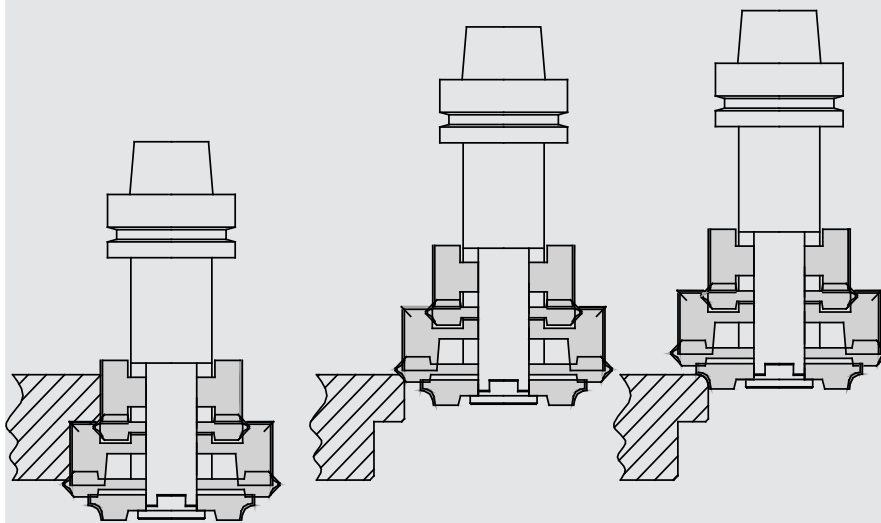
application example for different door thicknesses
profile is done in two passes



1 nd Operation

2 nd Operation

Application example with add-on cutterheads for individual doors



1 nd Operation

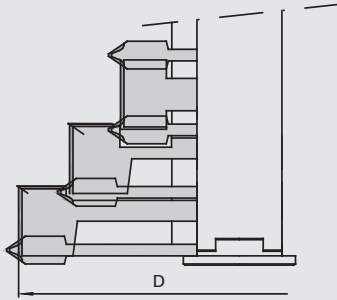
2. 2. Pass chamfer, rounding or top of rodshape can be controlled via the program

128660

Modula Double Rabbeting Sets HW

Product

Drawing

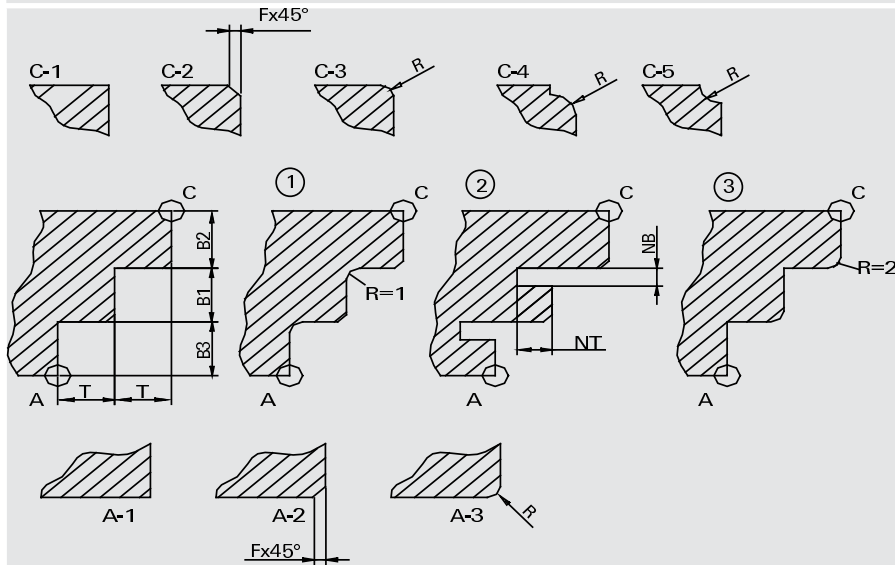


LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

| CNC routers
| for the production of door rabbets

Design

| with shear angle
| basis number of wings Z=2
| unchanging zero-point
| n max = 11,500 min-1

Advantages

| high flexibility thanks to modular design
| simple adjustment by means of rings

Notes

| expandable by chamfering, concave or radius cutterheads
| standard sets: edges A and C are angular
| wrenches are not included in delivery
| mounting-set Ident-No. 198948
| please order shank-tool holder separately

Ø D	B1	B2	B3	Ø d	Tmax		Ident-No.			
130	15-28	15-28	14-28	25	15	H-1, B, T-3, A, T-5	199781			
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]					
Options1					R	B	H	S	Class-No.	Ident-No.
Radius Spurs					1	13	15	2	150552	888476
					[mm]	[mm]	[mm]	[mm]		
Options2			B	Tmax			Class-No.	Ident-No.		
Grooving Knives			4	8			150512	879869		
Grooving Knives			5	8			150512	888747		
			[mm]	[mm]						
Spare parts						Dimension	Class-No.	Ident-No.		
Countersunk Flat Headed Screws for grooving knife						M5x11 T20	995125	879871		
						[mm]				

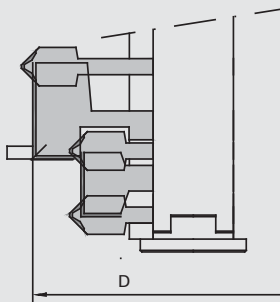
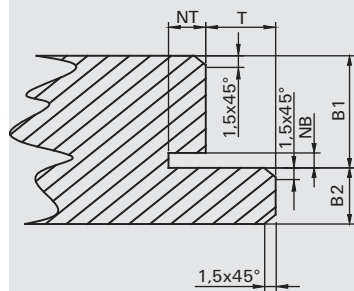
Options	R	Chamfer \sphericalangle	Cutterhead	Class-No.	Ident-No.
A-2		45	Y	120610	880580
A-3	2		Y	120660	880581
A-3	3		Y	120660	880582
C-2		45	B	120610	879830
C-3	2		B	120610	881166
C-3/4	3		B	120610	881167
C-3	4		F-1	120610	879984
C-3	5		F-1	120610	881170
C-3/4	6		F-1	120610	881171
C-3	8		U-1	120610	881880
C-3/4	10		U-1	120610	881881
C-5	3		N	120610	879859
C-5	4		N	120610	881164
C-5	5		K	120610	879858
C-5	6		K	120610	881165
	[mm]	[°]			

128660

Modula Door Frame Rabbeting Sets HW with chamfer

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

l CNC routers
l for the production of frame rabbets

Design

l set with chamfered edges and groove 4 x 8 mm
l with shear angle
l basis number of wings Z=2
l Ø 100 mm: n max = 14,500 min-1

Advantages

l high flexibility thanks to modular design
l simple adjustment by means of rings

Notes

l available also in counter-clockwise rotation or for rabbeting from below
l wrenches are not included in delivery
l mounting-set Ident-No. 198948
l please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199747
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199746
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199745
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199748
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives

B

Tmax

Class-No.

Ident-No.

4

8

150512

879869

5

8

150512

888747

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws for grooving knife

M5x11 T20

995125

879871

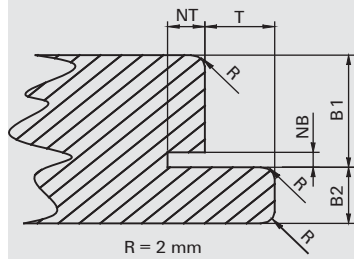
[mm]

128660

Modula Door Frame Rabbeting Sets HW with radius

Product

Drawing


LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for the production of frame rabbets

Design

| set with rounded edges and groove 4 x 8 mm
 | with shear angle
 | basis number of wings Z=2
 | Ø 100 mm: n max = 14,500 min-1

Advantages

| high flexibility thanks to modular design
 | simple adjustment by means of rings

Notes

| available also in counter-clockwise rotation or for rabbeting from below
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948
 | please order shank-tool holder separately

Ø D	B1	B2	Ø d	Tmax		Ident-No.
96	15-30	8-20	25	13	C-2, 2xB, T-2, E	199777
96	22-40	14-30	25	13	H-2, 2xB, T-7, E	199778
100	15-30	8-20	25	15	C-2, 2xB, T-4, A	199779
100	22-40	14-30	25	15	H-2, 2xB, T-9, A	199780
[mm]	[mm]	[mm]	[mm]	[mm]		

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	8	150512	879869
	5	8	150512	888747
	[mm]	[mm]		

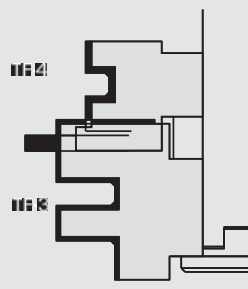
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20 [mm]	995125	879871

128660

Modula Door Case Sets HW

Product

Drawing

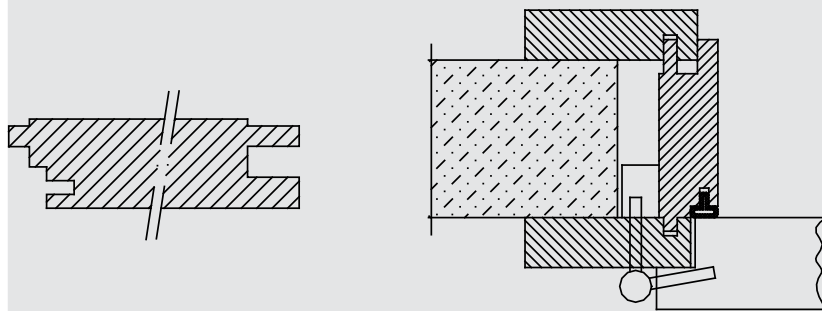


LEUCO
CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

- CNC routers
- for the production of door leaves made from solid wood and wood-based panels

Design

- basis number of wings Z=2
- n max = 14,500 min⁻¹

Advantages

- high flexibility thanks to modular design
- simple adjustment by means of rings

Notes

- machining of both sides with same set
- cutter set for one-sided operation upon request
- wrenches are not included in delivery
- mounting-set Ident-No. 198948
- please order shank-tool holder separately

Ø D	B1	Ø d	Tmax		Ident-No.
100 [mm]	25-30 [mm]	25 [mm]	15 [mm]	TF-3, TF-4	9202895

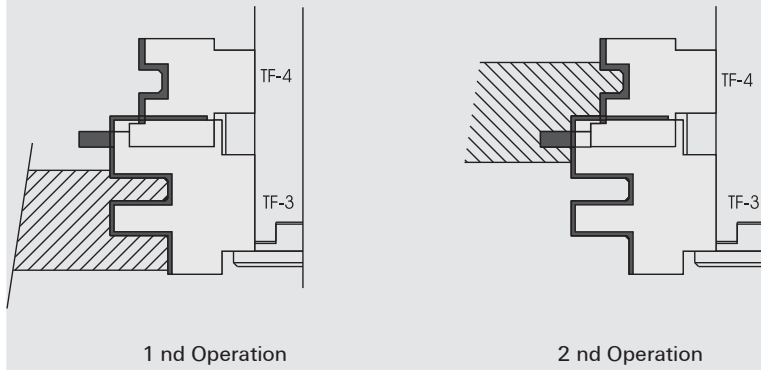
Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Profile Turnover Knives	10	13.5	1.5	up to 2006	151556	888963
Profile Turnover Knives	22,3	18	2	TF-4	151556	885906
Profile Turnover Knives	41	28.2	2	TF-3	151556	9202581
	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	[mm]	[mm]		

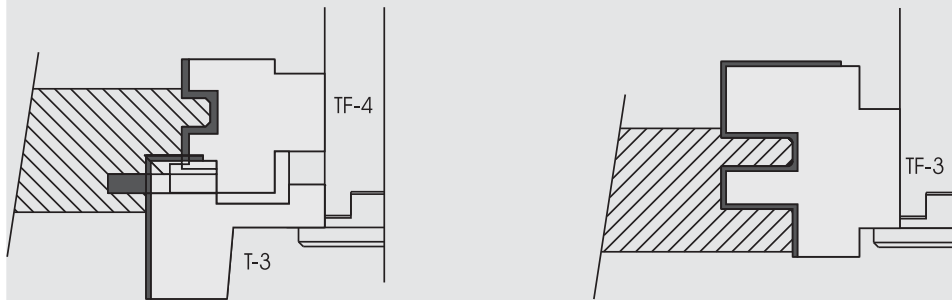
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20 [mm]	995125	879871

Modula Door Set Application

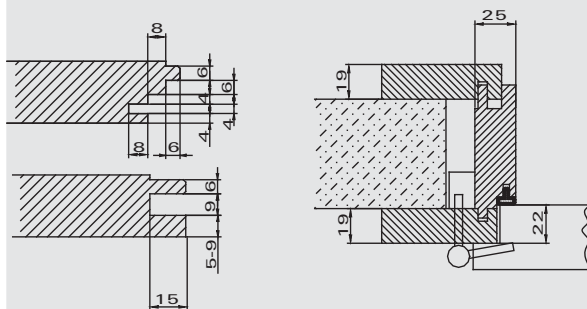
Application example with standard tool
 Profile is done in two passes



application example if cutting height is too small for the standard solution
 2 tools are used



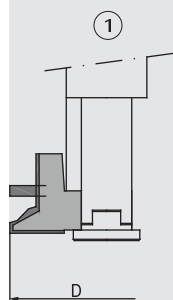
dimensions



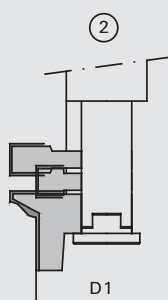
128660

Modula Counterprofile Sets HW - one-sided

Product



Drawing

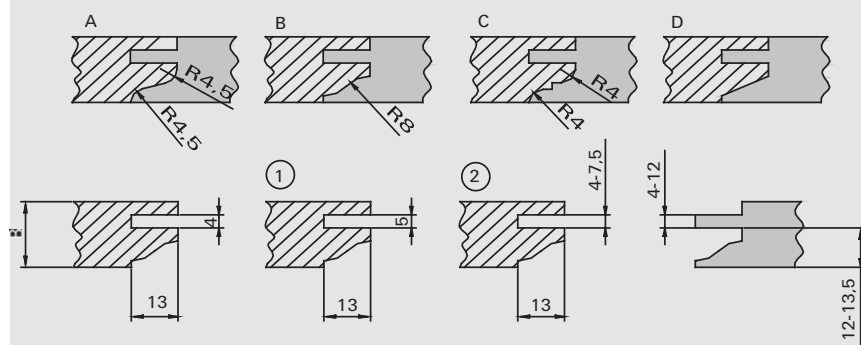


LEUCO
GNC

tungsten carbide [HW]

MEC

Application example



Machine / Application

l CNC routers
l for length- and counterprofiles on furniture parts, i.e. furniture doors and cassettes

Design

l basis number of wings Z=2
l \varnothing 100 mm: n max = 14,500 min-1

Advantages

l 4 profiles in the same body
l complete machining in one pass

Notes

l standard delivery with profile B, groove 4 x 13 mm
l optionally groove 5 x 13 mm or adjustable 4 - 7.5 x 13 mm
l available for clockwise and counter-clockwise rotation
l wrenches are not included in delivery
l mounting-set Ident-No. 198948
l please order shank-tool holder separately

\varnothing D	\varnothing D1	B	\varnothing d	Type	Ident-No.
96	70	20-27	25	1 X-2, groove 4	199775
96	70	20-27	25	2 X-1, G, W	199776
[mm]	[mm]	[mm]	[mm]		

Options 1	B	Tmax	Class-No.	Ident-No.
Grooving Knives	5	13	150512	879870
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

Options 2	B	Tmax	Class-No.	Ident-No.
cutter Q	4	13	120200	881153
	[mm]	[mm]		

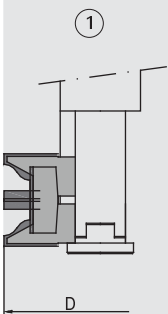
Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile A left	30	26	2	X-1	151521	882465
profile A right	30	26	2	X-2	151522	882466
profile B left	30	26	2	X-1	151521	882463
	[mm]	[mm]	[mm]			

Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile B right	30	26	2	X-2	151522	882464
profile C left	30	26	2	X-1	151521	882461
profile C right	30	26	2	X-2	151522	882462
profile D left	30	26	2	X-1	151521	882467
profile D right	30	26	2	X-2	151522	882468
	[mm]	[mm]	[mm]			

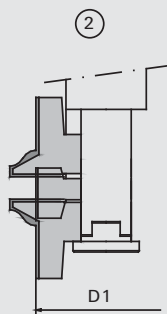
128660

Modula Counterprofile Sets HW - double-sided

Product



Drawing



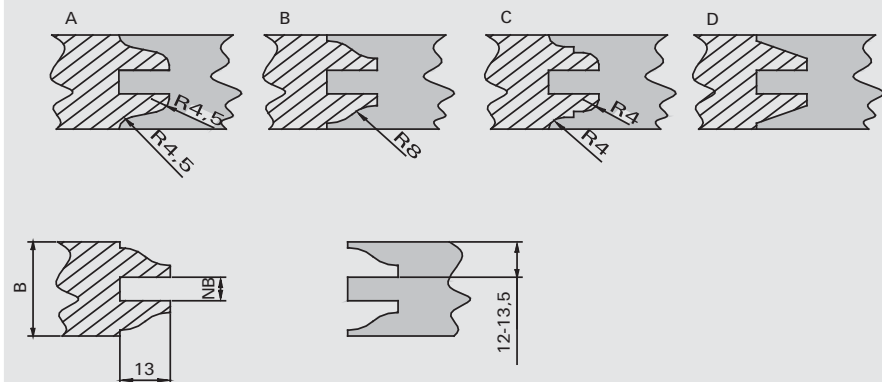
LEUCO

CNC

tungsten carbide [HW]

MEC

Application example



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for length- and counterprofiles on furniture parts, e.g. doors 	<ul style="list-style-type: none"> basis number of wings Z=2 Ø 100 mm: n max = 14,500 min-1 	<ul style="list-style-type: none"> 4 profiles in the same body complete machining in one pass 	<ul style="list-style-type: none"> standard delivery with profile B, groove 8 - 15 x 13 mm optionally groove 5 - 9,5 x 13 mm possible available for clockwise and counter-clockwise rotation wrenches are not included in delivery mounting-set Ident-No. 198948 please order shank-tool holder separately

Ø D	Ø D1	B	Ø d	Type	Ident-No.
96	70	34-42	25	1	X-1, X-2
96	70	34-42	25	2	X-1, C-1, X-2
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	20	12	1.5	C	150515	003082
	[mm]	[mm]	[mm]			

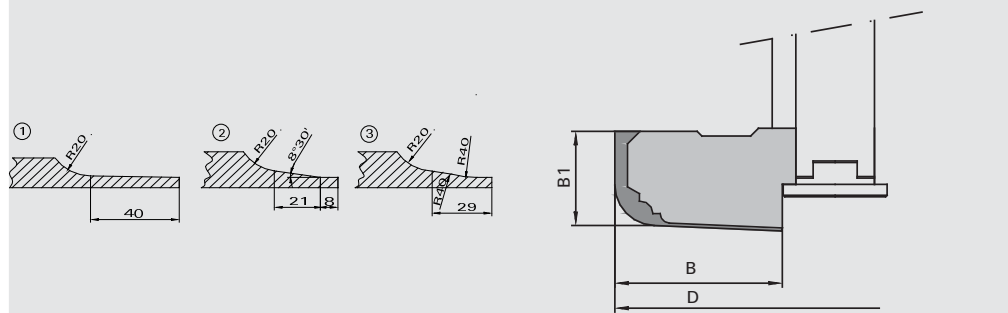
Grooving Knives	B	Tmax	Cutterhead	Class-No.	Ident-No.	
	8	13	X-1	150512	882483	
	8	13	X-2	150512	882460	
	5	13	X-1, X-2	150512	879870	
	[mm]	[mm]				
Spare parts			Dimension	Class-No.	Ident-No.	
Countersunk Flat Headed Screws for grooving knife			M5x11 T20 [mm]	995125	879871	
Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
profile A left	30	26	2	X-1	151521	882465
profile A right	30	26	2	X-2	151522	882466
profile B left	30	26	2	X-1	151521	882463
profile B right	30	26	2	X-2	151522	882464
profile C left	30	26	2	X-1	151521	882461
profile C right	30	26	2	X-2	151522	882462
profile D left	30	26	2	X-1	151521	882467
profile D right	30	26	2	X-2	151522	882468
	[mm]	[mm]	[mm]			

128660

Modula Panel Raising Cutterheads HW

Product

Drawing



LEUCO
GNC

tungsten carbide [HW]

MEC

Machine / Application

l CNC routers
l for panel raising and profiling in solid woods and wood-based panels

Design

l basis number of wings Z=2
l Ø 140 mm: n max = 9,000 min-1

Advantages

Notes

l further profiles are possible according to customer specifications
l wrenches are not included in delivery
l mounting-set Ident-No. 198948
l please order shank-tool holder separately

R	Ø D	B	B1	Ø d	Ident-No.
20	140	55	30	25	888504
[mm]	[mm]	[mm]	[mm]	[mm]	

Knives for bottom cutting edge	B	H	S	Class-No.	Ident-No.
	48	12	1.5	151521	888511
	[mm]	[mm]	[mm]		

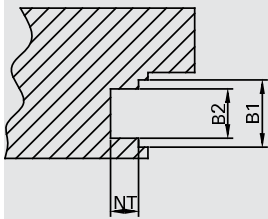
Knives for peripheral cutting edge	R	B	H	S	Class-No.	Ident-No.
	20	30	25	1.5	151766	889076
	[mm]	[mm]	[mm]	[mm]		

Support plate for peripheral cutting edge	R	B	H	Class-No.	Ident-No.
	20	30	25	925300	889077
	[mm]	[mm]	[mm]		

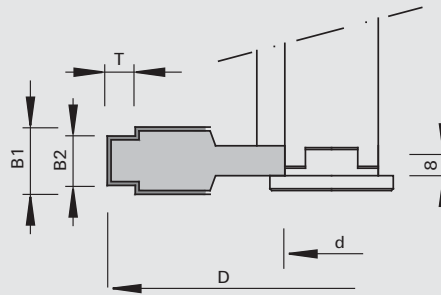
128660

Modula Step Grooving Cutterheads HW

Product



Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
 | for grooving of notches in solid woods and wood-based panels for safety-locks and fittings

Design

| basis number of wings $Z=2$
 | $n \text{ max} = 12,000 \text{ min}^{-1}$

Advantages

| less chipping thanks to divided cut

Notes

| application against feed
 | step groove for 18 and 20 mm possible with same cutter body by changing of profile knives
 | can be combined with other Modula cutterheads
 | wrenches are not included in delivery
 | Mounting Set Ident-No. 198948
 | please order shank tool holder separately

$\varnothing D$	B1	B2	$\varnothing d$	Tmax	Type	Ident-No.
120	18,1	13,2	25	7,5	R	879990
120	20,1	15,2	25	7,5	R	881190
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	B1	H	S	Class-No.	Ident-No.
	18,1	13,2	20	2	150515	881106
	20,1	15,2	20	2	150515	881183
	[mm]	[mm]	[mm]	[mm]		

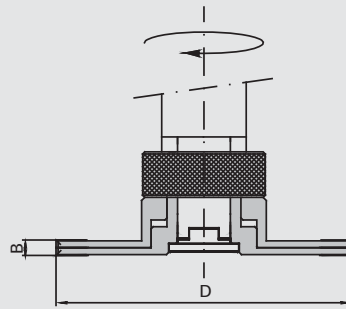
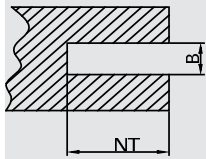
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=18	925300	881105
Magnetic Stops	1,0	997800	166094
	[mm]		

128660

Modula Grooving Cutterheads HW

Product

Drawing



LEUCO
GNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for grooving in solid woods and wood-based panels

Design

| basis number of wings Z=2
| n max = 11,000 min-1

Advantages

| unique adjusting unit with threaded bush

Notes

| play-free adjustment thanks to setting ring gauge
| fine-adjustment scale with 0,1 mm increments
| wrenches are not included in delivery
| mounting-set Ident-No. 198948
| please order shank-tool holder separately

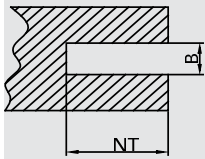
Ø D	B	Ø d	Tmax	Z		Ident-No.
140	4-7,5	25	40	4+4+4	with spurs	889645
140	7,5-11	25	40	4+2+4	with spurs	889876
150	10-18	25	45	2+2+4	with spurs	9201087
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	For Ident-No.	Class-No.	Ident-No.
Turnover Knives	9	12	1.5	889876	150515	167256
Turnover Knives	9,6	12	1.5	9201087	150515	171163
Turnover Knives	7,6	12	1.5	889876, 889645	150515	052543
Spurs	14	14	1.2	889876, 889645	150559	163701
Spurs	14	14	2	9201087	150559	003079
	[mm]	[mm]	[mm]			

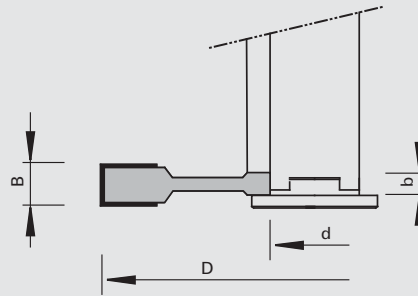
128660

Modula Planet Cutterheads HW

Product



Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for grooving of notches in solid woods and wood-based panels for fittings and drop-down seals (Planet) on doors

Design

| number of teeth $Z = 3 + 3$
| $n_{max} = 10,100 \text{ min}^{-1}$

Advantages

| reduced cutting pressure and less chipping thanks to division of cut

Notes

| application with feed
| mountable lefthand or righthand
| can be combined with other Modula cutterheads
| wrenches are not included in delivery
| Mounting Set Ident-No. 198948
| please order shank tool holder separately

$\emptyset D$	B	b	$\emptyset d$	Z	Type	Ident-No.
150	13,1	7	25	3+3	I	9206343
[mm]	[mm]	[mm]	[mm]			

Knives	B	H	S	Class-No.	Ident-No.
	7	12	1.5	until 1999	150515 881453
	9	12	1.5	from 2000	150515 167256
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=7,2	925100	870829
Magnetic Stops	1,0	997800	166094
	[mm]		

120210

Modula Single Jointing/Rabbeting Cutterheads HW - Z=2

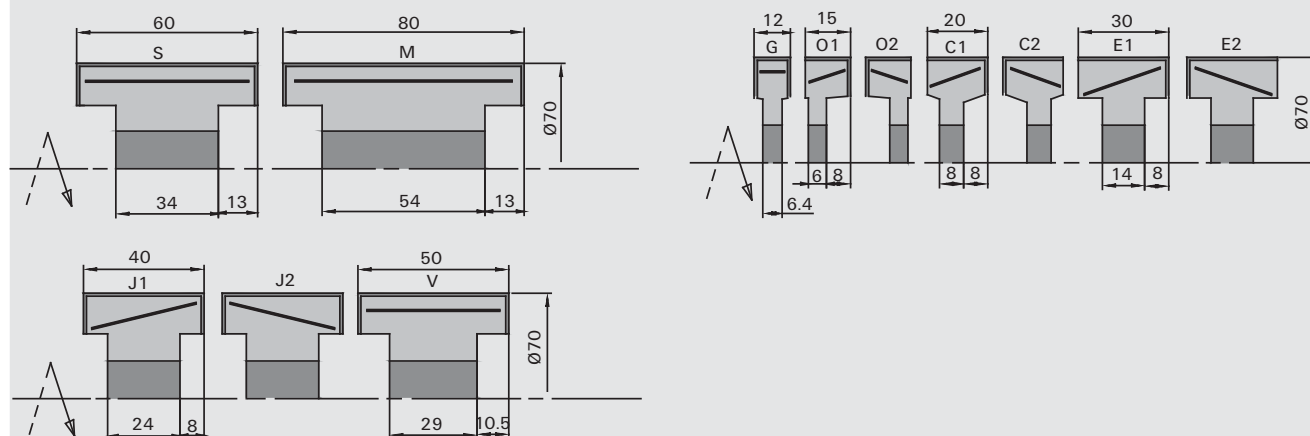
Product

Drawing



tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for jointing and rabbeting in solid woods and wood-based panels

Design

| cutterheads with B = 15 mm to 40 mm with shear angle
 | number of teeth Z = 2
 | n max = 14,500 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

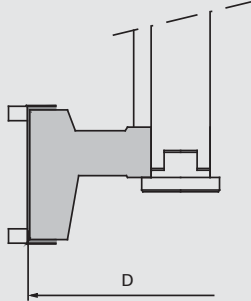
Ø D	B	b	Ø d	Z	Type	Ident-No.
70	12	6.4	25	2	G	879829
70	15	6	25	2	O-1	879828
70	15	6	25	2	O-2	879833
70	20	8	25	2	C-1	879827
70	20	8	25	2	C-2	879832
70	30	14	25	2	H-1	879854
70	30	14	25	2	H-2	879855
70	40	24	25	2	J-1	882012
70	40	24	25	2	J-2	882013
70	50	29	25	2	V	9201908
70	60	34	25	2	S	888526
70	80	54	25	2	M	888527
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	12	12	1.5	G	150515	003080
Turnover Knives	15	12	1.5	O-1, O-2	150515	003081
Turnover Knives	20	12	1.5	C-1, C-2	150515	003082
Turnover Knives	30	12	1.5	H-1, H-2	150515	003083
Turnover Knives	40	12	1.5	J-1, J-2	150515	164078
Turnover Knives	50	12	1.5	V	150515	003085
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Turnover Knives	60	12	1.5	S	150515	003086
Turnover Knives	80	12	1.5	M	150512	888545
	[mm]	[mm]	[mm]			
Spare parts	Dimension	Cutterhead		Class-No.	Ident-No.	
Set Screws	M5x10			995161	881087	
Clamping Bars	B=10	G, O-1, O-2		925300	164526	
Clamping Bars	B=18	C-1, C-2		925300	164076	
Clamping Bars	B=30	H-1, H-2		925300	164185	
Clamping Bars	B=40	J-1, J-2		925300	882014	
Clamping Bars	B=50	V		925300	883382	
Clamping Bars	B=60	S		925300	888543	
Clamping Bars	B=80	M		925300	888544	
Magnetic Stops	1,0			997800	166094	
	[mm]					

120210

Modula Single Rabbeting Cutterheads HW - Z=3

Product	Drawing		
			
		LEUCO CNC	
		tungsten carbide [HW]	
		MEC	
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing and rabbeting in solid woods and wood-based panels 	<ul style="list-style-type: none"> number of teeth Z = 3 with shear angle body made of aluminum n max = 11,700 min-1 		<ul style="list-style-type: none"> to be used with corresponding shank adapters and in combination with other Modula cutterheads optionally grooving knives can be used wrenches are not included in delivery mounting-set Ident-No. 198948


Ø D	B	b	Ø d	Tmax	Z	Ident-No.
140	48	35.6	25	47	3+6+6V	9205912
140	38	25.6	25	47	3+6+6V	9205913
[mm]	[mm]	[mm]	[mm]	[mm]		

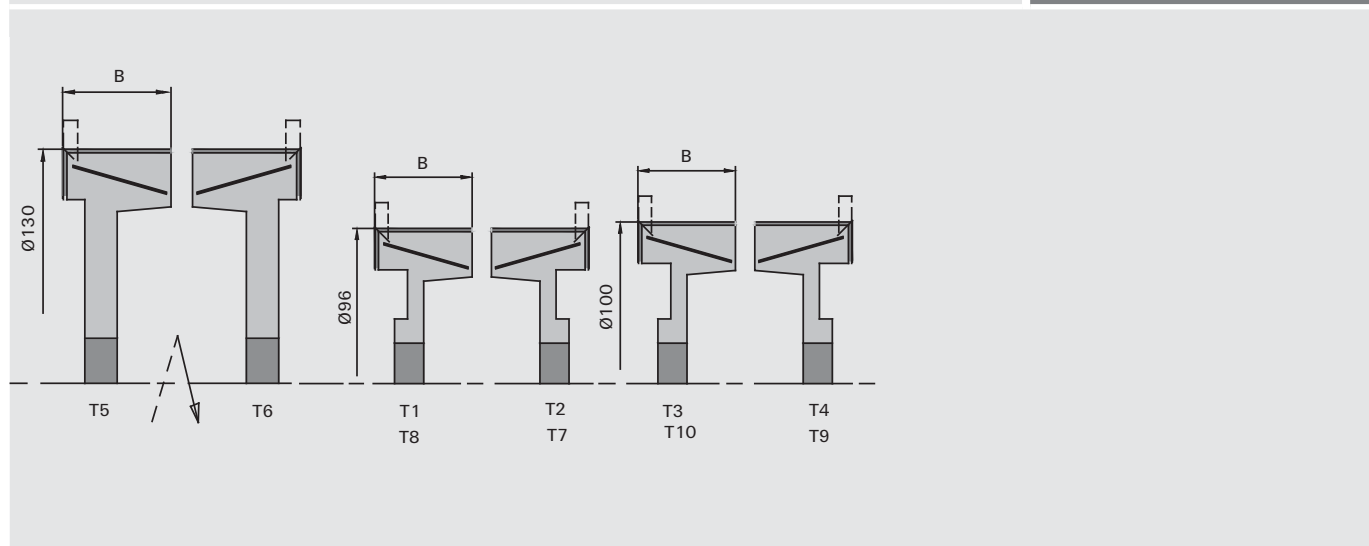
Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	39,2	12	1.5	150515	9203225
Turnover Knives	49,2	12	1.5	150515	9203226
Grooving Knives	4	8		150512	879869
Grooving Knives	4	13		150512	881180
Grooving Knives	5	8		150512	888747
Grooving Knives	5	8		150512	888748
Grooving Knives	5	13		150512	888749
Grooving Knives	5	13		150512	888750
	[mm]	[mm]	[mm]		

Spare parts		Dimension	For Ident-No.	Class-No.	Ident-No.
Countersunk Flat Headed Screws	for grooving knives	M5x11 T20		995125	879871
Countersunk Flat Headed Screws	for spurs	M5x7 T15		995125	900512
set screws		M6x20		995161	9204674
Pressure Jaws		B=38	9205913	925300	9205914
Pressure Jaws		B=48	9205912	925300	9201835
		[mm]			

120210

Modula Single Rabbeting Cutterheads HW - Z=2

Product	Drawing
	 <p>tungsten carbide [HW]</p> <p>MEC</p>



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for jointing and rabbeting in solid woods and wood-based panels 	<ul style="list-style-type: none"> number of teeth Z = 2 with shear angle Ø 100 mm: n max = 14,500 min-1 Ø 130 mm: n max = 11,500 min-1 		<ul style="list-style-type: none"> to be used with corresponding shank adapters and in combination with other Modula cutterheads wrenches are not included in delivery mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Z	Type	Ident-No.
96	30	9	25	2+2V	T-1	888467
96	30	9	25	2+2V	T-2	888466
96	40	15.5	25	2+2V	T-8	889427
96	40	15.5	25	2+2V	T-7	889426
100	30	9	25	2+2V	T-3	888524
100	30	9	25	2+2V	T-4	888523
100	40	15.5	25	2+2V	T-10	889429
100	40	15.5	25	2+2V	T-9	889428
130	30	9	25	2+2V	T-5	888525
130	30	9	25	2+2V	T-6	888522
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Cutterhead	Class-No.	Ident-No.
Spurs	14	14	2	T-3	150559	003079
Turnover Knives	30	12	1.5	T-1 to T-6	150515	003083
Turnover Knives	40	12	1.5	T-7 to T-10	150515	164078
Grooving Knives	4	8			150512	879869
Grooving Knives	4	13			150512	881180
Grooving Knives	5	8		T-1, T-3, T-5, T-8, T-10	150512	888747
Grooving Knives	5	8		T-2, T-4, T-6, T-7, T-9	150512	888748
Grooving Knives	5	13		T-1, T-3, T-5, T-8, T-10	150512	888749
Grooving Knives	5	13		T-2, T-4, T-6, T-7, T-9	150512	888750
	[mm]	[mm]	[mm]			

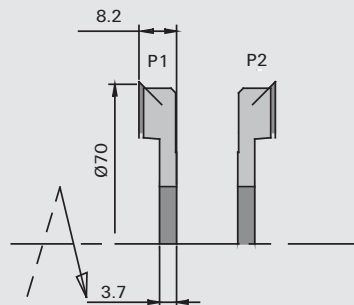
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
Countersunk Flat Headed Screws for spur	M5x7 T15	995125	900512
Set Screws	M5x10	995161	881087
Clamping Bars	B=30	925300	164185
Clamping Bars	B=40	925300	882014
Magnetic Stops	1,0	997800	166094
	[mm]		

120200

Modula Single Pre-Cut Cutterheads HW

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

l CNC routers
l for scoring in solid woods and wood-based panels

Design

l number of teeth Z = 2
l n max = 14,500 min-1

Advantages

Notes

l to be used with corresponding shank adapters and in combination with other Modula cutterheads
l wrenches are not included in delivery
l mounting-set Ident-No. 198948

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	8,2	3.7	25	2+2V	P-1	879831
70	8,2	3.7	25	2+2V	P-2	879834
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Radius Spurs	13	15	2	150552	888476
	[mm]	[mm]	[mm]		

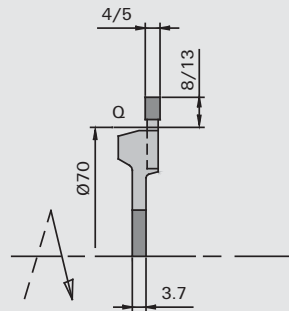
Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x7 T15	995125	900512
	[mm]		

120200

Modula Single Grooving Cutterheads HW

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for grooving in solid woods and wood-based panels

Design

| number of teeth $Z = 2$
| $n_{max} = 14,500 \text{ min}^{-1}$

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No. 198948

Ø D	B	Ø d	Tmax	Z	Type	Ident-No.
70	4	25	8	2	Q	879835
70	4	25	13	2	Q	881153
70	5	25	8	2	Q	881154
70	5	25	13	2	Q	881155
[mm]	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	4	8	150512	879869
	5	13	150512	879870
	5	8	150512	881179
	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws for grooving knife	M5x11 T20	995125	879871
	[mm]		

120610

Modula Single Chamfering Cutterheads HW

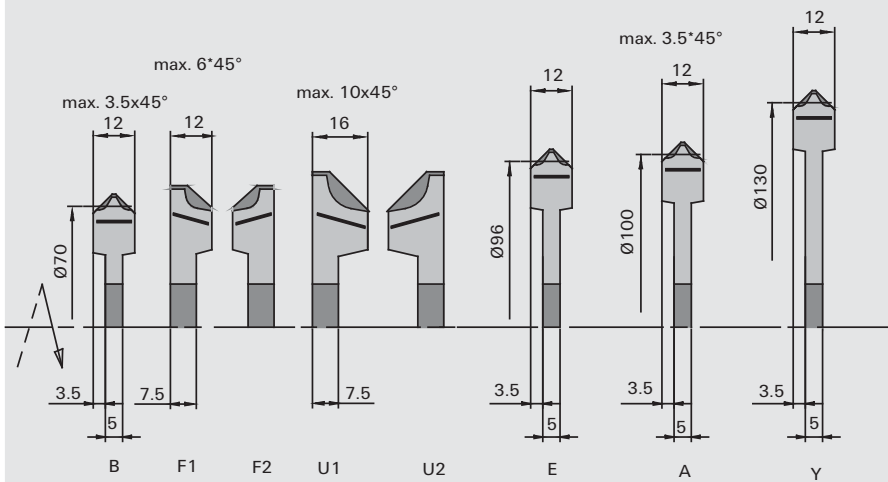
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

| CNC routers
 | for chamfering in solid woods and wood-based panels

Design

| number of teeth Z = 2
 | Ø 108 mm: n max = 14,500 min-1
 | Ø 138 mm: n max = 11,500 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
 | wrenches are not included in delivery
 | mounting-set Ident-No. 198948

Chamfer	Ø D	B	Ø d	Z	Type	Ident-No.
45	78	12	25	2	B	879830
45	82	12	25	2	F-1	881879
45	82	12	25	2	F-2	881878
45	90	16	25	2	U-1	881882
45	90	16	25	2	U-2	881885
45	104	12	25	2	E	888737
45	108	12	25	2	A	879845
45	138	12	25	2	Y	880580
[°]	[mm]	[mm]	[mm]			

Knives

Chamfer

B

S

Cutterhead

Class-No.

Ident-No.

45	12	1.5	A, B, E, Y	151545	180792
45	12	2	F-1	151545	881855
45	12	2	F-2	151545	881856
45	16	2	U-1	151545	881874
45	16	2	U-2	151545	881875
[°]	[mm]	[mm]			

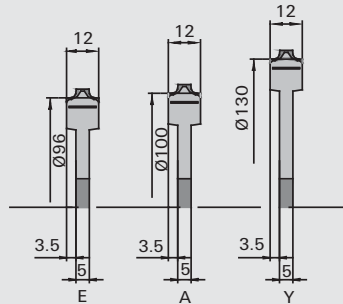
Spare parts	Dimension	Cutterhead	Class-No.	Ident-No.
Set Screws	M5x10		995161	881087
Clamping Bars	B=12	A, B, E, Y	925300	881496
Clamping Bars	B=10	F-1, F-2	925300	164526
Clamping Bars	B=16	U-1	925300	881876
Clamping Bars	B=16	U-2	925300	881877
Magnetic Stops	0,0		997800	016613
	[mm]			

120210

Modula Single Rounding Cutterheads HW

Product

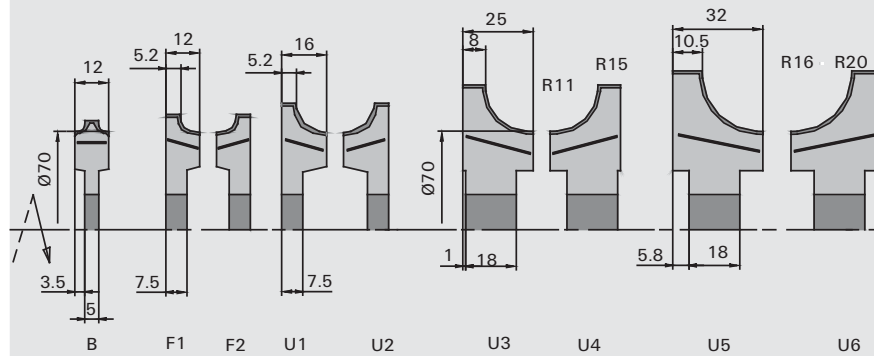
Drawing



LEUCO
GNC

tungsten carbide [HW]

MEC



Machine / Application

- | CNC routers
- | for rounding of solid woods and wood-based panels

Design

- | number of teeth Z = 2
- | Ø 108 mm: n max = 14,500 min-1
- | Ø 138 mm: n max = 11,500 min-1

Advantages

Notes

- | to be used with corresponding shank adapters and in combination with other Modula cutterheads
- | wrenches are not included in delivery
- | mounting-set Ident-No. 198948

R	Ø D	B	Ø d	Z	Type	Ident-No.
2	78	12	25	2	B	881166
3	78	12	25	2	B	881167
4	82	12	25	2	F-1	879984
4	82	12	25	2	F-2	879985
5	82	12	25	2	F-1	881170
5	82	12	25	2	F-2	881172
6	82	12	25	2	F-1	881171
6	82	12	25	2	F-2	881173
8	90	16	25	2	U-1	881880
8	90	16	25	2	U-2	881883
10	90	16	25	2	U-1	881881
10	90	16	25	2	U-2	881884
2	104	12	25	2	E	888738
3	104	12	25	2	E	888739
[mm]	[mm]	[mm]	[mm]			

R	Ø D	B	Ø d	Z	Type	Ident-No.
2	108	12	25	2	A	881168
3	108	12	25	2	A	881169
2	138	12	25	2	Y	880581
3	138	12	25	2	Y	880582
11	103	25	25	2	U-3	9202138
11	103	25	25	2	U-4	9202139
12	103	25	25	2	U-3	9202140
12	103	25	25	2	U-4	9202141
13	103	25	25	2	U-3	9202142
13	103	25	25	2	U-4	9202143
14	103	25	25	2	U-3	9202144
14	103	25	25	2	U-4	9202145
15	103	25	25	2	U-3	9202146
15	103	25	25	2	U-4	9202147
16	113	32	25	2	U-5	9202128
16	113	32	25	2	U-6	9202129
17	113	32	25	2	U-5	9202130
17	113	32	25	2	U-6	9202131
18	113	32	25	2	U-5	9202132
18	113	32	25	2	U-6	9202133
19	113	32	25	2	U-5	9202134
19	113	32	25	2	U-6	9202135
20	113	32	25	2	U-5	9202136
20	113	32	25	2	U-6	9202137
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	Ident-No.
	2	12	1.5	A, B, E, Y	151545	170340
	3	12	1.5	A, B, E, Y	151545	170341
	4	12	2	F-1	151545	881189
	4	12	2	F-2	151545	881188
	5	12	2	F-1	151545	881187
	5	12	2	F-2	151545	881186
	6	12	2	F-1	151545	879987
	6	12	2	F-2	151545	879988
	8	16	2	U-1	151545	881870
	8	16	2	U-2	151545	881871
	10	16	2	U-1	151545	881872
	10	16	2	U-2	151545	881873
	11	25	2	U-3	151545	9201953 o
	11	25	2	U-4	151545	9201954 o
	12	25	2	U-3	151545	9201951 o
	12	25	2	U-4	151545	9201952 o
	13	25	2	U-3	151545	9201949 o
	13	25	2	U-4	151545	9201950 o
	14	25	2	U-3	151545	9201947 o
	14	25	2	U-4	151545	9201948 o
	15	25	2	U-3	151545	9201913
	15	25	2	U-4	151545	9201914
	16	32	2	U-5	151545	9201961 o
	16	32	2	U-6	151545	9201962 o
	17	32	2	U-5	151545	9201959 o
	17	32	2	U-6	151545	9201960 o
	18	32	2	U-5	151545	9201957 o
	18	32	2	U-6	151545	9201958 o
	19	32	2	U-5	151545	9201955 o
	19	32	2	U-6	151545	9201956 o
	20	32	2	U-5	151545	9201936
	20	32	2	U-6	151545	9201937
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Cutterhead	Class-No.	Ident-No.
Set Screws	M5x10		995161	881087
Clamping Bars	B=12	A, B, E, Y, F-1, F-2	925300	881496
Clamping Bars	B=16	U-1	925300	881876
Clamping Bars	B=16	U-1	925300	881877
Clamping Bars	B=25	U-3	925300	9201887
Clamping Bars	B=25	U-4	925300	9201888
Clamping Bars	B=32	U-5	925300	9201883
Clamping Bars	B=32	U-6	925300	9201884
Magnetic Stops	0,0		997800	016613
	[mm]			

120610

Modula Single Chamfering Cutterheads HW - machining of aluminum

Product	Drawing	
		<p>LEUCO CNC</p> <p>tungsten carbide [HW]</p> <p>MEC</p>

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC routers for chamfering in aluminum 	<ul style="list-style-type: none"> number of teeth Z = 2 Ø 111mm: n max = 14,500 min-1 Ø 141 mm: n max = 11,500 min-1 		<ul style="list-style-type: none"> to be used with corresponding shank adapters and in combination with other Modula cutterheads wrenches are not included in delivery mounting-set Ident-No. 198948

Chamfer	Ø D	B	Ø d	Z	Type	Ident-No.
45	107	16	25	2	D-2	888528
45	111	16	25	2	D-4	888529
45	141	16	25	2	D-6	888530
[°]	[mm]	[mm]	[mm]			

Knives	Chamfer	B	S	Class-No.	Ident-No.
	45	16	2	151545	170329
	[°]	[mm]	[mm]		

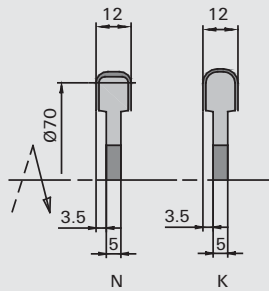
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=16	925300	888887
Magnetic Stops	0,0	997800	016613
	[mm]		

120610

Modula Single Concave Cutterheads HW

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

| CNC routers
| for coves in solid woods and wood-based panels

Design

| number of teeth Z = 2
| n max = 14,500 min-1

Advantages

Notes

| to be used with corresponding shank adapters and in combination with other Modula cutterheads
| wrenches are not included in delivery
| mounting-set Ident-No. 198948

R	Ø D	B	Ø d	Z	Type	Ident-No.
3	78	12	25	2	N	879859
4	78	12	25	2	N	881164
5	82	12	25	2	K	879858
6	82	12	25	2	K	881165
[mm]	[mm]	[mm]	[mm]			

Knives	R	B	S	Cutterhead	Class-No.	Ident-No.
	3	12	2	N	151521	881185
	4	12	2	N	151521	881184
	5	12	2	K	151521	879861
	6	12	2	K	151521	879860
	[mm]	[mm]	[mm]			

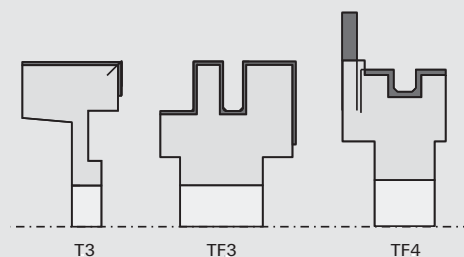
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M5x10	995161	881087
Clamping Bars	B=12	925300	881488
Magnetic Stops	1,0	997800	166094
	[mm]		

120210

Modula Single Cutterheads HW - production of door casings

Product

Drawing



LEUCO
CNC

tungsten carbide [HW]

MEC

Machine / Application

l CNC routers
l for door casings in solid woods and wood-based panels

Design

l number of teeth Z = 2
l n max = 14,500 min-1

Advantages

l machining of both sides with the same set

Notes

l for use with corresponding shank adapters and in combination with other Modula cutterheads
l wrenches are not included in delivery
l Mounting Set Ident-No. 198948
l tools for one-sided operation upon request

Ø D	B	b	Ø d	Z	Type	Ident-No.
100	22	16.3	25	2	TF-4	9202564
100	41	25	25	2	TF-3	9202563
100	30	9	25	2+2V	T-3	888524
[mm]	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	For Ident-No.	Class-No.	Ident-No.
Profile Turnover Knives	22,3	18	2	TF-4	151556	885906
Profile Turnover Knives	41	28.2	2	TF-3	151556	9202581
Turnover Knives	30	12	1.5	T-1 to T-6	150515	003083
Spurs	14	14	2	T-3	150559	003079
Profile Turnover Knives	10	13.5	1.5	profile up to 2006	151556	888963
	[mm]	[mm]	[mm]			

Grooving Knives	B	Tmax	Class-No.	Ident-No.
	4	13	150512	881180
	[mm]	[mm]		

Spare parts	Dimension	Cutterhead	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x11 T20	for grooving knife	995125	879871
Clamping Bars	B=18		925300	164076
Clamping Bars	B=40		925300	882014
Clamping Bars	B=30		925300	164185
Set Screws	M5x10		995161	881087
	[mm]			

120210

Modula Single Counter Profile Cutterheads HW

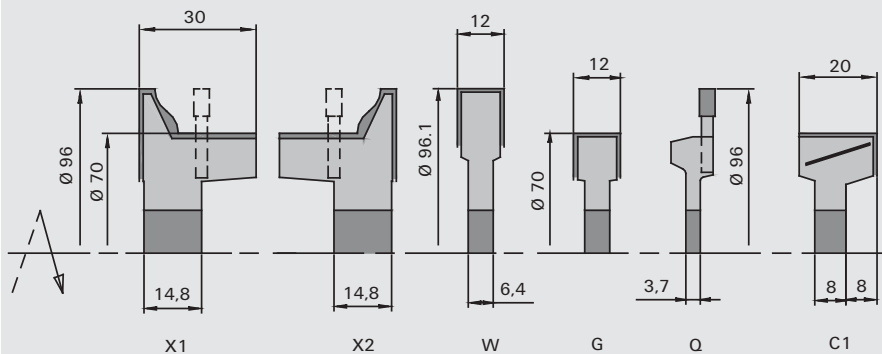
Product

Drawing

LEUCO
CNC

tungsten carbide [HW]

MEC



Machine / Application

l CNC routers
l for length- and counterprofiles
in solid wood and wood-based
materials

Design

l number of teeth $Z = 2$
l $n_{max} = 14,500 \text{ min}^{-1}$

Advantages

Notes

l to be used with corresponding
shank adapters and
in combination with other
Modula cutterheads
l wrenches are not included in
delivery
l mounting-set Ident-
No. 198948

Ø D	B	b	Ø d	Z	Type	Ident-No.
70	20	8	25	2	C-1	879827
70	12	6.4	25	2	G	879829
70	5		25	2	Q	881155
96	12	6.4	25	2	W	882457
96	30	14.8	25	2	X-2	882458
96	30	14.8	25	2	X-1	882459
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Cutterhead

Class-No.

Ident-No.

Set Screws	M5x10		995161	881087
Clamping Bars	B=10	G, O-1, O-2	925300	164526
Clamping Bars	B=18	C-1, C-2	925300	164076
Clamping Bars	B=30	X-1, X-2	925300	882473
Magnetic Stops	1,0		997800	166094
	[mm]			

150512 / 150521

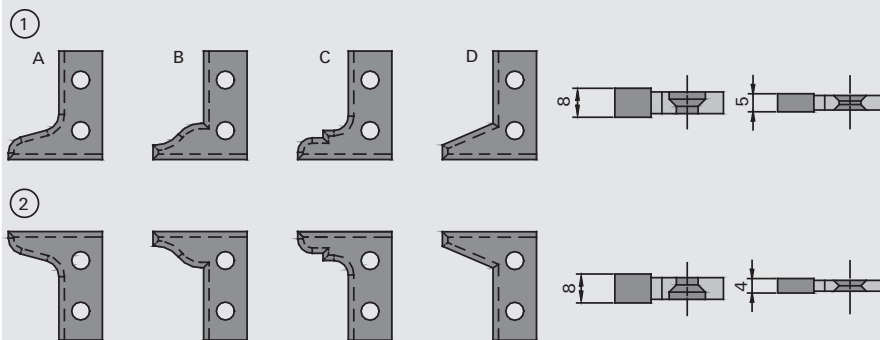
Modula Turnover Knives, Profile Knives HW

Product

Drawing



tungsten carbide [HW]



Machine / Application

l for length- and counterprofiles in solid wood and wood-based materials

Design

l number of teeth $Z = 2$

Advantages

Notes

l type 1 for cutterheads lefthand X-1
l type 2 for cutterheads righthand X-2

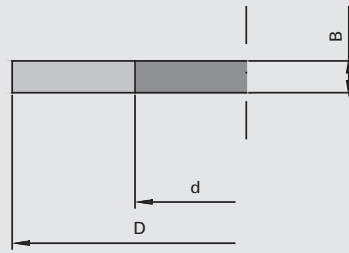
	B	H	S	Type	Ident-No.
grooving knives l + r	4	13			881180
grooving knives l + r	5	13			879870
grooving knives left	8			X-1	882483
grooving knives right	8			X-2	882460
raker	12	12	1.5		003080
raker	20	12	1.5	W, G	003082
profile A left	30	26	2	C-1	882465
profile A right	30	26	2	X-1	882466
profile B left	30	26	2	X-2	882463
profile B right	30	26	2		882464
profile C left	30	26	2		882461
profile C right	30	26	2		882462
profile D left	30	26	2		882467
profile D right	30	26	2		882468
	[mm]	[mm]	[mm]		

955520

Modula Spacers

Product

Drawing



Machine / Application

Design

Advantages

Notes

I special spacers with double keyway for Modula tool system

Ø D	B	Ø d	DKN	Ident-No.
40	20	25	DKN	879880
40	10	25	DKN	879881
40	6	25	DKN	879882
40	5	25	DKN	879883
40	4	25	DKN	879884
40	2	25	DKN	879885
40	1	25	DKN	879886
40	1	25	DKN set 3x0,2 + 4x0,1	881178
40	0,5	25	DKN	879887
40	0,2	25	DKN	881029
40	0,1	25	DKN	881028
[mm]	[mm]	[mm]	[mm]	

985700

Modula Mounting Sets

Product	Drawing	
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Machine / Application	Design	Advantages		Notes
				<p>all Modula cutterheads and sets will be generally supplied without mounting tools; therefore please order the complete mounting-set once the supplied Ø 25mm arbor allows for simplest changing of the cutterheads</p>

	Ident-No.
complete mounting-set	9210474

Content Mounting Set	Dimension	Class-No.	Ident-No.
Screwdrivers	T20	985730	9210391
Screwdrivers	T15x80	985730	171188
Magnetic Stops	0,5	997800	166093
Magnetic Stops	1,0	997800	166094
Copper Paste		993420	879330
Torque Screwdrivers		985730	9210355
Hexagon Insert	SW2,5	985730	9210356
Screwdrivers	SW4x100	985730	166091
Screwdrivers	SW6	985730	881191
Mounting Aids	Ø25	995122	881194
	[mm]		

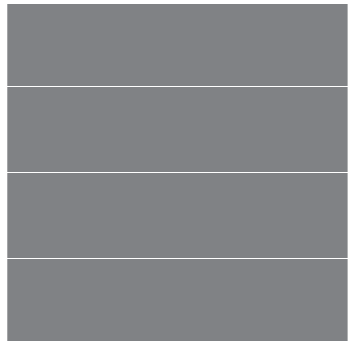
985700

Mounting device for tools with HSK 63

Product



Drawing



Machine / Application

Design

Advantages

Notes

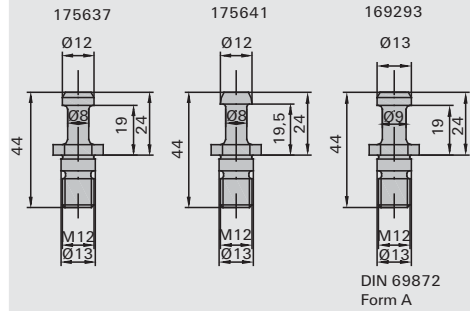
- | for collet chucks, SINO clamping system and change of turnover knives etc.
- | Tool-Support: with clamp lever for torsion protection; tiltable with latch at 90°; simple and secure handling
- | Combi-Grip: especially for Sino clamping system; secure grip by roller clamp

	Ø d	Ident-No.
Kombi-Grip	HSK 63E + F	199874
tool-man	HSK 63F	9215520
replacement clamping ring	HSK 63F	9205048
	[mm]	

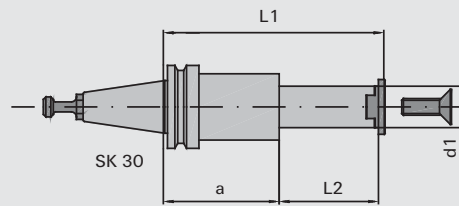
997200

Adapters SK 30

Product



Drawing



Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter SK 30
- | steep angle taper according to DIN 69871 without dog and locating grooves
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | please order retaining bolt separately
- | the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 30	25	25-70	118	45	198971
SK 30	25	25-70	143	70	198973
SK 30	25	25-70	163	90	198975
SK 30	30	25-70	163		198977
[mm]	[mm]	[mm]	[mm]	[mm]	

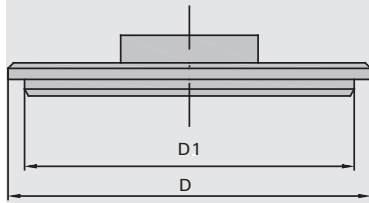
Spare parts

		Class-No.	Ident-No.
Retention Knobs	up to 08/92	997870	175637
Retention knobs	for SK 30	997870	169293
Retention knobs	Ø 12 mm - HSD motor	997870	173641
Pivot Bolts	35-60 mm	985720	881177

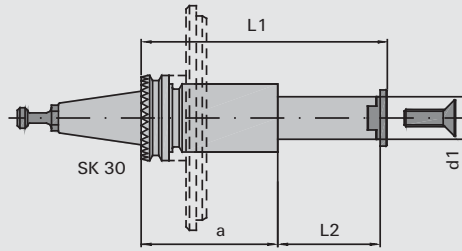
997200

Tool Adapters SK 30 with ring gear

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | adapter SK 30 Morbidelli and SCM
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

- | for Morbidelli 510 and SCM storage lids are not needed
- | for Morbidelli 503 and 504 a storage lid is necessary (to be ordered separately)
- | the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 30 [mm]	25 [mm]	25-70 [mm]	154 [mm]	80 [mm]	882166

Spare parts

Class-No.

Ident-No.

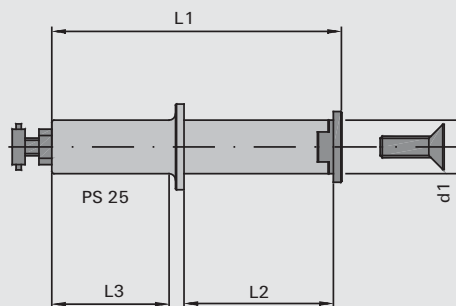
Retention Knobs	Morbidelli, SCM	997870	173646
Storage Lids	Morbidelli 503/504 Ø 125 mm	997300	882311
Storage Lids	Morbidelli 503/504 Ø 135 mm	997300	882308

997200

Adapters PS 25

Product

Drawing



LEUCO
GNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter PS 25 or collets
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

clamping length depending on application; please always state dimension L2

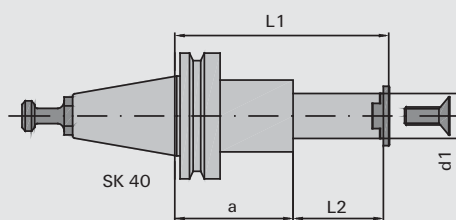
Ø d	L3	Ø d1min	L2	L1	Ident-No.
PS 25	126	25	4,5	135	199708
PS 25	113	25	12,5	135	198953
PS 25	101	25	25	135	198956
PS 25	81	25	45	135	198958
PS 25	55	25	71	135	198960
[mm]	[mm]	[mm]	[mm]	[mm]	

997200

Adapters SK 40

Product

Drawing



LEUCO
GNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- | machine adapter SK 40
- | steep angle taper according to DIN 69871 without dog and locating grooves
- | for clockwise and counter-clockwise rotation
- | anti-twist protection by means of spline
- | incl. clamping lid

Advantages

Notes

incl. retaining bolt according to DIN 69871A
the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
SK 40	25	25-70	118	45	198979
SK 40	25	25-70	143	70	198981
SK 40	25	25-70	163	90	198983
SK 40	30	25-80	163		198985
[mm]	[mm]	[mm]	[mm]	[mm]	

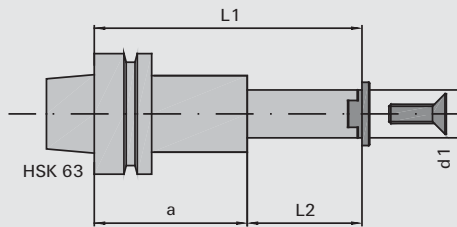
Spare parts		Class-No.	Ident-No.
Retention knobs	up to 08/92	997870	169294
Pivot Bolts	35-60 mm	985720	881177

997200

Adapters HSK 63

Product

Drawing



LEUCO
CNC

Machine / Application

for mounting of Modula sets or single cutters

Design

- machine adapter HSK 63F
- for clockwise and counter-clockwise rotation
- anti-twist protection by means of spline
- incl. clamping lid

Advantages

Notes

- incl. retaining bolt according to DIN 69871A
- the clamping length is determined by application; please always state requested dimensions L2 and A

Ø d	Ø d1min	L2	L1	a	Ident-No.
HSK 63F	25	25-87	137	50	199720 &
HSK 63F	25	25-71	151	80	198967 &
HSK 63F	25	25-71	171	100	199719 &
HSK 63F	30	25-80	160		198968 &
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

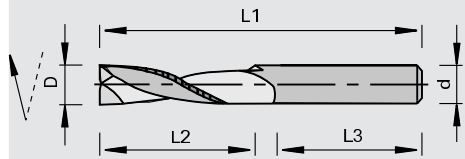
Ident-No.

Pivot Bolts	35-60 [mm]	985720	881177
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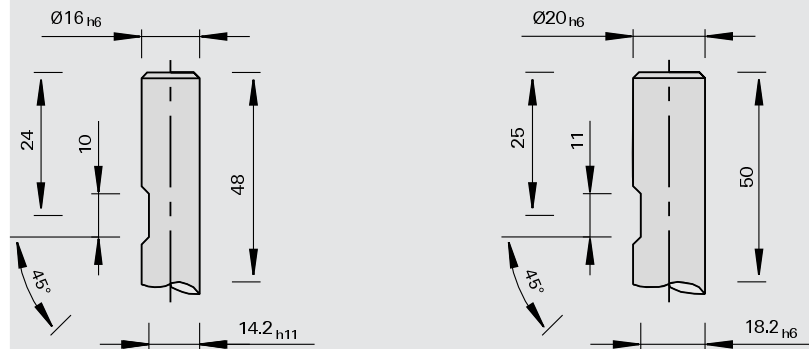
Solid Tungsten Carbide Shank-Type Cutters

Shank design for finishing cutter with chip breakers Class-No. 129460

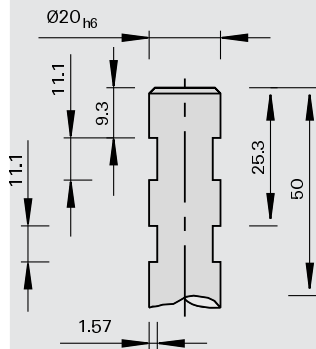
Cylindrical shank without clamping surface



For clamping in spacer sleeves according to DIN 6359 also called Weldon chuck

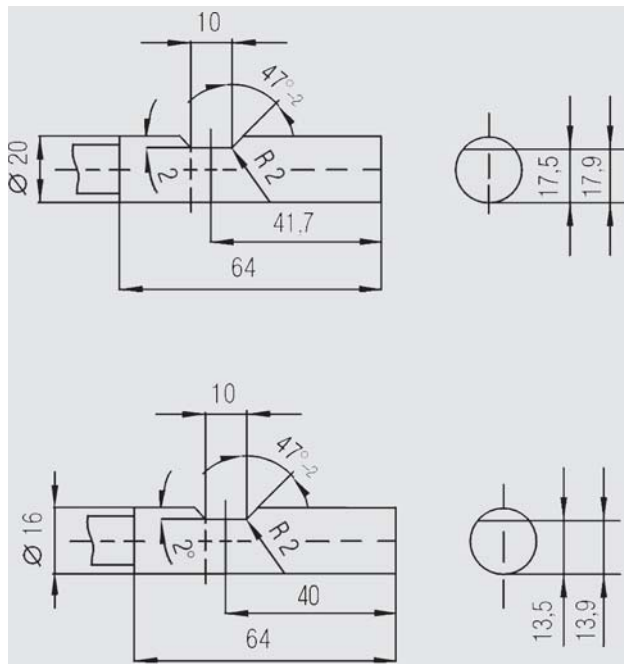


For clamping in special clamping chucks by MAKA

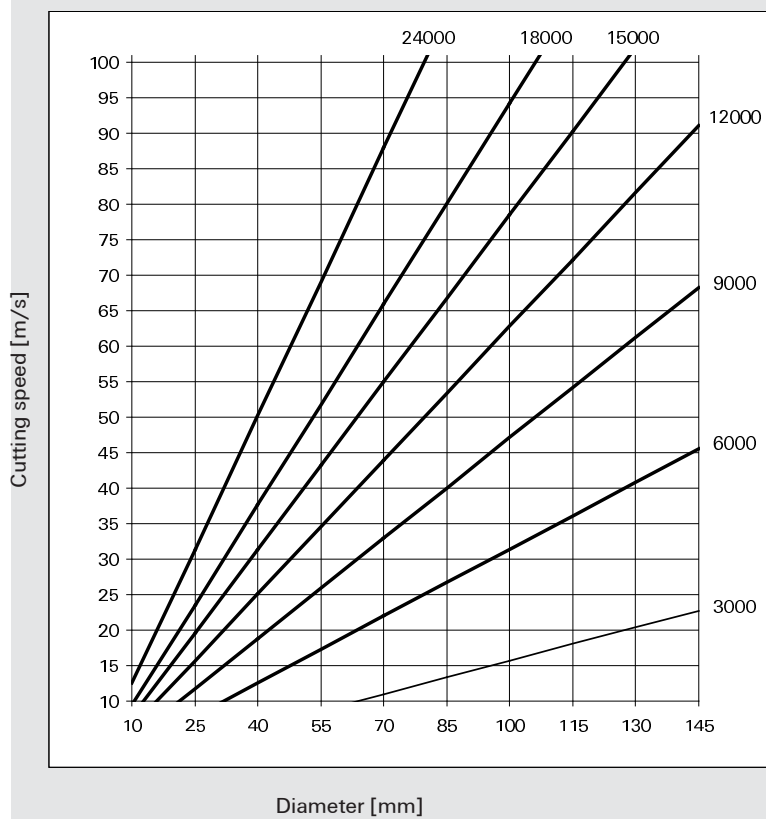


Clamping surface on Shank-Type Cutters

Particularly for solid carbide Lock-Case Cutters used in horizontal drilling/-milling aggregates of Homag and Weeke.



Determination of RPM [min-1]



Order / Inquiry for Special Tools: Shank-Type Cutters

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

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

Machine

Make: _____

Model: _____

Motor output [kW]: _____

RPM range [min-1]: _____

Feed rate [m/min]: _____

Type of feed:	MAN	<input type="radio"/>	<input type="radio"/>
Sense of rotation:	Left	<input type="radio"/>	Right <input type="radio"/>
Only solid carbide cutters: spiral	Positive	<input type="radio"/>	<input type="radio"/>
	Negative	<input type="radio"/>	<input type="radio"/>
No. of teeth [pcs.]:			
Rakers:			
Spur:			
Grooving knives:			
Edge breaker:			

Workpiece material

Description: _____

Cutting quality:

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

Direction of cut:

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

Coating

Yes	<input type="radio"/>	No	<input type="radio"/>
-----	-----------------------	----	-----------------------

Arrangement of cutting edges:

Only peripheral cutting	<input type="radio"/>
With face cutting edge	<input type="radio"/>
With plunge tip	<input type="radio"/>

Shear angle: Single-sided Alternate

Coating

Description: _____

Further Information _____

Cutting material

Carbide	<input type="radio"/>	Diamond	<input type="radio"/>
ST	<input type="radio"/>	HS	<input type="radio"/>
Face side: Top	<input type="radio"/>	Bottom	<input type="radio"/>

Tool

With tipped cutting edges:

With exchangeable cutting edges:

EcoPro Cutterhead	<input type="radio"/>
SuperProfiler	<input type="radio"/>
UltraProfiler	<input type="radio"/>
Standard	<input type="radio"/>

check if applicable

Cutting diameter D [mm]: _____

Cutting length L2 [mm]: _____

Cutting width B [mm]: _____

Overall length L1 [mm]: _____

Shank length L3 [mm]: _____

Shank design:

Cylindrical shank [Ø]: _____

Other shank types [MK2, HSK F63, ...] _____

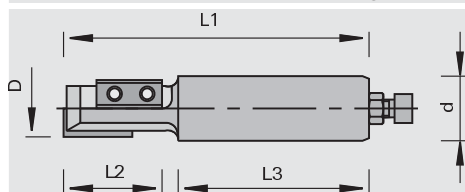
Only solid carbide cutters: shank design [no.] _____

Please indicate the following on workpiece samples or drawings:

- | | |
|--------------------------|------------------------|
| Bottom side of workpiece | Dimension |
| Sense of rotation | Application conditions |
| Motor spindle | Profile drawing |
| Workpiece support | Tool drawing |

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.



519-01.0708



Drill Bits

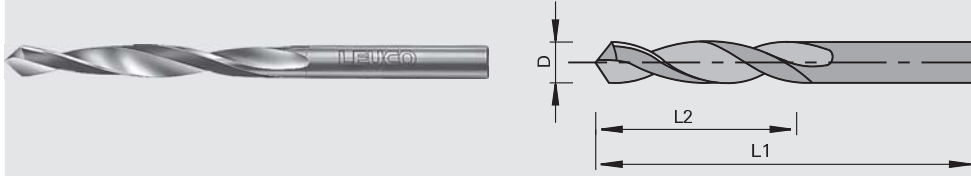
Product	Page
Twist Drills	5-1
Step Drills	5-4
Through-Hole Bits	5-5
Dowel Bits	5-12
Boring Spikes	5-25
Boring Countersink	5-26
Countersink Parts	5-27
Countersink Bits for Twist Drills	5-29
Cylinder Boring Bits	5-30
Technical Information	5-35

130010

Twist Drills with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through holes and dowel holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges
- | solid carbide design
- | cutting \varnothing = shank \varnothing
- | tip angle 120°

Advantages

- | high feed rates possible
- | large resharpenable area

Notes

- | clamping element: draw-in collet chuck, adapter Class-No. 933389, drill chuck

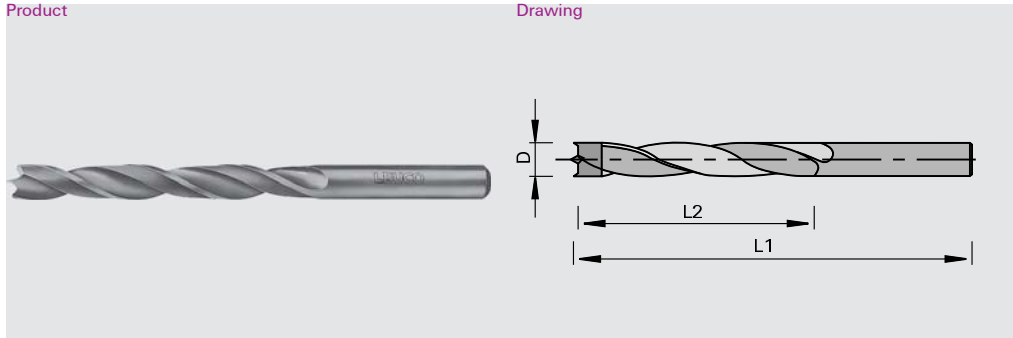
$\varnothing D$	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	25	50	182625	182626
2.5	27	55	182627	182628
3.0	27	55	182629	182630
3.5	27	52	182631	182632
4.0	27	55	182633	182634
5.0	28	60	182635	182636
[mm]	[mm]	[mm]		

130010

Twist Drills HW

Product

Drawing



LEUCO DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | centering point
- | cutting Ø = shank Ø
- | 2 negative spurs
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating
- | chip-free hole edges thanks to negative spurs

Notes

- | clamping element: draw-in collet chuck, drill chuck

Ø D	L2	L1	Ident-No. [L]	Ident-No. [R]
5.0	35	70	173145 o	167929
6.0	35	70		167930 o
7.0	35	70		167931 o
8.0	35	70	173148 o	167932 o
10	35	70	173150 o	167934 o
12	35	70		167936 o
4.0	55	80		160503
4.5	60	85		160504 o
5.0	60	90		160505
5.5	65	100		164243 o
6.0	65	100		160506
6.5	70	110		164244 o
7.0	70	110		160507 o
8.0	75	120		160508
8.5	80	130		164245 o
9.0	80	130		160509 o
10	90	140		160510
11	95	150		160511 o
12	100	155		160512
[mm]	[mm]	[mm]		



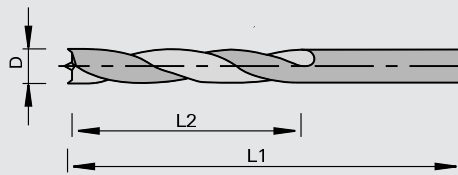
330010

Twist Drills HS

Product



Drawing



High Speed Steel [HS]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for drilling of dowel holes in solid woods

Design

- | 2 spurs
- | centering point
- | special coating
- | cutting \varnothing = shank \varnothing
- | HS design

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point
- | long edge lives thanks to special coating

Notes

- | clamping element: draw-in collet chuck, drill chuck

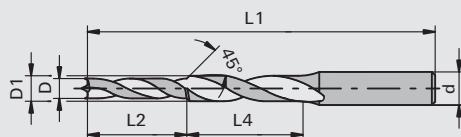
$\varnothing D$	L2	L1	Ident-No. [L]	Ident-No. [R]
2.0	22	49	167671	167669
2.5	25	57	167672	167670
3.0	30	61	160530	160518
3.5	35	70	160531 o	160519 o
4.0	40	75	160532	160520
4.5	45	80	160533 o	160521
5.0	45	83	160534	160522
5.5	50	90	160535 o	160523 o
6.0	50	90	160536 o	160524 o
6.5	55	98	177175 o	160525 o
7.0	60	105	177176 o	160526 o
7.5	60	105		177177 o
8.0	70	113	160539 o	160527
8.5	70	113		177178 o
9.0	75	120		160528 o
10	80	130		160529 o
[mm]	[mm]	[mm]		

330710

Step Drills HS for drill-in hinges

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for step-drillings for screw-in of drill-in hinges such as Anuba, Simons, etc

Design

- | 2 spurs
- | centering point
- | cylindrical shank without clamping surface
- | post-drill with countersink 45°
- | HS design

Advantages

- | safe drilling thanks to centering point

Notes

Hole diameter 1	Ø D	Ø D1	L4	L2	Ø d	L3	L1	Ident-No.
14,5	6.3	7.2	40	24	10	30	105	R 183092 o
16	6.7	7.7	35	30	10	30	105	R 183093 o
18	7.7	8.7	35	30	10	30	105	R 183094 o
20	8.8	9.8	35	30	10	30	105	R 183095 o
13/15	6	6.8	50	15	10	30	105	R 183096 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



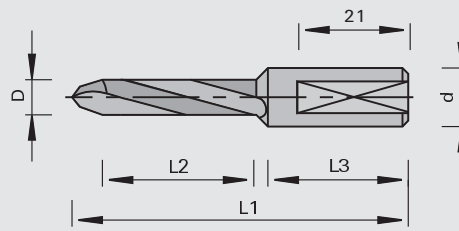
130012

Through-Hole Bits HW - Topline

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | cylindrical shank with clamping surface
- | new cutting geometry
- | HW-tipped

Advantages

- | increased edge lives compared to traditional through-hole bits thanks to special HW and special grinding
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | other dimensions possible with minimum quantities of 10 pieces; price and delivery time on request

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	25	10	25	57.5	177804	177805
8	25	10	25	57.5	177806	177807
5	30	10	30	70	178648	178649
8	30	10	30	70	178650	178651
[mm]	[mm]	[mm]	[mm]	[mm]		

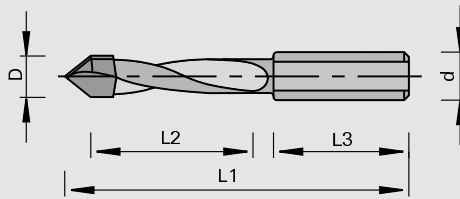
130013

Mosquito Through-Hole Bits HW

Product



Drawing



MOSQUITO

tungsten carbide [HW]

MAN

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- HW-plunging tip made from super-fine grain material

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- long edge lives thanks to HW plunging tip
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

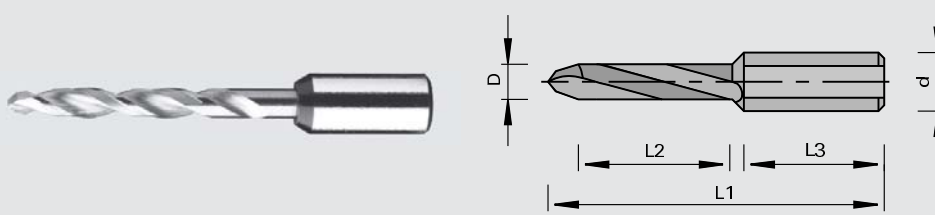
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	27	10	26	57.5	182458	182459
8	27	10	26	57.5	182460 o	182461 o
5	35	10	26	70	182462	182463
6	35	10	26	70	183689 o	183688 o
7	35	10	26	70	183691	183690
8	35	10	26	70	182464	182465
10	35	10	26	70	183693 o	183692 o
[mm]	[mm]	[mm]	[mm]	[mm]		

130013

Mosquito Through-Hole Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | chip-free hole edges thanks to special cutting edge geometry
- | high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- | through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3	27	10	30	70	183687	183686
4	40	10	22	70	183167	183166
5	40	10	22	70	183153	183152
6	40	10	22	70	183155 o	183154 o
8	40	10	22	70	183157	183156
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Ident-No. [R]
6	35	10	50	100	184289
[mm]	[mm]	[mm]	[mm]	[mm]	

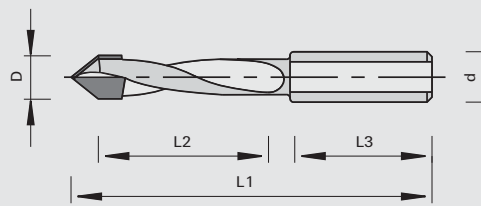
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130011

Ecoline Through-Hole Bits HW

Product

Drawing

LEUCO
ecolineLEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges with 60 degrees
- | cylindrical shank with clamping surface
- | spiral without back guide
- | plunging tip with carbide plate for reduced demands

Advantages

Notes

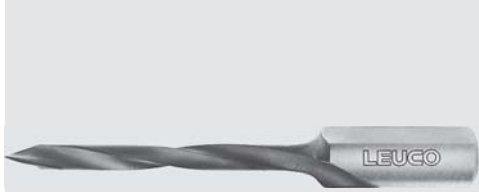
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	39	10	20	70	183389	183388
7	42	10	20	70	183391	183390
8	44	10	20	70	183393	183392
5	46	10	20	77	183395	183394
8	51	10	20	77	183397	183396
[mm]	[mm]	[mm]	[mm]	[mm]		

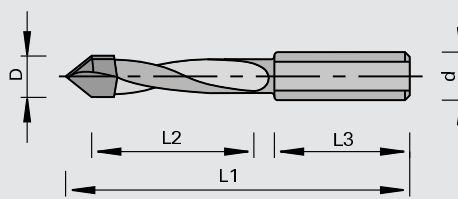
130015

Through-Hole Bits HW - without back-guide

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges (60 degree angle)
- | HW-tipped
- | cylindrical shank with clamping surface
- | spiral without back guide

Advantages

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

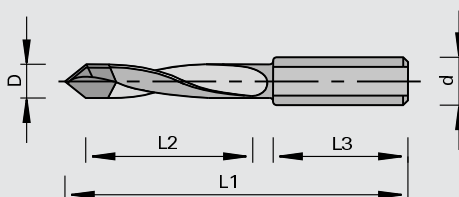
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4	27	10	25	57.5	182239 o	182240 o
5	25	10	25	57.5	055827	055823
5.1	25	10	25	57.5	176473 o	176472 o
6	25	10	25	57.5	176475	176474
7	27	10	25	57.5	182245 o	182246 o
8	22	10	25	57.5	055830	055826
3	27	10	25	70	182237 o	182238 o
4	35	10	25	70	182241	182242
5	35	10	25	70	176505	176504
5.5	35	10	25	70	182243 o	182244 o
6	35	10	25	70	176259	176258
7	35	10	25	70	181581	181582
8	35	10	25	70	176507	176506
10	35	10	25	70	182669 o	182670 o
11	35	10	25	70	182249 o	182250 o
5	45	10	25	77	176477	176476
6	45	10	25	77	176479	176478
7	45	10	25	77	182251 o	182252 o
8	43	10	25	77	176481	176480
9	42	10	25	77	182253 o	182254 o
10	42	10	25	77	176483	176482
11	40	10	25	77	182255 o	182256 o
12	40	10	25	77	176485	176484
[mm]	[mm]	[mm]	[mm]	[mm]		

130015

Through-Hole Bits HW - with back-guide

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through-holes in solid woods and wood-based panels

Design

- | 2 v-point cutting edges (60 degree angle)
- | HW-tipped
- | cylindrical shank with clamping surface
- | spiral with back-guide

Advantages

- | protection of the hole edge upon exiting thanks to spiral with back guide

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | clamping elements: combi chuck, quick-change chuck

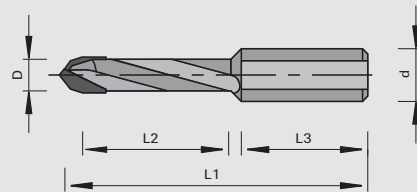
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	25	8	20	55.5	176497 o	176496 o
8	25	8	20	55.5	176499 o	176498 o
5	25	10	20	57.5	173604	173595
8	25	10	20	57.5	173611 o	173596 o
5	35	8	20	67	176501	176500
8	35	8	20	67	176503	176502
5	35	10	25	70	176255	176254
8	35	10	25	70	176257	176256
[mm]	[mm]	[mm]	[mm]	[mm]		

230012

Through-Hole Bits DP

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels and composite materials

Design

- | special cutting edge geometry, roof-shaped tip and double chamfer
- | spiral without back guide
- | DP-tipped

Advantages

- | long edge life when machining extremely abrasive materials
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
5	27	10	26	57.5	1	183015 s	183014 s
5	35	10	26	70	1	183017 s	183016 s
6	35	10	26	70	2	183019 s	183018 s
8	35	10	26	70	2	183021 s	183020 s
10	35	10	26	70	2	183049 s	183050 s
[mm]	[mm]	[mm]	[mm]	[mm]			

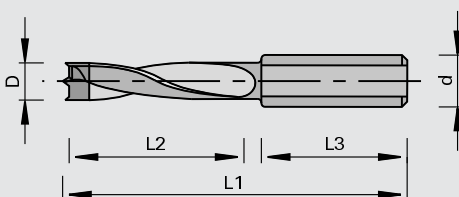
130215

Dowel Bits HW - with back-guide

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw: Ident-No. 001600 M5x10 DIN 551 for precise length adjustment
- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | clamping element: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4	30	8	19	55.5	166107 o	166106 o
5	30	8	19	55.5	011543	011542
6	30	8	19	55.5	054884	054883
8	30	8	19	55.5	054892	054891
10	30	8	19	55.5	054896	054895
12	30	8	20	55.5	166113 o	166112 o
4	40	8	19	67		167154 o
5	40	8	19	67	057494	057493
6	40	8	19	67	057496 o	057495
7	40	8	19	67	167167	167157
8	40	8	19	67	057498	057497
9	40	8	19	67	167169	167159
10	40	8	19	67	057500	057499
12	40	8	19	67	167172 o	167162 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	30	10	19	57.5	167184	167174
6	30	10	20	57.5	167185	167175
7	30	10	20	57.5	167186	167176
8	30	10	20	57.5	167187	167177
10	30	10	20	57.5	167188	167178
12	30	10	20	57.5	167189	167179
13	30	10	20	57.5	167190 o	167180
14	30	10	20	57.5	167191	167181
15	30	10	20	57.5	167192	167182
16	30	10	20	57.5	167193 o	167183 o
5	43	10	19	70	167203	167194
6	43	10	19	70	167204	167195
8	43	10	19	70	167205	167196
9	43	10	19	70	167206 o	167197
10	43	10	19	70	167207	167198
12	43	10	19	70	167208	167199
[mm]	[mm]	[mm]	[mm]	[mm]		

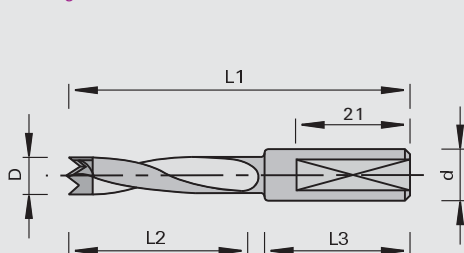
130212

Dowel Bits HW - Topline

Product



Drawing



LEUCO
topline

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | centering point
- | HW-tipped

Advantages

- | tool life increased up to tenfold compared to traditional dowel bits thanks to special HW and special grinding
- | chip-free hole edges thanks to special cutting edge geometry
- | safe drilling thanks to centering point

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | other dimensions possible with minimum quantities of 10 pieces; price and delivery time on request

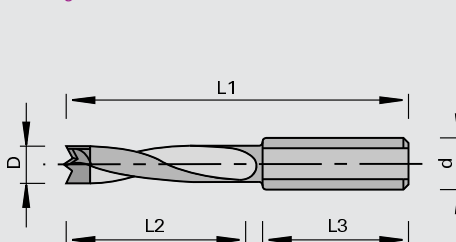
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	30	8	19	55.5	178695	178696
4	20	10	27	57.5	179464	179465
5	25	10	27	57.5	177792	177793
6	25	10	27	57.5	177794	177795
8	25	10	27	57.5	177796	177797
10	30	10	27	57.5	178789	178788
4	20	10	30	70	179466	179467
5	35	10	30	70	177798	177799
6	35	10	30	70	177800	177801
8	35	10	30	70	177802	177803
10	35	10	30	70	178703	178704
[mm]	[mm]	[mm]	[mm]	[mm]		

130213

Mosquito Dowel Bits HW

Product

Drawing



MOSQUITO

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | HW-tipped

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high process safety thanks to constant quality of the bores for a long time
- | tool life increased up to sixfold compared to traditional dowel bits thanks to wear-resistant HW plunging tip

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

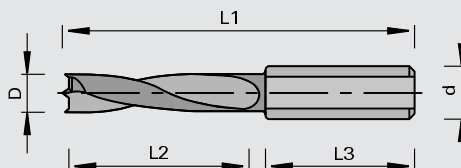
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	25	10	27	57.5	181168	181167
6	25	10	27	57.5	181522	181521
7	27	10	27	57.5	183159 o	183158 o
8	25	10	27	57.5	181170	181169
9	27	10	27	57.5	183161 o	183160 o
10	25	10	27	57.5	181524	181523
5	35	10	30	70	181172	181171
6	35	10	30	70	181526	181525
7	35	10	30	70	183163 o	183162 o
8	35	10	30	70	181174	181173
9	35	10	30	70	183165 o	183164 o
10	35	10	30	70	181528	181527
[mm]	[mm]	[mm]	[mm]	[mm]		

130213

Mosquito Dowel Bits with solid carbide body

Product

Drawing



MOSQUITO

Solid Tungsten Carbide

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | special cutting edge geometry
- | 2 spurs
- | centering point
- | boring part made from fine-grain solid tungsten carbide

Advantages

- | chip-free hole edges thanks to special cutting edge geometry with spurs
- | safe drilling thanks to centering point
- | high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- | high process safety thanks to constant quality of the bores for a long time

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 included in delivery
- | through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

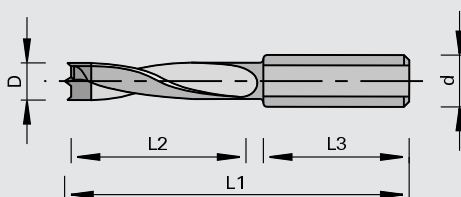
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
3	9	10	35	57.5	183143 o	183142 o
3	18	10	31	57.5	182380	182381
4	20	10	29	57.5	182382 o	182383 o
5	22	10	27	57.5	182384	182385
6	22	10	25	57.5	183145 o	183144 o
8	22	10	25	57.5	183147 o	183146 o
3	18	10	43.5	70	182386	182387
4	27	10	34.5	70	182388	182389
5	30	10	31.5	70	182390	182391
6	30	10	30	70	183149	183148
8	35	10	22	70	183151	183150
[mm]	[mm]	[mm]	[mm]	[mm]		

130215

Dowel Bits HW - with back-guide, long version

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | long cutting length
- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | HW-tipped

Advantages

- | deep holes thanks to long cutting length
- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- | shell countersink Class-No. 130660
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	50	10	30	85	177194	177193
5	65	10	30	105	177206 o	177205
6	50	10	30	85	177196 o	177195
6	65	10	30	105	177208 o	177207
7	50	10	30	85	177198	177197
7	65	10	30	105	177210	177209
8	50	10	30	85	177200	177199
8	65	10	30	105	177212	177211
10	50	10	30	85	177202	177201
10	65	10	30	105	177214	177213
12	50	10	30	85	177204	177203
12	65	10	30	105	177216 o	177215
[mm]	[mm]	[mm]	[mm]	[mm]		

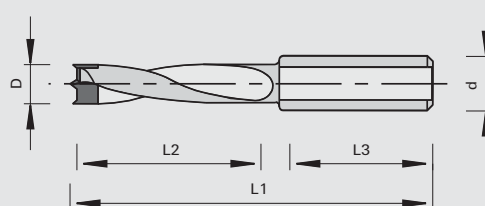
130211

Ecoline Dowel Bits HW

Product



Drawing



LEUCO
ecoline

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | plunging tip with carbide plate for reduced demands

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

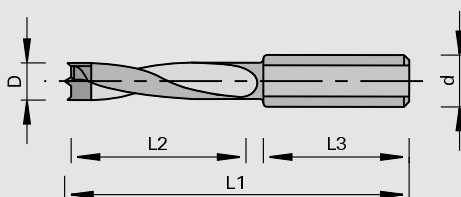
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	26	10	20	57.5	183375	183374
8	31	10	20	57.5	183377	183376
10	32	10	20	57.5	183379	183378
5	39	10	20	70	183381	183380
6	40	10	20	70	183383	183382
8	44	10	20	70	183385	183384
10	45	10	20	70	183387	183386
[mm]	[mm]	[mm]	[mm]	[mm]		

130217

Dowel Bits HW - without back-guide

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4.0	27	10	27	57.5	003175	003174
4.5	27	10	27	57.5	177228	177227
5.0	27	10	27	57.5	003179	003178
5.1	27	10	27	57.5	177230	177229
5.2	27	10	27	57.5	167707 o	167708 o
6.0	27	10	27	57.5	003183	003182
7.0	27	10	27	57.5	003187	003186
8.0	27	10	27	57.5	003191	003190
8.2	27	10	27	57.5	167216	167213
9.0	27	10	27	57.5	003195	003194
10.0	27	10	27	57.5	003199	003198
10.5	27	10	27	57.5	182261 o	182262 o
11.0	27	10	27	57.5	177232 o	177231
12.0	27	10	27	57.5	003207	003206
4.0	35	10	30	70	173175	173174
4.5	35	10	30	70	182263 o	182264 o
5.0	35	10	30	70	003231	003230
5.1	35	10	30	70	182265 o	182266 o
5.5	35	10	30	70	182267	182268 o
6.0	35	10	30	70	003235	003234
6.5	35	10	30	70	182269 o	182270 o
7.0	35	10	30	70	167224	167219
7.5	35	10	30	70	182271 o	182272 o
8.0	35	10	30	70	003243	003242
8.1	35	10	30	70	182273 o	182274 o
8.2	35	10	30	70	182275	182276 o
8.5	35	10	30	70	182277 o	182278 o
9.0	35	10	30	70	167225	167220
10.0	35	10	30	70	003251	003250
10.2	35	10	30	70	182279 o	182280 o
11.0	35	10	30	70	167226	167221
12.0	35	10	30	70	167227	167222
13	35	10	30	70	183042	183043
14	35	10	30	70	183044	183045
16	35	10	30	70	183046	183047
5.0	44	10	30	77	167233	167228
6.0	44	10	30	77	167234	167229
[mm]	[mm]	[mm]	[mm]	[mm]		

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
8.0	44	10	30	77	167235	167230
10.0	44	10	30	77	167236	167231
12.0	44	10	30	77	173181	173180
[mm]	[mm]	[mm]	[mm]	[mm]		

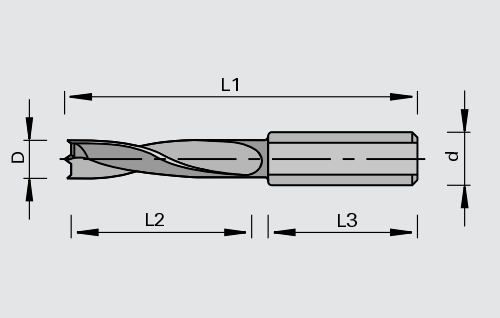
330215

Dowel Bits HS - with back-guide

Product



Drawing



High Speed Steel [HS]
MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for drilling of dowel holes in solid woods

Design

- | 2 spurs
- | centering point
- | spiral with back-guide
- | HS design

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point
- | protection of the hole edge upon exiting thanks to spiral with back guide

Notes

- | clamping element: combi chuck, quick-change chuck

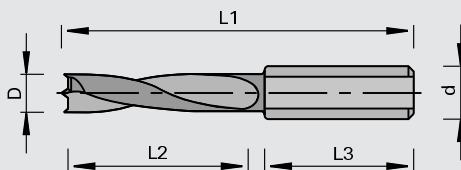
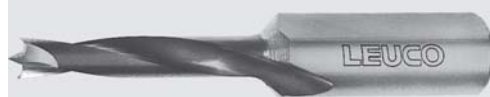
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
4	30	10	20	57.5	177234 o	177233 o
5	30	10	20	57.5	177236 o	177235 o
6	30	10	20	57.5	177238 o	177237 o
8	30	10	20	57.5	177240 o	177239 o
10	30	10	20	57.5	177242 o	177241 o
5	43	10	20	70	177246	177245
6	43	10	20	70	160479 o	177247 o
7	43	10	20	70	177250 o	177249 o
8	43	10	20	70	177248	160475 o
10	43	10	20	70	177252 o	177251 o
12	43	10	20	70	177254 o	177253 o
14	43	10	20	70	177256 o	177255 o
16	43	10	20	70	177258 o	177257 o
[mm]	[mm]	[mm]	[mm]	[mm]		

330215

Dowel Bits HS - without back-guide

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for drilling of dowel holes in solid woods

Design

- | 2 spurs
- | centering point
- | spiral without back guide
- | HS design

Advantages

- | chip-free hole edges thanks to spurs
- | safe drilling thanks to centering point

Notes

- | clamping element: combi chuck, quick-change chuck

Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	45	10	30	85	177260 o	177259 o
6	45	10	30	85		177261 o
8	45	10	30	85	177266 o	177265 o
10	45	10	30	85	177268 o	177267 o
12	45	10	30	85	177270 o	177269 o
6	65	10	30	105	177274 o	177273 o
8	65	10	30	105		177277 o
10	65	10	30	105	177280 o	177279 o
12	65	10	30	105	177282 o	177281 o
[mm]	[mm]	[mm]	[mm]	[mm]		

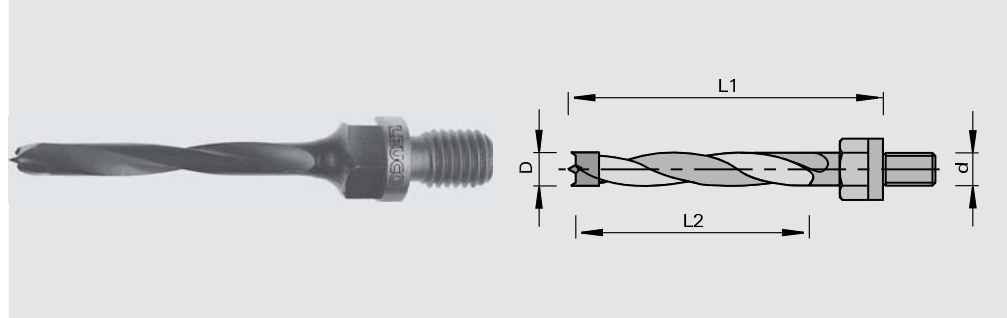


130226

Dowel Bits HS - without back-guide, with threaded shank

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral without back guide
- | plastic coated
- | threaded shank
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating
- | high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- | for coordination with machines see section Clamping Systems

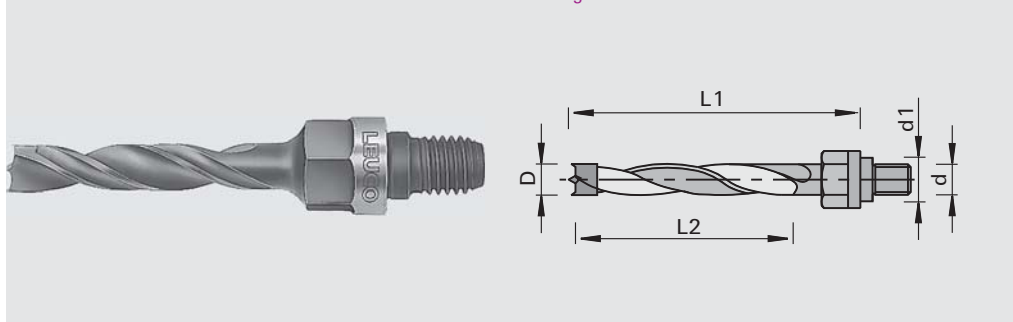
Ø D	L2	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5	45	M8	63	160570 o	160566 o
5	45	M10	63	167697	167698
6	45	M10	63	160576 o	160574 o
8	45	M8	63	160572 o	160568 o
8	45	M10	63	160577	160575
10	45	M10	63	167699 o	167700 o
12	45	M8	63	167691 o	167692 o
12	45	M10	63	167701 o	167702 o
[mm]	[mm]	[mm]	[mm]		

130226

Dowel Bits HS - with back-guide and threaded shank

Product

Drawing



**LEUCO
DUR**

tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- | 2 negative spurs
- | centering point
- | spiral with back-guide
- | plastic coated
- | shank with thread and passfit
- | HW-tipped

Advantages

- | chip-free hole edges thanks to negative spurs
- | safe drilling thanks to centering point
- | optimum chip evacuation thanks to plastic coating
- | high stability thanks to threaded shank for direct clamping onto the boring spindle

Notes

- | for coordination with machines see section Clamping Systems

Ø D	L2	Ø d1	Ø d	L1	Ident-No. [L]	Ident-No. [R]
5	45	11	M10	63	167703 o	167704 o
6	45	11	M10	63	167705 o	167706 o
8	45	11	M10	63	160584	160582
10	45	11	M10	63	160585 o	160583 o
[mm]	[mm]	[mm]	[mm]	[mm]		

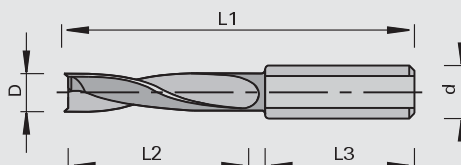


130214

High-Performance Dowel Bits with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | stationary boring machines
- | automatic boring machines
- | CNC machining centers
- | for drilling of through holes and dowel holes in solid woods, wood-based panels and composite materials

Design

- | special cutting edge geometry
- | 2 spurs
- | spiral with back-guide
- | boring part made from solid tungsten carbide

Advantages

- | special tooth geometry and spurs for minimal cutting force and cutting pressure
- | protection of the hole edge upon exiting thanks to spiral with back guide
- | high feed rates and large resharpenable area thanks to solid carbide bit

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck
- | tooth geometry applied for patent
- | change of grinding or reduction of diameter ist not possible

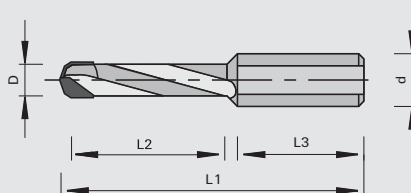
Ø D	L2	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
5	32	10	22	57.5	182815	182814
8	32	10	22	57.5	182819	182818
5	36	10	30	70	182825	182824
6	36	10	30	70	182827	182826
8	36	10	30	70	182829	182828
10	36	10	30	70	184754	184753
[mm]	[mm]	[mm]	[mm]	[mm]		

230215

Dowel Bits DP

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels and composite materials

Design

- | special cutting edge geometry, 2 DP rakers which form a double chamfer
- | spiral without back guide
- | DP-tipped

Advantages

- | long edge life when machining extremely abrasive materials
- | chip-free hole edges thanks to special cutting edge geometry

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-change chuck

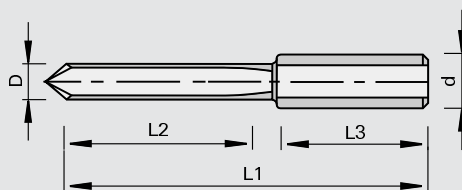
Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
5	27	10	26	57.5	2	183005 s	183004 s
6	27	10	26	57.5	2	183007 s	183006 s
8	27	10	26	57.5	2	183009 s	183008 s
5	35	10	30	70	2	183011 s	183010 s
6	35	10	30	70	2	183051 s	183052 s
8	35	10	30	70	2	183013 s	183012 s
10	35	10	30	70	2	183053 s	183054 s
[mm]	[mm]	[mm]	[mm]	[mm]			

130010

Boring spikes with solid carbide body

Product

Drawing



Solid Tungsten Carbide

MAN

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for drilling of dowel holes in wood-based panels

Design

- | cylindrical shank $\varnothing 10$ mm with clamping surface and adjusting screw
- | solid carbide design

Advantages

- | large resharpenable area
- | long edge lives

Notes

- | for clockwise and counter-clockwise rotation
- | clamping element: combi chuck, quick-clamping chuck

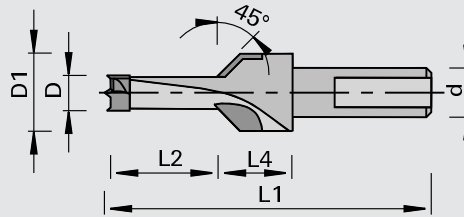
$\varnothing D$	L2	$\varnothing d$	L3	L1	Ident-No.
2.0	12	2,0		38	183059 o
2.5	12	2,5		45	180942
3	12	3		45	180943
3.5	15	3,5		45	183060 o
4	12	4		45	180944 o
2.5	15	10	33	57.5	183061 o
3	15	10	33	57.5	183062 o
5	25	10	25	57.5	180945 o
3.5	30	10	24	70	183063 o
4	32	10	25	70	183064 o
5	35	10	25	70	180946 o
[mm]	[mm]	[mm]	[mm]	[mm]	

130710

Boring Countersink HW

Product

Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | portable boring machines
- | automatic boring machines
- | for drilling and countersinking in solid woods and wood-based panels

Design

- | spiral PTFE coated
- | 2 spurs
- | centering point

Advantages

- | for drilling and countersinking in one pass
- | safe drilling thanks to centering point

Notes

- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	L2	Ø D1	L4	Ø d	L1	Ident-No. [L]	Ident-No. [R]
8	12	16	15	10	57.5	180847	180846
8	15	16	15	10	57.5	180849	180848
10	12	16	15	10	57.5	180853	180852
10	15	16	15	10	57.5	180855 o	180854 o
8	12	16	15	10	70	180859	180858
8	15	16	15	10	70	180861 o	180860 o
8	20	16	15	10	70	180863	180862
10	12	16	15	10	70	180865	180864
10	15	16	15	10	70	180867 o	180866 o
10	20	16	15	10	70	180869 o	180868 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

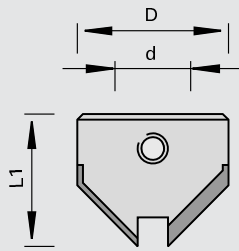
130660

Countersink Parts HW to be mounted on Twist Drills and Dowel Bits

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on twist drills and dowel bits with back-guide on the drill spiral with set screw
- continuous adjustment of the countersink diameter and the boring depth

$\varnothing D$	$\varnothing d$	L1	Ident-No. [L]	Ident-No. [R]
15.5	3	17.5		177291
16	4	15	183811 o	183812
16	5	15	183174	183175
16	6	15	183176	183177
16	7	15	183178	183179
18	8	15	183180	183181
18	9	15	183813 o	183814 o
20	10	15	183182	183183
20	12	15	183815 o	183816
[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Set Screws

M6x4 DIN EN ISO 4029

995161

167068

Cranked Wrench Keys

SW3 DIN ISO 2936

985730

009672

[mm]

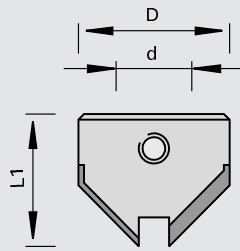
130660

Countersink Parts HW to be mounted on Dowel Bits

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on elongated shank of dowel bits \varnothing 5 - 12 mm with setscrew
- continuous adjustment of the countersink diameter and the boring depth

\varnothing D	\varnothing d	L1	Ident-No. [L]	Ident-No. [R]
15.5	10	16.5	177294	177293
20	10	16	183184	183185
22	10	16.5		177295
[mm]	[mm]	[mm]		

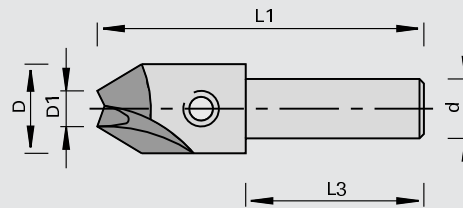
Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Set Screws	M6x4 DIN EN ISO 4029	169312, 177293	995161	167068
Set Screws	M6x5 DIN EN ISO 4029	177295	995161	165049
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
	[mm]			

130660

Countersink Bits HW for Twist Drills

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

MAN

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for mounting of twist drills with \varnothing 3 - 6 mm
- continuous adjustment of the countersink diameter and the boring depth

\varnothing D	\varnothing D1	\varnothing d	L3	L1		Ident-No.
15	3.0	10	30	58	R	173190
15	3.0	10	30	58	L	173191 o
15	3.5	10	30	58	R	173192
15	4.0	10	30	58	R	173194
15	4.0	10	30	58	L	173195
15	4.5	10	30	58	R	173196
15	4.5	10	30	58	L	173197 o
15	5.0	10	30	58	R	173198
15	5.0	10	30	58	L	173199
15	6.0	10	30	58	R	173202 o
15	6.0	10	30	58	L	173203 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Set Screws

M6x6 DIN EN ISO 4029
[mm]

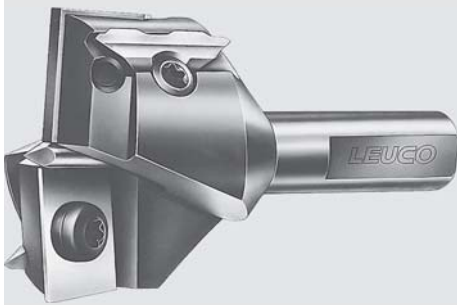
995161

180003

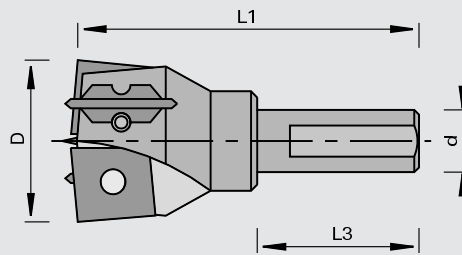
130135

Cylinder Boring Bits with HW Turnover Knives

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 turnover spurs and centering point

Advantages

- | long edge lives thanks to wear-resistant HW grade
- | chip-free hardware hinge holes thanks to scoring cut of the turnover spurs

Notes

- | replaceable and adjustable centering point
- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5		162612
26	10	26	57.5		162614
30	10	26	57.5		162616 #
35	10	26	57.5	162619	162618
25	10	26	70		182570
26	10	26	70		182571 #
30	10	26	70		182572 #
35	10	26	70		182573
[mm]	[mm]	[mm]	[mm]		

Turnover Knives	Dimension	For Ident-No.	Class-No.	Ident-No.
Turnover Knives	10,5x12x1,5	162612, 182570	150515	162636
Turnover Knives	11x12x1,5	162614, 162615, 182571	150515	162637
Turnover Knives	13x12x1,5	162616, 182572	150515	162638
Turnover Knives	15,7x12x1,5	162618, 162619, 182573	150515	163846
Spurs	18x6x3,5		150558	181263
Centering Points	3x33,5 [mm]		165512	162624

Spare parts	Dimension	For Ident-No.	Class-No.	Ident-No.
Set Screws	M6x6 DIN EN ISO 4028		995161	163841
Countersunk Flat Headed Screws	M3,5x6 T15	162614, 162615, 162616, 162618, 162619, 182571, 182572, 182573	995125	162648
Countersunk Flat Headed Screws	M3,5x5,5 T15	162612, 182570	995125	162649
Head Cap Screws	M3,5x3,8 T15 [mm]		995115	162645

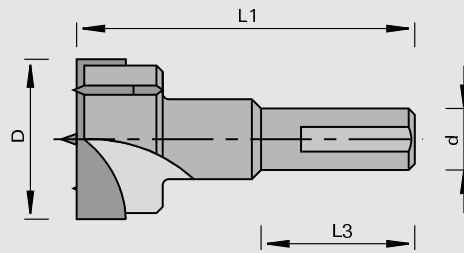
130117

Cylinder Boring with HW - Z=2+2

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- | 2 rakers, 2 spurs and centering point
- | HW-tipped

Advantages

- | chip-free holes thanks to scoring cut of the spurs

Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	003303	003302
16	10	26	57.5	003305	003304
18	10	26	57.5	003309	003308
20	10	26	57.5	003313	003312
22	10	26	57.5	003315	003314
25	10	26	57.5	003319	003318
26	10	26	57.5	003321	003320
30	10	26	57.5	003327	003326
35	10	26	57.5	003333	003332
40	10	26	57.5	003337	003336
15	10	26	70	178978	172250
18	10	26	70	178983	178984
20	10	26	70	178979	172251
22	10	26	70	182257	182258
25	10	26	70	178980	172252
26	10	26	70	182374	182375
30	10	26	70	178981	172253
35	10	26	70	178982	172254
40	10	26	70	182259	182260
[mm]	[mm]	[mm]	[mm]		

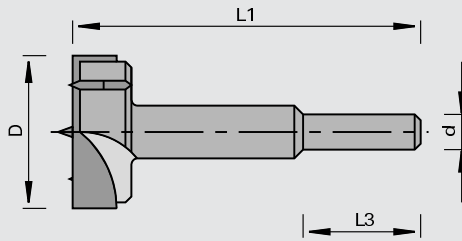
130119

Cylinder Boring with HW - portable boring machines

Product



Drawing



tungsten carbide [HW]
MAN

Machine / Application

| portable boring machines
| for chip-free drilling in solid woods and wood-based panels

Design

| 2 rakers, 2 spurs and centering point
| HW-tipped
| Ø 12: spurs in rakers
| cylindrical shank

Advantages

| chip-free holes thanks to scoring cut of the spurs

Notes

| diameter of the cylindrical shank is adapted to the cutting pressure
| clamping elements: drill chuck

Ø D	Ø d	L3	L1	Ident-No.
12	10	62	90	173204 o
14	10	60	90	167685
15	10	60	90	160424
16	10	60	90	160425
17	10	60	90	167686
18	10	60	90	160426
19	10	60	90	167687
20	10	60	90	160427
21	10	60	90	173205
22	10	60	90	160428
23	10	60	90	167688
24	10	60	90	160429
25	10	60	90	160430
26	10	60	90	160431
27	10	74	90	173206 o
28	10	60	90	160432
30	10	60	90	160433
32	10	60	90	160434
34	10	74	90	167689 o
35	10	60	90	160435
36	10	30	90	160436 o
38	10	60	90	160437 o
40	10	60	90	160438
42	10	30	90	167690 o
45	10	60	90	173207
50	10	60	90	173208
[mm]	[mm]	[mm]	[mm]	

Ø D	Ø d	L3	L1	Ident-No.
15	13	108	140	173210 o
16	13	108	140	173211 o
18	13	107	140	160388 o
20	13	105	140	160389 o
22	13	105	140	160390 o
24	13	105	140	173212 o
25	13	103	140	160392 o
26	13	103	140	160393 o
28	13	103	140	160394 o
30	13	103	140	160395 o
32	16	103	140	160396 o
34	16	103	140	173213 o
35	16	103	140	160398 o
[mm]	[mm]	[mm]	[mm]	

Ø D	Ø d	L3	L1	Ident-No.
38	16	103	140	173215 o
40	16	103	140	160401 o
42	16	120	140	160402 o
44	16	120	140	173216 o
45	16	120	140	180742 o
46	16	120	140	173217 o
48	16	120	140	173218 o
50	16	118	140	160407 o
52	16	118	140	160408 o
54	16	118	140	173219 o
55	16	118	140	160409 o
56	16	118	140	173220 o
58	16	118	140	173221 o
60	16	50	140	160410 o
63	16	50	140	173228 o
65	16	50	140	160411 o
68	16	50	140	173222 o
70	16	50	140	160412 o
75	20	115	140	173223 o
80	20	115	140	160414 o
90	20	115	140	173225 o
[mm]	[mm]	[mm]	[mm]	

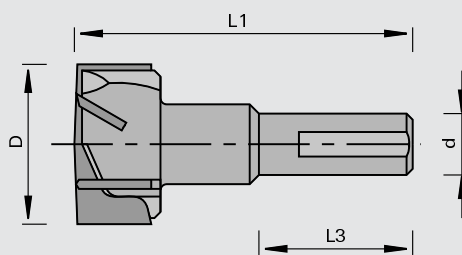
130115

Cylinder Boring with HW - Z=3+3

Product



Drawing



tungsten carbide [HW]

MAN

Machine / Application

- | hardware hinge machines
- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in solid woods and wood-based panels

Design

- | 3 rakers, 3 spurs, without centering point
- | HW-tipped

Advantages

- | boring depths close to the bottom-side laminate
- | chip-free holes thanks to scoring cut of the spurs
- | high feed rates thanks to Z = 3+3

Notes

- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

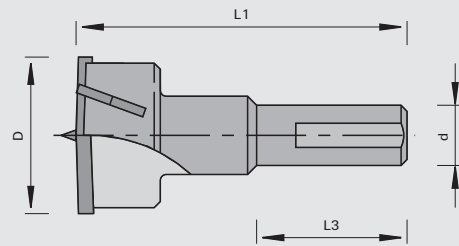
Ø D	Ø d	L3	L1	Ident-No. [L]	Ident-No. [R]
25	10	26	57.5	160385	160384
26	10	26	57.5		003278
30	10	26	57.5		003280
35	10	26	57.5	003285	003284
40	10	26	57.5		713347 o
[mm]	[mm]	[mm]	[mm]		

230115

Cylinder Boring Bits DP

Product

Drawing



polycrystalline diamond [DP]

MEC

Machine / Application

- | automatic boring machines
- | CNC machining centers
- | for chip-free drilling in raw and laminated panels

Design

- | 2 DP rakers, 2 DP spurs
- | HW Centering point
- | resharpenable several times

Advantages

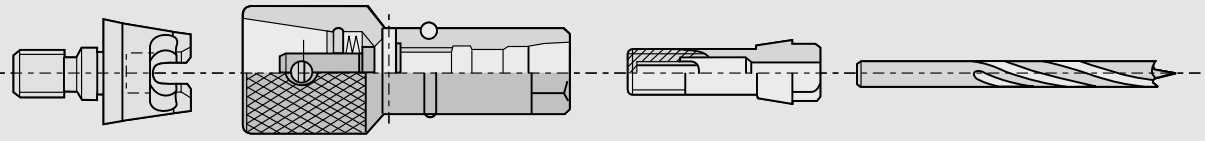
- | long edge life when machining abrasive materials
- | economic efficiency thanks to possibility to resharpen several times
- | chip-free holes thanks to scoring cut of the spurs
- | safe drilling thanks to centering point

Notes

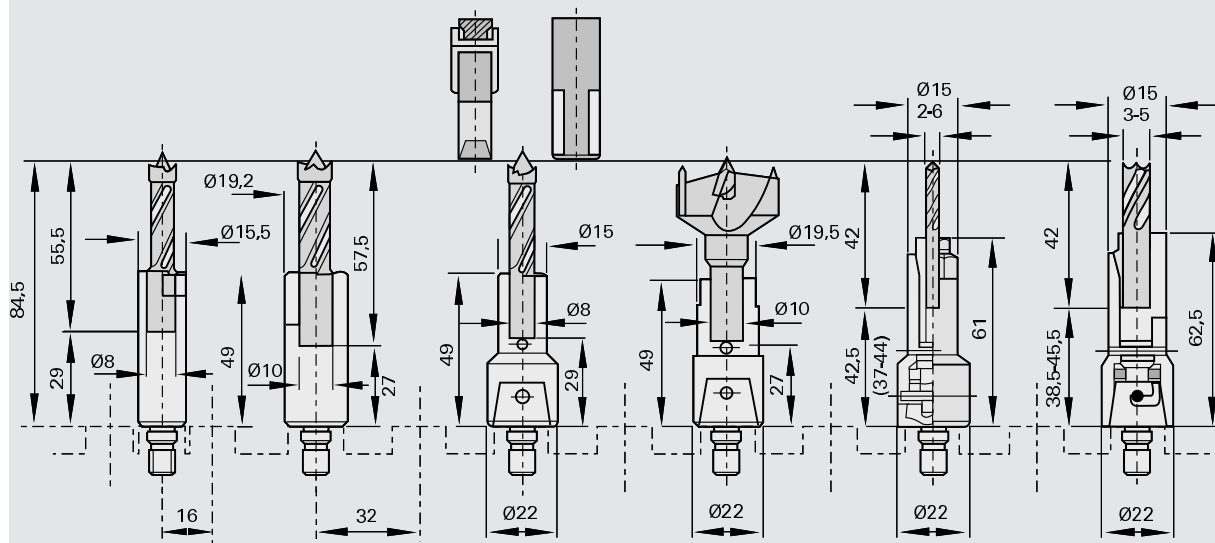
- | cylindrical shank with clamping surface
- | adjusting screw Ident-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- | adjusting screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- | clamping elements: combi chuck, quick-clamping chuck

Ø D	Ø d	L3	L1	Z	Ident-No. [L]	Ident-No. [R]
15	10	26	57.5	2+2	182995 s	182994 s
20	10	26	57.5	2+2	182997 s	182996 s
25	10	26	57.5	2+2	182999 s	182998 s
30	10	26	57.5	2+2	183001 s	183000 s
35	10	26	57.5	2+2	183048 s	183002 s
[mm]	[mm]	[mm]	[mm]			

Quick-Change Systems for Boring Bits



Features	Advantages	Benefit
<ul style="list-style-type: none"> precise tapered adapter 	<ul style="list-style-type: none"> precise radial running accuracy of the boring bit 	<ul style="list-style-type: none"> improved product quality
<ul style="list-style-type: none"> tight connection 	<ul style="list-style-type: none"> tight connection between boring bit and machine 	<ul style="list-style-type: none"> safe operation
<ul style="list-style-type: none"> simple locking 	<ul style="list-style-type: none"> quick change of the boring bit 	<ul style="list-style-type: none"> short downtimes
<ul style="list-style-type: none"> color-coded top part to mark the direction of rotation 	<ul style="list-style-type: none"> quick and easy recognition of the direction of rotation 	<ul style="list-style-type: none"> no high demands on the machine operators
<ul style="list-style-type: none"> compatible with old "Klack" and combi chuck 	<ul style="list-style-type: none"> upgrading and partial equipping of existing machines possible 	<ul style="list-style-type: none"> low cost



Order / Inquiry for Special Tools: Drill Bits / Plunge Cutters

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

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

Machine

Make: _____

Model: _____

Type: _____

Operating RPM [min-1]: _____

Feed rate [m/min]: _____

Workpiece material

Description: _____

Through hole:

Blind hole:

Boring depth [mm]: _____

Coating

Yes No

Description: _____

Further Information _____

Product line

Topline

Standard

Cutting material

Carbide

Diamond

HS

Tool

Twist Drills

Through-Hole Bits

Dowel Bits

Shell countersink

Countersink for twist drill bits

Cylinder boring bit

Brazed

With turnover knives

Bore diameter D [mm]: _____

Effective length L2 [mm]: _____

Overall length L1 [mm]: _____

Shank length L3 [mm]: _____

Shank design d:

 Cylindrical shank [Ø]: _____

 Other shank types: _____

 Type (per enclosure): _____

No. of cutting edges: _____

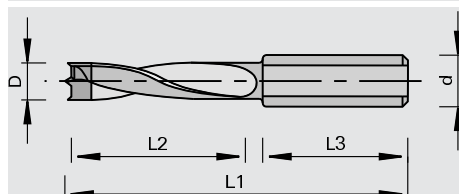
Rakers: _____

Spur: _____

Sense of rotation: Right Left

o check if applicable

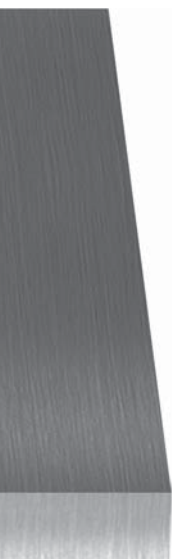
Please indicate additional dimension and markings in the tool drawing.



520-01.0708



Turnover Knives, Profile Knives, Knives

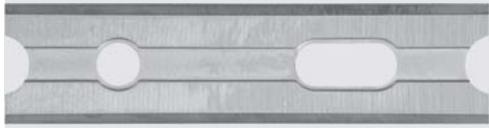


Product	Page
Turnover Knives, Profile Knives	6-1
Turnover Spurs	6-11
Turnover Knives	6-13
centering point	6-22
Mini Turnover Knives	6-23
Portable Planer Turnover Knives	6-25
Radius and Chamfering Turnover Knives / Profile Knives	6-26
Profile Knives / Turnover Knives	6-34
Profile Turnover Knives	6-43
Scraper Turnover Knives / Knives	6-46
Cup Knives	6-57
Saw Teeth	6-58
Planing Knives	6-59
Blanks	6-65

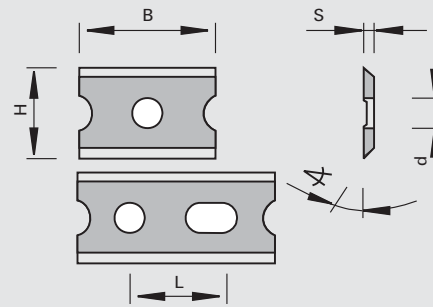
150516

EcoKnife Turnover Knives HW with 2 cutting edges

Product



Drawing



tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

- | cutting material: HW
- | HL Board 06
- | less HW raw material charge

- | long edge lives and optimum cutting quality in wood materials, plastics, hard and soft woods
- | turnover knife with less weight
- | less unbalance

- | packing unit: 10 pieces

B	H	S	Ø d	L	Wedge	Ident-No.
20	12	1.5	4		55	183569
30	12	1.5	4	11-14	55	183570
50	12	1.5	4	20-26	55	183571
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

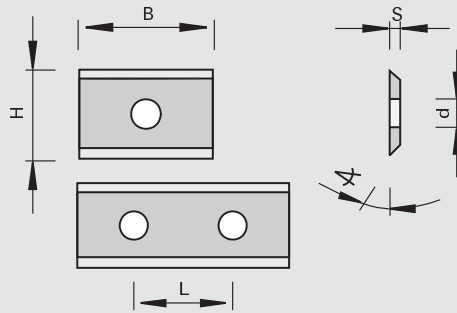
150511 / 150512 / 150515 / 150516 / 150518 / 150718

Turnover Knives HW with 2 cutting edges

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

Design

- | Topline (polished face and micro-ground clearance angle)
- | cutting material: HW
- | HW HL Board 01 for wood-based panels and plastics
- | HW HL Board 02 for wood-based panels and plastics
- | HL Board 06 for wood-based panels, plastics, hard and soft woods
- | HL Board 05 for wood-based panels, plastics and hard woods
- | HL Solid 25 for hard and soft woods
- | HL Solid 25 Topline for hard and soft woods

Advantages

- | long edge lives and optimum cutting quality in solid woods

Notes

- | packing unit: 10 pieces

B	H	S	Ø d	L	Wedge◊	LEUCODUR	Ident-No.
7,6	12	1.5	4		55	HL Board 05	052543
7,5	12	1.5	4		45	HL Solid 25	173473 o
9,6	12	1.5	4		55	HL Board 05	171163
10,5	12	1.5	4		55	HL Board 05	162636
11	12	1.5	4		55	HL Board 05	162637
13	12	1.5	4		55	HL Board 05	162638
15	12	1.5	4		55	HL Board 05	003081
15	12	1.5	4		45	HL Solid 25	173467 o
15,7	12	1.5	4		55	HL Board 05	163846
17	12	1.5	4		55	HL Board 05	162639
18	12	1.5	4		55	HL Board 05	162520
19	12	1.5	4		55	HL Board 05	164242
20	12	1.5	4		55	HL Board 01	180222
20	12	1.5	4		55	HL Board 02	176469
20	12	1.5	4		55	HL Board 06	178287
20	12	1.5	4		55	HL Board 05	003082
20	12	1.5	4		45	HL Solid 25	173468 o
20	12	1.5	4		45	HL Solid 25 Topline	176265
30	12	1.5	4	14	55	HL Board 01	180223
30	12	1.5	4	14	55	HL Board 02	176470
30	12	1.5	4	14	55	HL Board 06	178288
30	12	1.5	4	14	55	HL Board 05	003083
30	12	1.5	4	14	45	HL Solid 25	173469 o
30	12	1.5	4	14	45	HL Solid 25 Topline	176266
40	12	1.5	4	26	55	HL Board 02	182191 o
40	12	1.5	4	26	55	HL Board 05	164078
40	12	1.5	4	26	45	HL Solid 25	173470 o
40	12	1.5	4	26	45	HL Solid 25 Topline	176267
50	12	1.5	4	26	55	HL Board 01	180224
50	12	1.5	4	26	55	HL Board 02	176471
50	12	1.5	4	26	55	HL Board 06	178289
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge∠	LEUCODUR	Ident-No.
50	12	1.5	4	26	55	HL Board 05	003085
50	12	1.5	4	26	45	HL Solid 25 Topline	176268
60	12	1.5	4	26	55	HL Board 05	003086
60	12	1.5	4	26	45	HL Solid 25	173472 o
60	12	1.5	4	26	45	HL Solid 25 Topline	176269
80	13	2.2	4	59-61	55	HL Board 06	003087
80	13	2.2	4	59-61	45	HL Solid 25 Topline	181677
100	13	2.2	4	59-61	55	HL Board 06	003088
120	13	2.2	4	59-61	55	HL Board 06	003089
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

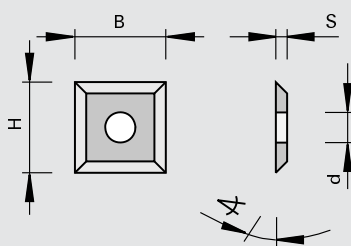
150513 / 150515 150518 / 150718

Turnover Knives HW with 4 cutting edges

Product



Drawing



tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

- | Topline (polished face and micro-ground clearance angle)
- | cutting material: HW
- | HL Board 03 for wood-based panels and plastics
- | HL Board 05 for wood-based panels, plastics and hard woods
- | HL Solid 25 Topline for hard and soft woods
- | HL Solid 30 for hard and soft woods

- | long edge lives and optimum cutting quality in solid woods

- | packing unit: 10 pieces

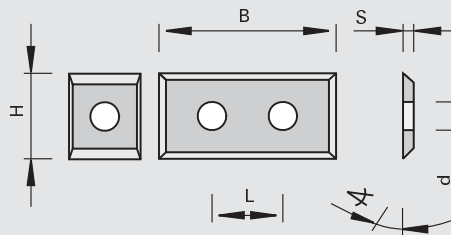
B	H	S	Ø d	Wedge∠	LEUCODUR	Ident-No.
10,5	10,5	1.5	4	55	HL Solid 30	162316
12	12	1.5	4	55	HL Board 03	180820
12	12	1.5	4	55	HL Board 05	003080
12	12	1.5	4	45	HL Solid 25 Topline	176340
17	17	2	4	55	HL Board 05	Weinig 162581
19	19	2	4	55	HL Board 05	162582
[mm]	[mm]	[mm]	[mm]	[°]		

150513 / 150515

Turnover Knives HW with 2 cutting edges, end sharpened

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in shank-type cutters

Design

| cutting material: HW
 | HL Board 02 for wood-based panels and plastics
 | HL Board 03 for wood-based panels and plastics
 | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces

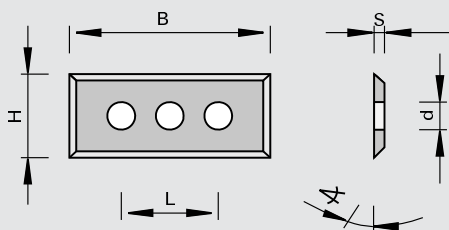
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
17,5	7	1.5			55	HL Board 05	184257
29,5	7	1.5	3,3	14	55	HL Board 05	184258
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
29,5	9	1.5	4	14	55	HL Board 03	180807
29,5	9	1.5	4	14	55	HL Board 05	180821
39,5	9	1.5	4	26	55	HL Board 05	180815
49,5	9	1.5	4	26	55	HL Board 03	180808
49,5	9	1.5	4	26	55	HL Board 05	180806
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
9	12	1.5	4		55	HL Board 05	167256
10	12	1.5	4		55	HL Board 05	165914
19,5	12	1.5	4		55	HL Board 05	183777
29,5	12	1.5	4	14	55	HL Board 02	181160
29,5	12	1.5	4	14	55	HL Board 05	180825
39,5	12	1.5	4	26	55	HL Board 05	171149
49,5	12	1.5	4	26	55	HL Board 05	180826
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150516 / 150513

Turnover Knives HW with 2 cutting edges, end sharpened - 3 holes

Product

Drawing



tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

- | cutting material: HW
- | HL Board 06 for wood-based panels, plastics and hard woods
- | HW HL Board 03 for wood-based panels and plastics

| packing unit: 10 pieces

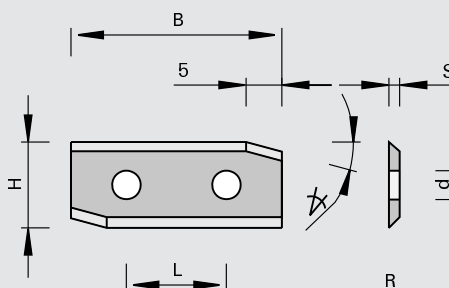
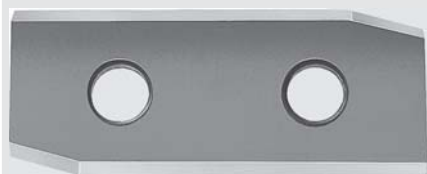
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
50	9	1.5	3,7	37	55	HL Board 03	181982
50	12	1.7	4	37	55	HL Board 06	179994
50	12	1.7	4	37	55	HL Board 03	182456
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150515

Turnover Knives HW with 2 cutting edges and chamfer - HolzHer

Product

Drawing



tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

- | machines HOLZ-HER
- | for use in edge banding / jointing cutterheads

- | grinding angle 55 degrees
- | cutting material: HW
- | HL Board 06 for wood-based panels, plastics and hard woods

| packing unit: 10 pieces

Chamfer	B	H	S	Ø d	L	Ident-No. [L]	Ident-No. [R]
15	29,5	12	1.5	4	14	160118	160618
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		

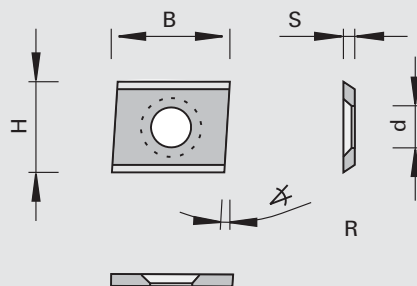
150518

Turnover Knives HW with 2 cutting edges, edge bevel - Brandt, Ott

Product



Drawing



tungsten carbide [HW]

Machine / Application

- | machines Brandt, Ott
- | Brandt: for use in grooving cutterheads and prism cutterheads or as flat scraper
- | Ott: for the use as flat scraper

Design

- | grinding angle 55 degrees
- | cutting material: HW
- | HL Solid 25 for hard and soft woods

Advantages

Notes

- | packing unit: 10 pieces

B	H	S	Ø d	Clearance \sphericalangle 1	Ident-No. [L]	Ident-No. [R]
15,0	14,3	2,5	6,3	6	184263	184262
[mm]	[mm]	[mm]	[mm]	[°]		

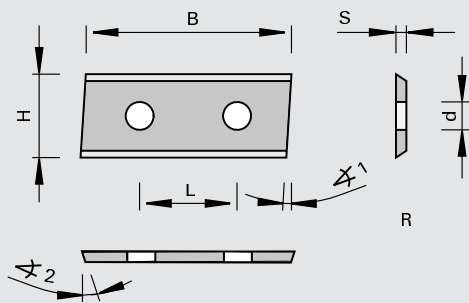
150515

Turnover Knives HW with 2 cutting edges, edge bevel and end sharpened

Product



Drawing



tungsten carbide [HW]

Machine / Application

- | for use in V-grooving cutterheads and prism cutterheads

Design

- | grinding angle 55 degrees
- | cutting material: HW
- | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

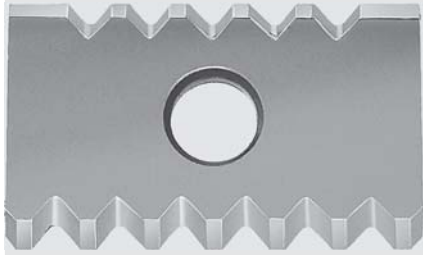
- | packing unit: 10 pieces

B	H	S	Ø d	L	Clearance \sphericalangle 1	Clearance \sphericalangle 2	Ident-No. [L]	Ident-No. [R]
19,5	12	1,5	4		3,5	10	160626	160625
29,5	12	1,5	4	14	5		003119	003118
49,2	12	1,5	4	26	5		003121	003120
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]		

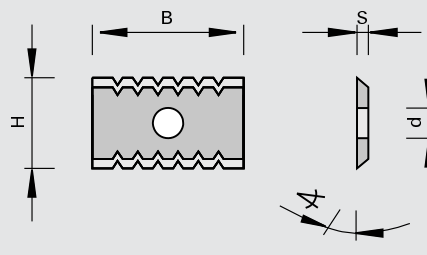
150515

Turnover Knives HW with 2 cutting edges - interrupted cutting edges

Product



Drawing



tungsten carbide [HW]

Machine / Application

| for use in hoggers

Design

| chip breakers for optimum cut division
| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

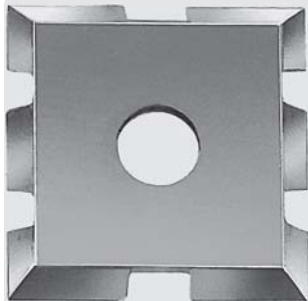
| packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	Ident-No.
20 [mm]	12 [mm]	1.5 [mm]	4 [mm]	55 [°]	055905

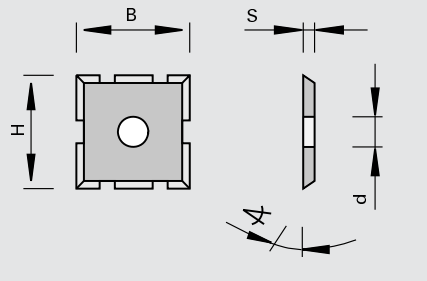
150518

Turnover Knives HW with 4 cutting edges - interrupted cutting edges

Product



Drawing



tungsten carbide [HW]

Machine / Application

Design

| chip breakers for optimum cut division
| cutting material: HW
| HL Solid 25 for hard and soft woods

Advantages

Notes

| packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	Ident-No.
15 [mm]	15 [mm]	2 [mm]	4 [mm]	55 [°]	167873

151558

Profile knives HW - for dove-tail profiles

Product		Drawing					
				tungsten carbide [HW]			
Machine / Application	Design	Advantages	Notes				
<ul style="list-style-type: none"> for dove-tail cutterheads Hundegger 	<ul style="list-style-type: none"> cutting material: HW HL Solid 25 for hard and soft woods 		<ul style="list-style-type: none"> packing unit per single profile 10 pieces 				
B	H	S	Ø d	L	Wedge	Profile	Ident-No.
39,5	15.68	2	4	26	55	A	185205 s
39,5	15.68	2	4	26	55	B	185206 s
39,5	15.68	2	4	26	55	C	185207 s
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

150523 / 150525

Profile Knives HW with 1 cutting edge, end sharpened

Product		Drawing					
				tungsten carbide [HW]			
Machine / Application	Design	Advantages	Notes				
<ul style="list-style-type: none"> for use in shank-type cutters 	<ul style="list-style-type: none"> cutting material: HW HW HL Board 03 for wood-based panels and plastics HL Board 05 for wood-based panels, plastics and hard woods 		<ul style="list-style-type: none"> packing unit: 10 pieces 				
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
16	7	1.5	3,4	7	55	HL Board 03	180262
23	7	1.5	3,4	14	55	HL Board 05	182697
28	7	1.5	3,4	14	55	HL Board 03	180260
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

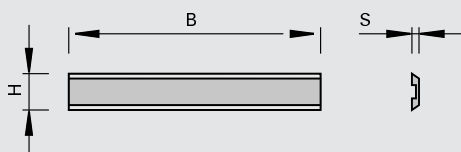
150515

Turnover Knives HW with 2 cutting edges - Leitz

Product



Drawing



tungsten carbide [HW]

Machine / Application

| for use in Leitz cutterheads

Design

| cutting material: HW HL Board
05 for wood-based panels,
plastics and hard woods

Advantages

Notes

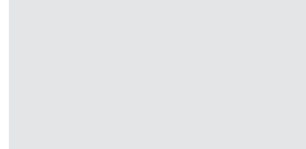
| packing unit: 10 pieces

B	H	S	Ident-No.
14,7	8	1.5	181504
19,7	8	1.5	181505
30	8	1.5	181506
35	8	1.5	181507
40	8	1.5	181508
50	8	1.5	181509
60	8	1.5	181510
80	8	1.5	181511
[mm]	[mm]	[mm]	

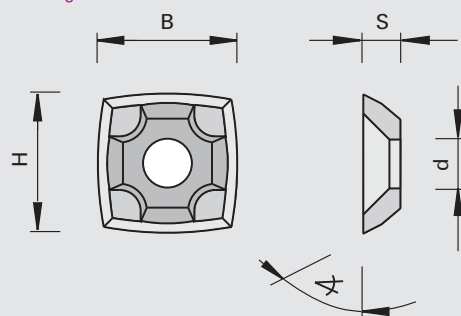
150518 / 150519

Turnover Knives HW with 4 cutting edges with countersink - EWD, Hundegger

Product



Drawing



tungsten carbide [HW]

Machine / Application

| machines EWD, Hundegger
| for use in cutterheads

Design

| cutting material: HW
| HL Solid 20 for hard and soft
woods
| HL Solid 30 for hard and soft
woods
| HL Solid 60 for soft woods

Advantages

Notes

| packing unit: 10 pieces

B	H	S	Ø d	Wedge	LEUCODUR	Ident-No.	
21	21	5.5	7,3	40	HL Solid 20	EWD	184786
21	21	5.5	7,3	40	HL Solid 30	Hundegger	180639
21	21	5.5	7,3	40	HL Solid 60	Hundegger	180638
[mm]	[mm]	[mm]	[mm]	[°]			

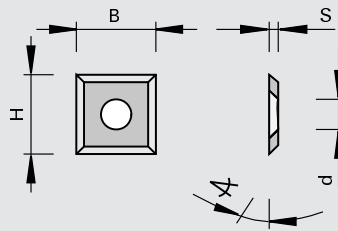
150518 / 150519

Turnover Knives HW with 4 cutting edges and countersink

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

- | machines Homag, Fischer Brugg
- | for the use as flat scraper on Homag edge banding machines FA20
- | for use in edge jointing cutterheads
- | for use in spiral cutterheads
- | for use in cutterheads

Design

Advantages

Notes

- | packing unit: 10 pieces

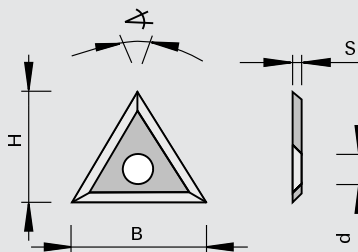
B	H	S	Ø d	Wedge	LEUCODUR		Ident-No.
13,6	13,6	2	6,3	45	HL Solid 40	Fischer Brugg	163829
14,3	14,3	2,5	6,3	45	HL Solid 25	IMA	183828
14,3	14,3	2,5	6,3	55	HL Solid 25	Homag (FA20)	170248
15	15	2,5	6,2	50	HL Solid 25	Chamfering Cutterhead	181243
15	15	2,5	6,4	60	HL Solid 25	with rounded edges (R=50 mm for Ø D<100 mm)	180454
15	15	2,5	6,4	60	HL Solid 25	with rounded edges (R=150 mm for Ø D>100 mm)	185274
20	14,3	2,5	6,3	55	HL Solid 15	Homag	168509
22	22	2,0	6,5	60	HL Solid 25	Weinig	185277
[mm]	[mm]	[mm]	[mm]	[°]			

150558/132821

Triangular Spur HW with 3 cutting edges

Product

Drawing



tungsten carbide [HW]

Machine / Application

| for use in Leitz cutterheads

Design

| cutting material: HW
 | HL Solid 25 for hard and soft woods
 | HL Solid 30 for hard and soft woods

Advantages

Notes

| packing unit: 10 pieces

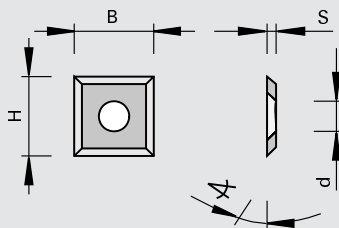
B	H	S	Ø d	Corner∟	LEUCODUR	Ident-No.
22	19.05	2	6,5	60	HL Solid 25	180779
22,9	19.8	2.5	6,4	60	HL Solid 30	183685
[mm]	[mm]	[mm]	[mm]	[°]		

150553 / 150555 / 150759 / 150758

Turnover Spurs HW with 4 cutting edges and countersink

Product

Drawing



tungsten carbide [HW]

Machine / Application

| for use in cutterheads

Design

| Topline (polished face and micro-ground clearance angle)

Advantages

| significantly improved cutting edges
 | excellent cutting quality especially in solid woods

Notes

| Ident-No. 167777 for scoring device of the HOLZ-HER vertical panel sizing saw
 | * marking for easier mounting
 | packing unit: 10 pieces

B	H	S	Ø d	Wedge∟	LEUCODUR	Ident-No.
10,5	10.5	1.5	4	55	HL Solid 25 Lestro	176719
14	14	1.2	8,6	60	HL Solid 40	163701
14	14	1.2	8,6	60	HL Solid 40 HOLZ-HER	167777
14	14	2	6,3	60	HL Solid 25 Topline	176341
14	14	2	6,3	60	HL Solid 40 Weinig	003079
14	14	2	6,3	60	HL Board 05	180954
14	14	2	6,3	60	HL Board 03	180646
15	15	2.5	6,2	60	HL Solid 25 Weinig	185276
[mm]	[mm]	[mm]	[mm]	[°]		

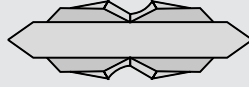
150558

Turnover spurs HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

Design

- | cutting edge with scoring cut
- | cutting material: HW
- | HL Solid 15 for wood-based panels, hard and soft woods

Advantages

- | chip-free hole edges thanks to cutting edge with scoring cut

Notes

- | packing unit: 10 pieces

Dimension

LEUCODUR

Ident-No.

18x6x3,5
[mm]

HL Board 15

181263

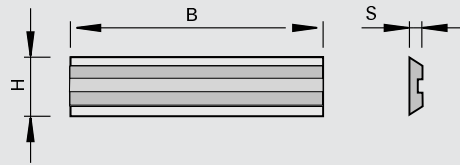


332121

Turnover Knives HS with 2 cutting edges - Weing

Product

Drawing



High Speed Steel [HS]

Machine / Application

for use in Weing planing cutterheads Centrolock for planing of soft woods

Design

cutting material: high speed steel (HS 18%) for soft woods

Advantages

high planing quality and long edge lives

Notes

packing unit: 2 pieces

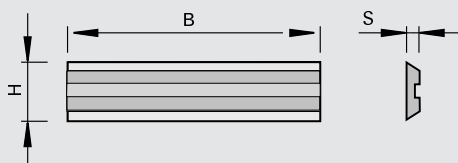
B	H	S	Ident-No.
20	16	3	184334 o
60	16	3	184335 o
80	16	3	184336 o
100	16	3	184337 o
130	16	3	184338
150	16	3	184339 o
170	16	3	184340
180	16	3	184341 o
190	16	3	184342 o
210	16	3	184343 o
230	16	3	184344 o
240	16	3	184345
260	16	3	184346 o
270	16	3	184347 o
285	16	3	184331 o
310	16	3	184348 o
460	16	3	184349 o
[mm]	[mm]	[mm]	

150518

Turnover Knives HW with 2 cutting edges - Weinig

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in Weinig planing cutterheads Centrolock for planing of glued soft woods, hard woods and MDF

Design

cutting material: HW
HL Solid 25 for hard and soft woods

Advantages

high planing quality and long edge lives

Notes

packing unit: 2 pieces

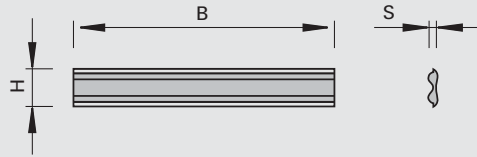
B	H	S	Ident-No.
20	16	3	181593 o
60	16	3	181594 o
80	16	3	181595 o
100	16	3	181596
130	16	3	181597
150	16	3	181598 o
170	16	3	181599
180	16	3	181600 o
190	16	3	181601 o
210	16	3	181602 o
230	16	3	181603 o
240	16	3	181604
260	16	3	181605 o
270	16	3	181606 o
310	16	3	181607 o
460	16	3	181608 o
[mm]	[mm]	[mm]	

332751

Turnover Knives SP with 2 cutting edges - Tersa

Product

Drawing



Alloyed Steel

Machine / Application

I for use in Tersa planing cutterheads

Design

I SP - 13% chrome - special steel

Advantages

Notes

I packing unit: 2 pieces

B	H	S	Ident-No.
60	10	2.3	175405 o
70	10	2.3	175406 o
80	10	2.3	175407 o
90	10	2.3	175408 o
100	10	2.3	175409 o
110	10	2.3	175410 o
120	10	2.3	175411 o
130	10	2.3	175412 o
140	10	2.3	175413 o
150	10	2.3	175414 o
160	10	2.3	175415 o
170	10	2.3	175416 o
180	10	2.3	175417 o
185	10	2.3	175418 o
190	10	2.3	175419 o
200	10	2.3	175420 o
210	10	2.3	175421 o
220	10	2.3	175422 o
230	10	2.3	175423 o
240	10	2.3	175424 o
250	10	2.3	175425 o
260	10	2.3	175426 o
265	10	2.3	175427 o
270	10	2.3	175428 o
280	10	2.3	175429 o
290	10	2.3	175430 o
300	10	2.3	175431 o
310	10	2.3	175432 o
315	10	2.3	175433 o
320	10	2.3	175434 o
330	10	2.3	175435 o
340	10	2.3	175436 o
350	10	2.3	175437 o
360	10	2.3	175438 o
370	10	2.3	175439 o
380	10	2.3	175440 o
390	10	2.3	175441 o
400	10	2.3	175442 o
410	10	2.3	175443 o
420	10	2.3	175444 o
430	10	2.3	175445 o
440	10	2.3	175446 o
450	10	2.3	175447 o
460	10	2.3	175448 o
[mm]	[mm]	[mm]	

B	H	S	Ident-No.
470	10	2.3	175449 o
480	10	2.3	175450 o
490	10	2.3	175451 o
500	10	2.3	175452 o
510	10	2.3	175453 o
520	10	2.3	175454 o
530	10	2.3	175455 o
540	10	2.3	175456 o
550	10	2.3	175457 o
560	10	2.3	175458 o
570	10	2.3	175459 o
580	10	2.3	175460 o
590	10	2.3	175461 o
600	10	2.3	175462 o
610	10	2.3	175463 o
620	10	2.3	175464 o
630	10	2.3	175465 o
635	10	2.3	175466 o
637	10	2.3	175467 o
640	10	2.3	175468
650	10	2.3	175469 o
[mm]	[mm]	[mm]	

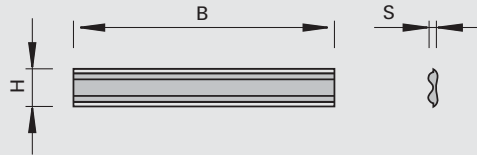


332751

Turnover Knives HS with 2 cutting edges - Tersa

Product

Drawing



High Speed Steel [HS]

Machine / Application

| for use in Tersa planing
cutterheads

Design

| cutting material: HS

Advantages

Notes

| packing unit: 2 pieces

B	H	S	Ident-No.
60	10	2.3	175305 o
80	10	2.3	175307 o
90	10	2.3	175308 o
100	10	2.3	175309 o
110	10	2.3	175310 o
120	10	2.3	175311 o
130	10	2.3	175312 o
140	10	2.3	175313 o
150	10	2.3	175314 o
160	10	2.3	175315 o
170	10	2.3	175316 o
180	10	2.3	175317 o
185	10	2.3	175318 o
190	10	2.3	175319 o
200	10	2.3	175320 o
210	10	2.3	175321 o
220	10	2.3	175322 o
230	10	2.3	175323 o
240	10	2.3	175324 o
250	10	2.3	175325 o
260	10	2.3	175326 o
265	10	2.3	175327 o
270	10	2.3	175328 o
280	10	2.3	175329 o
300	10	2.3	175331 o
310	10	2.3	175332
320	10	2.3	175334 o
330	10	2.3	175335 o
350	10	2.3	175337 o
360	10	2.3	175338 o
400	10	2.3	175342 o
410	10	2.3	175343
420	10	2.3	175344 o
430	10	2.3	175345 o
450	10	2.3	175347 o
500	10	2.3	175352 o
510	10	2.3	175353
520	10	2.3	175354
530	10	2.3	175355 o
540	10	2.3	175356 o
610	10	2.3	175363 o
630	10	2.3	175365
635	10	2.3	175366 o
640	10	2.3	175368
[mm]	[mm]	[mm]	

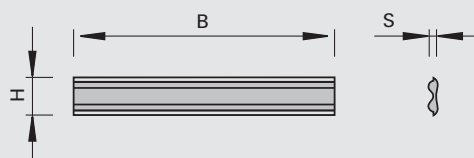
B	H	S	Ident-No.
650	10	2.3	175369 o
[mm]	[mm]	[mm]	

132751

Turnover Knives HW with 2 cutting edges - Tersa

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in Tersa planing
cutterheads

Design

| cutting material: HW

Advantages

| optimal precision as manuf-
actured from one piece up to
B=650 mm

Notes

| packing unit 2 pieces

B	H	S	Ident-No.
60	10	2.3	175205 o
70	10	2.3	175206 o
80	10	2.3	175207 o
90	10	2.3	175208 o
100	10	2.3	175209 o
110	10	2.3	175210 o
120	10	2.3	175211 o
130	10	2.3	175212 o
140	10	2.3	175213 o
150	10	2.3	175214 o
160	10	2.3	175215 o
170	10	2.3	175216 o
180	10	2.3	175217 o
185	10	2.3	175218 o
190	10	2.3	175219 o
200	10	2.3	175220 o
210	10	2.3	175221 o
220	10	2.3	175222 o
230	10	2.3	175223 o
240	10	2.3	175224 o
250	10	2.3	175225 o
260	10	2.3	175226 o
265	10	2.3	175227 o
270	10	2.3	175228 o
280	10	2.3	175229 o
290	10	2.3	175230 o
300	10	2.3	175231 o
310	10	2.3	175232 o
315	10	2.3	175233 o
320	10	2.3	175234 o
330	10	2.3	175235 o
340	10	2.3	175236 o
350	10	2.3	175237 o
360	10	2.3	175238 o
370	10	2.3	175239 o
380	10	2.3	175240 o
390	10	2.3	175241 o
400	10	2.3	175242 o
[mm]	[mm]	[mm]	

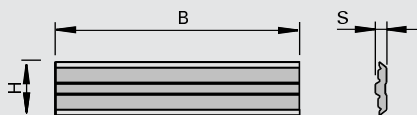
B	H	S	Ident-No.
410	10	2.3	175243 o
420	10	2.3	175244 o
430	10	2.3	175245 o
440	10	2.3	175246 o
450	10	2.3	175247 o
460	10	2.3	175248 o
470	10	2.3	175249 o
480	10	2.3	175250 o
490	10	2.3	175251 o
500	10	2.3	175252 o
510	10	2.3	175253
520	10	2.3	175254 o
530	10	2.3	175255 o
540	10	2.3	175256 o
550	10	2.3	175257 o
560	10	2.3	175258 o
570	10	2.3	175259 o
580	10	2.3	175260 o
590	10	2.3	175261 o
600	10	2.3	175262 o
610	10	2.3	175263 o
620	10	2.3	175264 o
630	10	2.3	175265 o
635	10	2.3	175266 o
640	10	2.3	175268 o
650	10	2.3	175269 o
[mm]	[mm]	[mm]	

332121

Turnover Knives HS with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



High Speed Steel [HS]

Machine / Application

for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of soft woods

Design

cutting material: HS for soft woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

packing unit 2 pieces

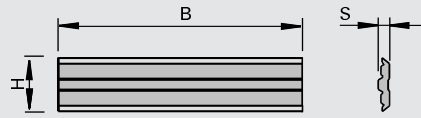
B	H	S	Ident-No.
80	12	2.7	182769 o
100	12	2.7	182770 o
130	12	2.7	182771 o
150	12	2.7	182772 o
170	12	2.7	182773 o
180	12	2.7	182774 o
190	12	2.7	182775 o
210	12	2.7	182776 o
230	12	2.7	182777 o
240	12	2.7	182778 o
310	12	2.7	182779 o
410	12	2.7	182780 o
510	12	2.7	182782 o
520	12	2.7	182781 o
640	12	2.7	182783 o
[mm]	[mm]	[mm]	

150518

Turnover Knives HW with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of hard woods and MDF

Design

cutting material: HW
HL Solid 25 for hard and exotic woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

a cutting length of more than 630 mm is reached by means of several knives
packing unit 2 pieces

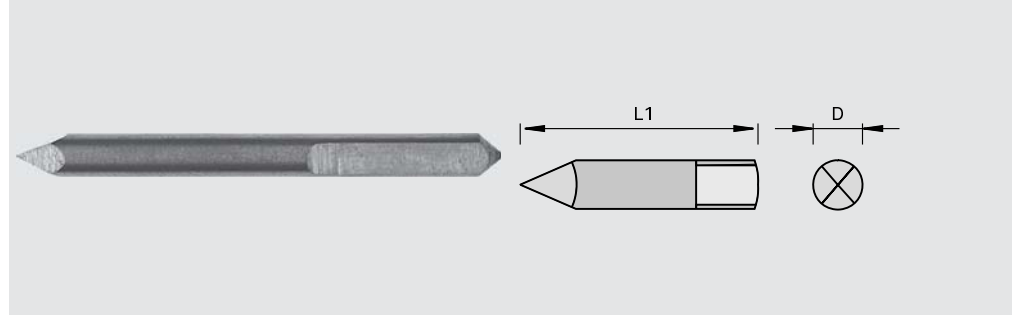
B	H	S	Ident-No.
100	12	2.7	182784 o
130	12	2.7	182785 o
150	12	2.7	182786 o
170	12	2.7	182787 o
180	12	2.7	182788 o
190	12	2.7	182789 o
210	12	2.7	182790 o
230	12	2.7	182791 o
240	12	2.7	182792 o
410	12	2.7	182793 o
510	12	2.7	182794 o
640	12	2.7	182795 o
[mm]	[mm]	[mm]	

165512

Centering points HW

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

Design

Advantages

Notes

- | with surface on shank for set screw
- | cutting material: HW
- | HL Solid 40 for hard and soft woods

- | packing unit: 10 pieces

Ø D

L1

Ident-No.

3

33.5

162624


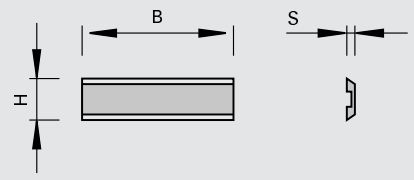

[mm]

[mm]



150535

Mini Turnover Knives HW with 2 cutting edges

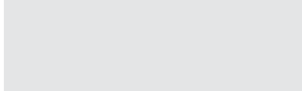
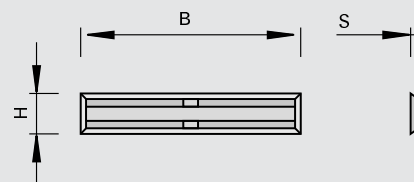

Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
for use in shank-type cutter-heads	cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

B	H	S	Ident-No.
12	5.5	1.1	162670
20	5.5	1.1	160623
40	5.5	1.1	160674
50	5.5	1.1	163572
[mm]	[mm]	[mm]	

150535

Mini Turnover Knives HW with 2 cutting edges, end sharpened

Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
for use in shank-type cutters	cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

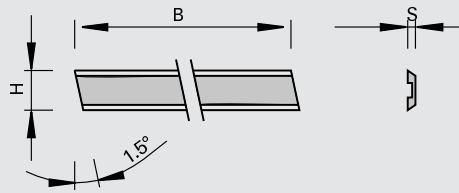
B	H	S	Ident-No.
12	5.5	1.1	168696
20	4.1	1.1	173480
20	5.5	1.1	173481
25	5.5	1.1	173793
30	5.5	1.1	173482
50	5.5	1.1	173483
[mm]	[mm]	[mm]	

150535

Mini Turnover Knives HW with 2 cutting edges, end bevel

Product

Drawing



tungsten carbide [HW]

Machine / Application

- | CNC machining centers
- | for use in shank-type cutters

Design

- | cutting material: HW
- | HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

- | packing unit: 10 pieces

B	H	S	Ident-No.
39,8	5.5	1.1	163211 o
[mm]	[mm]	[mm]	

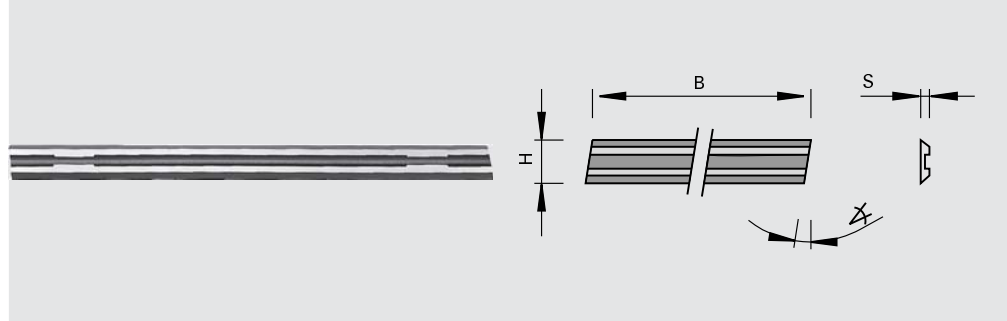


150549

Portable Planer Turnover Knives HW with 2 cutting edges and edge bevel

Product

Drawing



tungsten carbide [HW]

Machine / Application

| portable planers

Design

| cutting material: HW
| HL Solid 40 for hard and soft woods

Advantages

Notes

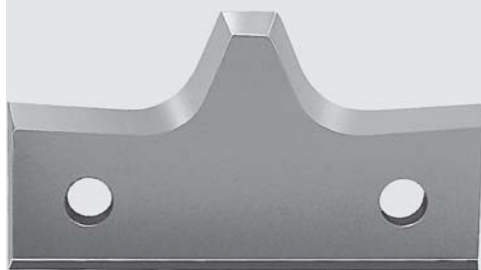
| Ident-No. 166381 can only be used in the original ELU clamping element
| packing unit: 10 pieces

B	H	S	Clearance \sphericalangle 1		Ident-No.
75,5	5.5	1.1	1.5	AEG HTH 75, Bosch 0590, P400, 1590, 1591, Festo REP 75, Haffner FH 222, HOLZ-HER 2223, 2286, 2320, Kress Jet Star 6701, Mafell HU 75, Metabo 6375, Scheer MH 80, MH 75/3, Skil 98 H	162439
75,7	5.5	1.2	8	Black&Decker DN 750	166079 o
80,5	5.9	1.2	8	ELU MFF 80	166381
82	5.5	1.1	3	AEG, Fein, Haffner, Hitachi, Mafell, Makita, Metabo, Bosch, Black&Decker DN712	165617
102	5.5	1.1	3	AEG EH 102, HB 750	419671 o
[mm]	[mm]	[mm]	[°]		

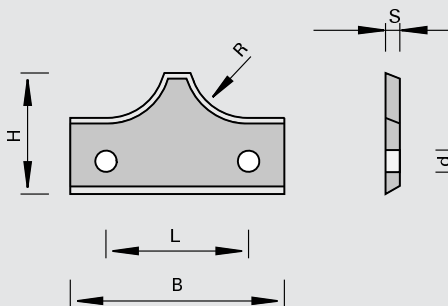
151545

Radius Profile Knives HW with 2 cutting radii and bottom chamfer - Homag, IMA

Product



Drawing



tungsten carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

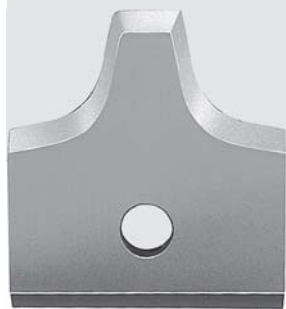
packing unit: 10 pieces

R	B	H	S	Ø d	L		Ident-No.
2	20,5	15	2	3	12	Homag	163062 s
3	20,8	15	2	3	12	Homag	163063
5	30	17	2	3	20	Homag	163065
4	20,8	15	2	3	12	Homag	163064 s
6	30,5	17	2	3	20	Homag	163066
8	30,5	17	2	3	20	Homag	163068 s
2	20,8	14.7	2	3	12	IMA	164166 s
3	20,8	14.7	2	3	12	IMA	164167 s
4	20,8	14.7	2	3	12	IMA	164168 s
5	30,5	16.5	2	3	20	IMA	164169 s
6	30,5	16.5	2	3	20	IMA	164170 s
7	30,5	16.5	2	3	20	IMA	164171 s
8	30,5	16.5	2	3	20	IMA	164172 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

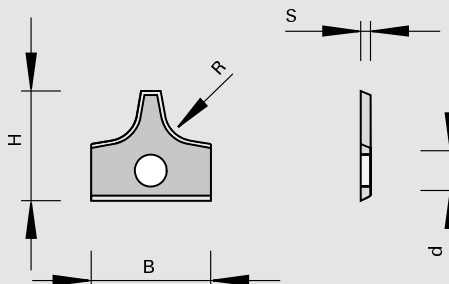
151545 / 151585

Radius Profile Knives HW with 2 cutting radii and bottom chamfer

Product



Drawing



tungsten carbide [HW]

Machine / Application

l type A for use in edge rounding cutterheads
l type B for use in scraper holders

Design

l cutting material: HW
l HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

l packing unit: 10 pieces

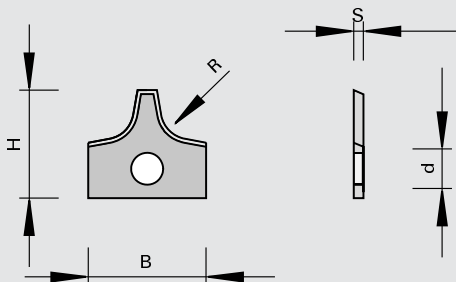
R	B	H	S	Ø d	Profile run-out	Type	Ident-No.
2	12	12	1.5	4	5	A	HOLZ-HER
3	12	12	1.5	4	5	A	HOLZ-HER
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		
R	B	H	S	Ø d	Profile run-out	Type	Ident-No.
2	16	15.5	2	4,4	10	A	Brandt
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		
R	B	H	S	Ø d	Profile run-out	Type	Ident-No.
1,5	16	17.5	2	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt
2	16	17.5	2	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt
2	16	17.5	2	4,4	10	A	Brandt
2,5	16	17.5	2	4,4	10	A	
3	16	17.5	2	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt
3	16	17.5	2	4,4	10	A	Brandt
4	16	17.5	2	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt
5	16	17.5	2	4,4	10	A	HOLZ-HER, Homag, Ott, IMA, Wilmsmeyer, Brandt
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		
R	B	H	S	Ø d	Profile run-out	Type	Ident-No.
2	16	17.5	2	3	10	B	IMA, Wilmsmayer, Torwegge
2,5	16	17.5	2	3	10	B	IMA, Wilmsmayer, Torwegge
3	16	17.5	2	3	10	B	IMA, Wilmsmayer, Torwegge
4	16	17.5	2	3	10	B	IMA, Wilmsmayer, Torwegge
5	16	17.5	2	3	10	B	IMA, Wilmsmayer, Torwegge
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

151545 / 151585

Radius Profile Knives HW with 2 cutting radii

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

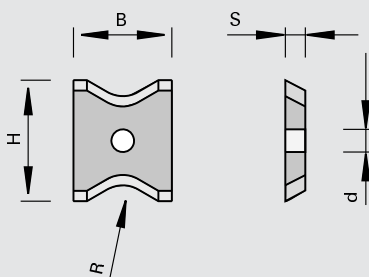
R	B	H	S	Ø d	Profile run-out	Ident-No.
2	12	13	2	5	10	Brandt
2,5	12	13	2	4	10	
3	12	13	2	5	10	Brandt
6	24	22	2	4,4	10	Homag, Ott
8	24	22	2	4,4	10	Homag, Ott
9	24	22	2	4,4	10	Homag, Ott
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

151555

Radius Profile Knives HW symmetrical with 2 cutting radii

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in edge banding / rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

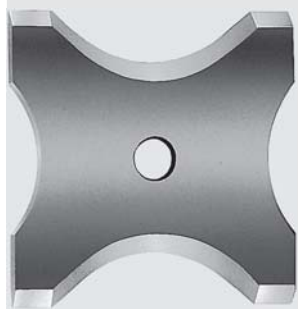
R	B	H	S	Ø d	Profile run-out	Ident-No.
2	13	16	2	4	5	162794
3	13	16	2	4	5	162795
4	13	16	2	4	5	162565
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

R	B	H	S	Ø d	Profile run-out	Ident-No.
2	13	16	2	4	15	IMA
3	13	16	2	4	15	IMA
4	13	16	2	4	15	IMA
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

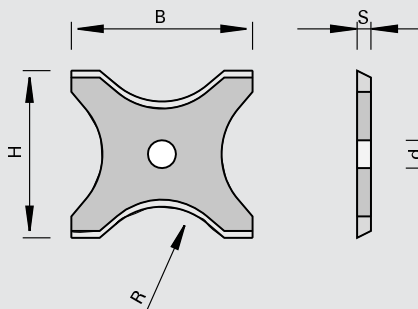
15 1555

Radius Turnover Knives HW symmetrical with 2 cutting radii

Product



Drawing



tungsten carbide [HW]

Machine / Application

for use in edge banding / rounding cutterheads

Design

5 degree profile run-out
cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

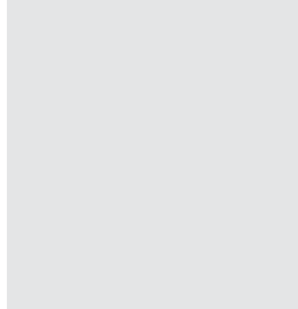
packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
5	20	21	2	4	162566
6	20	21	2	4	162567
7	20	21	2	4	162568 #
8	20	21	2	4	162569
9	26	24	2	4	162796
10	26	24	2	4	162570
11	26	24	2	4	162571
12	26	24	2	4	162572
[mm]	[mm]	[mm]	[mm]	[mm]	

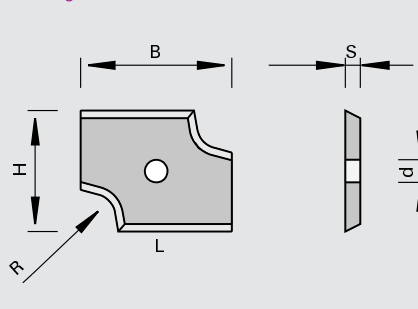
15 1555

Radius Turnover Knives HW with 2 cutting radii

Product



Drawing



tungsten carbide [HW]

Machine / Application

for use in edge rounding cutterheads

Design

cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

R	B	H	S	Ø d		Ident-No. [L]	Ident-No. [R]
3	20	16	2	3		168355	168356
2	30	14	2	4	Reich	177136 s	177135 s
2,5	30	14	2	4	Reich	177138 #	177137 #
3	30	14	2	4	Reich	177140 #	177139
[mm]	[mm]	[mm]	[mm]	[mm]			

151545 / 151586

Radius Profile Knives HW with 1 cutting radius and bottom chamfer

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
for use in edge rounding cutterheads	cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

R	B	H	S	Ø d	LEUCODUR	Ident-No. [L]	Ident-No. [R]
2	12	14.5	2	4	HL Board 05	172142	172141
2,5	12	14.5	2	4	HL Board 05	171224	171223
3	12	14.5	2	4	HL Board 05	172144	172143
2,5	14,5	14.5	2	5	HL Board 06	181657	181658
[mm]	[mm]	[mm]	[mm]	[mm]			

151545

Radius Profile Knives HW with 1 cutting radius

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
for use in rounding cutterheads	cutting material: HW HL Board 05 and HL Board 06 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

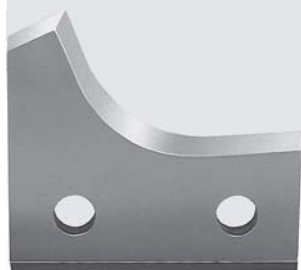
R	B	H	S	Ø d	Profile run-out	LEUCODUR	Ident-No. [L]	Ident-No. [R]
2	12	15	2	4	10	HL Board 06	177034	177038
1,5	12	17	2	5	13	Homag HL Board 05	177605	177606
2	12	17	2	5	13	Homag HL Board 05	177607	177608
2,5	12	17	2	5	13	Homag HL Board 05	177609 #	177610 #
3	12	17	2	5	13	Homag HL Board 05	177611	177612
2	12	18	2	4	11	HL Board 05		172725
3	12	18	2	4	11	HL Board 05		172726 #
1	13	15	2	4	10	HL Board 06	180722	180721
1,5	13	15	2	4	10	HL Board 06	181954	181953
2	13	15	2	4	10	HL Board 06	181956	181955
2,5	13	15	2	4	10	HL Board 06	180728	180727
3	13	15	2	4	10	HL Board 06	181957	181958
4	14	17	2	4	10	HL Board 05	177036 #	177040 #
2	15	14.5	2	4	15	HL Board 05	177317	177318
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			

R	B	H	S	Ø d	Profile run-out	LEUCODUR	Ident-No. [L]	Ident-No. [R]
2,5	15	14.5	2	4	15	HL Board 05	177319	177320
3	15	14.5	2	4	15	HL Board 05	177321	177322
5	15	17	2	4	10	HL Board 05	177037	177041
3	15	18.4	2	4	5	HL Board 05	168272 #	168279 #
4	15	18.4	2	4	5	HL Board 05	168273 #	168280 #
5	15	18.4	2	4	5	HL Board 05	168274 #	168281
6	15	21.6	2	4	5	HL Board 05	168286 #	168293 s
8	15	21.6	2	4	5	HL Board 05	168288 #	168295 #
2	16,1	14	2	4	15	HL Board 05	178219	178218
3	16,1	14	2	4	15	HL Board 05	178221	178220
2	19,6	15.2	2	4	15	HL Board 05	173817	173816
3	19,6	15.2	2	4	15	HL Board 05	173393	173392
9	20	25.8	2	4	5	HL Board 05	168301 s	168310 s
10	20	25.8	2	4	5	HL Board 05	168302 s	168311 s
12	20	25.8	2	4	5	HL Board 05	168304 s	168313
[mm]	[mm]	[mm]	[mm]	[mm]	[°]			

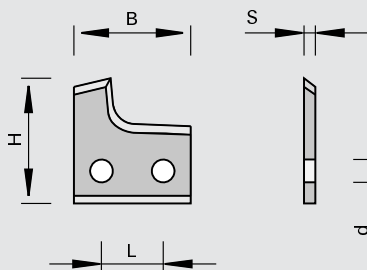
151545

Radius Profile Knives HW with 1 cutting radius - Homag, IMA

Product



Drawing



tungsten carbide [HW]

Machine / Application

- l machine Homag, IMA
- l for use in rounding cutterheads

Design

- l 5 degree profile run-out
- l cutting material: HW
- l HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

R	B	H	S	Ø d	L		Ident-No. [L]	Ident-No. [R]
10	21,8	20	2	3	12	Homag	163071 #	163072
12	21,8	20	2	3	12	Homag	163075 s	163076 #
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

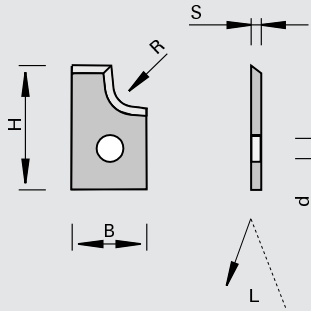
R	B	H	S	Ø d	L		Ident-No. [L]	Ident-No. [R]
9	21,8	19.5	2	3	12	IMA	164173 s	164174 s
10	21,8	19.5	2	3	12	IMA	164175 s	164176 s
11	21,8	19.5	2	3	12	IMA	164177 s	164178 s
12	21,8	19.5	2	3	12	IMA	164179 s	164180 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

151545

Radius Profile Knives HW with 1 cutting radius - IMA

Product

Drawing



tungsten carbide [HW]

Machine / Application

l machines IMA
l for use in rounding cutterheads

Design

l 15 degree profile run-out
l cutting material: HW
l HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

l packing unit: 10 pieces

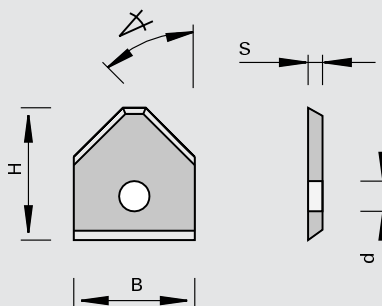
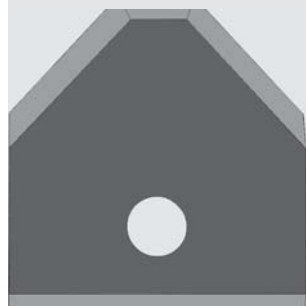
R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
2	12	18	2	5	180174	180173
3	12	18	2	5	180176	180175
[mm]	[mm]	[mm]	[mm]	[mm]		

151545

Chamfering Knives HW with 2 cutting radii

Product

Drawing



tungsten carbide [HW]

Machine / Application

l for use in edge rounding cutterheads

Design

l cutting material: HW
l HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

l Ident-No. 180792 for Modula
l packing unit: 10 pieces

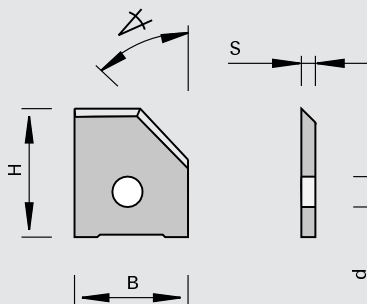
Chamfer∠	B	H	S	Ø d	Ident-No.
45	12	12	1.5	4	180792
45	12	12	1.5	4	171190
45	16	17.5	2	3	169292
45	16	17.5	2	4,3	170329
[°]	[mm]	[mm]	[mm]	[mm]	

151545 / 151546

Chamfering Knives HW with 1 cutting radius

Product

Drawing



tungsten carbide [HW]

Machine / Application

machining centers Homag
for use in chamfering cutter-
heads

Design

cutting material: HW
HL Board 05 for wood-based
panels, plastics and hard
woods
HL Board 06 for wood-based
panels, plastics and hard
woods

Advantages

Notes

packing unit: 10 pieces

Chamfer	B	H	S	Ø d	LEUCODUR	Ident-No. [L]	Ident-No. [R]
5	12	16	2	5	HL Board 06	179174	179173
15	12	16	2	4	HL Board 05	177042	177045
30	13,5	16	2	4	HL Board 05	177043	177046
45	12	16	2	4	HL Board 05	177822	177823
45	15	16	2	4	HL Board 05	177044 s	177047 s
[°]	[mm]	[mm]	[mm]	[mm]			

151519

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 90 degrees

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> vertical panel sizing saws HOLZ-HER for use in 90 degree Folding cutterhead Ident-No. 182616 for the machining of aluminum composite materials 	<ul style="list-style-type: none"> cutting material: HW HL Solid 40 for hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	◁	Ident-No.
14 [mm]	14 [mm]	2 [mm]	6,4 [mm]	90 [°]	182079

151516

Profile Turnover Knives HW for aluminum composite materials - HOLZ-HER, 135 degrees

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> vertical panel sizing saws HOLZ-HER for use in 135 degree Folding cutterhead Ident-No. 703144 for the machining of aluminum composite materials 	<ul style="list-style-type: none"> cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

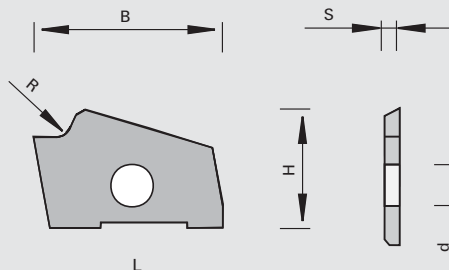
B	H	S	Ø d	◁	Ident-No.
20 [mm]	18 [mm]	2 [mm]	5,7 [mm]	135 [°]	182080 s

15 1586

Radius Profile Knives HW - Brandt

Product

Drawing



tungsten carbide [HW]

Machine / Application

edge banding machines Brandt since date of fabrication 2005
for use in rounding cutterheads with special chip removing design

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

packing unit: 10 pieces

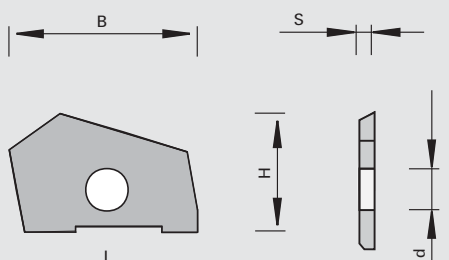
R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
1,5	22,32	14	2	5	183068 s	183067 s
2	22,32	14	2	5	182332	182331
2,5	22,32	14	2	5	182368	182367
3	22,32	14	2	5	182334	182333
[mm]	[mm]	[mm]	[mm]	[mm]		

15 1586

Chamfering Profile Knives HW - Brandt

Product

Drawing



tungsten carbide [HW]

Machine / Application

edge banding machines Brandt since date of fabrication 2005
for use in rounding cutterheads with special chip removing design

Design

cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

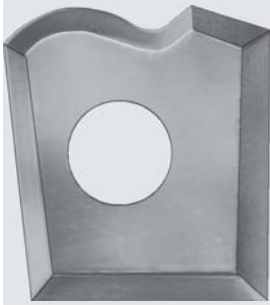
packing unit: 10 pieces

Chamfer∠	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
45	22,32	14	2	5	182667	182666
[°]	[mm]	[mm]	[mm]	[mm]		

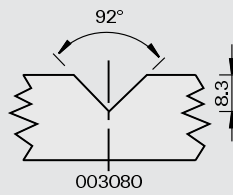
150515 / 151545

Profile Knives HW for ornamental groove cutterheads

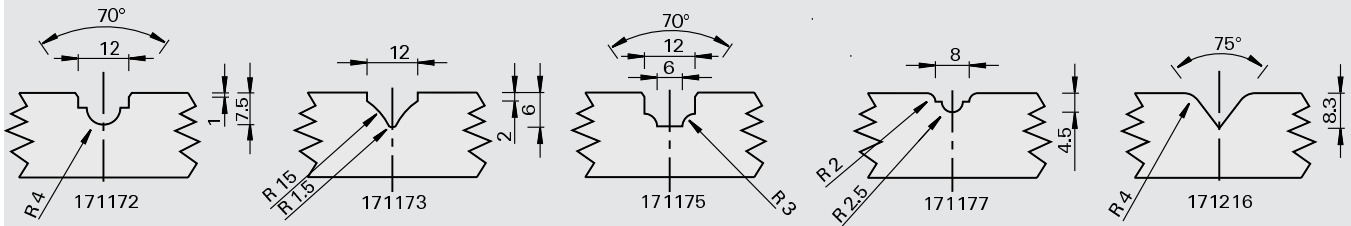
Product



Drawing



tungsten carbide [HW]



Machine / Application

| for use in ornamental groove cutterheads

Design

| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
12	12	1.5	4	003080
12	12	1.5	4	171177 #
11	12	1.5	4	171175 #
11	12	1.5	4	171172
12	12	1.5	4	171216
11	12	1.5	4	171173
[mm]	[mm]	[mm]	[mm]	

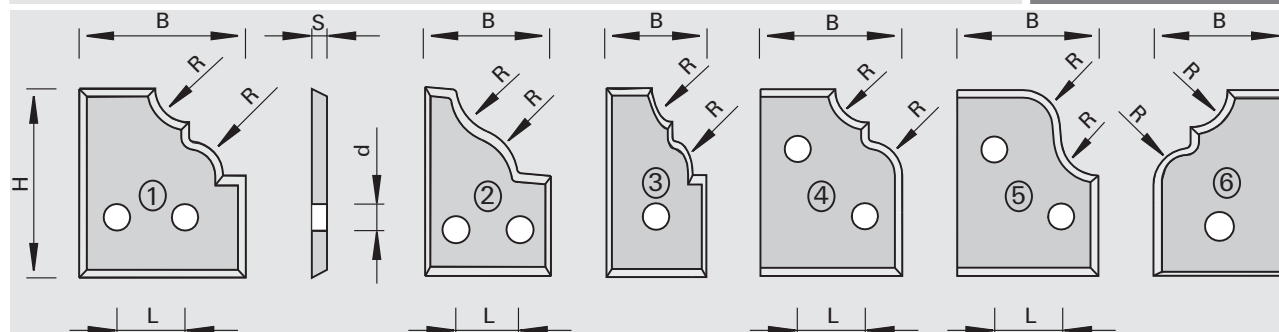
15 1548

Profile Knives HW for stile-and-rail profile cutterheads and panel raising cutterheads

Product



Drawing



tungsten carbide [HW]

Machine / Application

l type 1, 2, 3 for use in stile-and-rail profile cutterheads
l type 4, 5, 6 for use in panel-raising cutterheads

Design

l cutting material: HW
l HL Solid 25 for hard and soft woods

Advantages

Notes

l packing unit: 10 pieces

R	B	H	S	Ø d	L	Type	Ident-No.
4,5	19,3	24,5	2	3,5	11,2	1	165912 #
6,5	16,3	24,5	2	3,5	8,3	2	166127 #
7	13,3	24,5	2	3,5		3	167469 #
4,5	19	25	2	3,5	9	4	165930 #
5	19	25	2	3,5	9	5	165932 #
4,5	16	22,5	2	4		6	168883
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

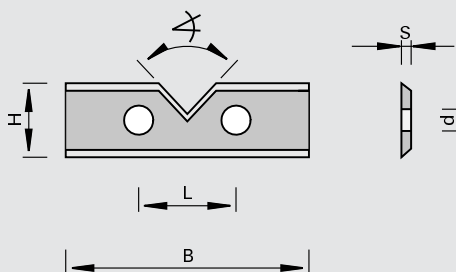
15 1548

Miter Glue Joint Profile Knives HW

Product



Drawing



tungsten carbide [HW]

Machine / Application

l for use in miter glue joint cutterheads

Design

l cutting material: HW
l HL Solid 25 for hard and soft woods

Advantages

l very accurate profiling for optimum glue joints

Notes

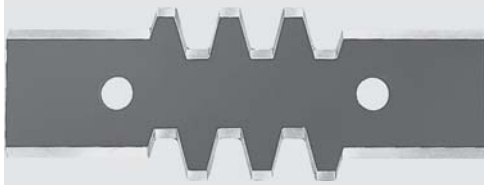
l packing unit: 10 pieces

Chamfer	B	H	S	Ø d	L	Ident-No.
86	39,5	12	1,5	4	26	165916
[°]	[mm]	[mm]	[mm]	[mm]	[mm]	

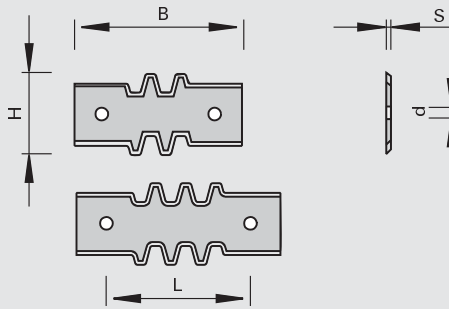
15 1558

Glue Joint Profile Turnover Knives HW

Product



Drawing



tungsten carbide [HW]

Machine / Application

for use in glue joint cutterheads

Design

cutting material: HW
HL Solid 25 for hard and soft woods

Advantages

very accurate profiling for optimum glue joints

Notes

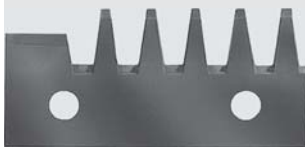
packing unit: 10 pieces

B	H	S	Ø d	L	Ident-No.
50	21.6	2	4	26	165911
60	21.6	2	4	32	165909
[mm]	[mm]	[mm]	[mm]	[mm]	

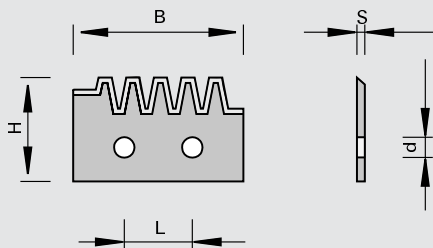
15 1598

Glue Joint Profile Turnover Knives HW Set

Product



Drawing



tungsten carbide [HW]

Machine / Application

for use in adjustable glue joint cutterheads

Design

cutting material: HW
HL Solid 25 for hard and soft woods

Advantages

very accurate profiling for optimum glue joints



Notes

set consists of 4 pieces
Ident-No. 167977, 4 pieces
Ident-No. 167976
packing unit: 10 pieces

B	H	S	Ø d	L	Ident-No.
42	20	2	4	26	168240
[mm]	[mm]	[mm]	[mm]	[mm]	

132891

Turnover Knife Holders - Ledinek Rotoles

Product	Drawing	
		 tungsten carbide [HW]


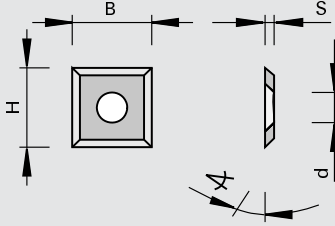

Machine / Application	Design	Advantages	Notes
planing machines Ledinek Rotoles for LEUCODUR turnover knives straight and with chamfer	for mounting of LEUCODUR turnover knives 14 x 14 mm and 14.3 x 14.3 mm		

	Ident-No.
for thicknesser (TOK 14x14x2) top	182082 o
for service planing rotor (TOK 14x14x2) bottom	182083 o
for thicknesser segments (TOK 14,3x14,3x2,5) top	182084 o
for service planing rotor segments (TOK 14,3x14,3x2,5) bottom	182085 o

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x9 T20 D=Ø9,3 [mm]	995 125	827277

150553 / 150555 / 150558 / 150559

Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles

Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
planing machines Ledinek Rotoles for use in turnover knife holders for plain milling	cutting material: HW HL Board 03 for wood-based panels and plastics HL Board 05 for wood-based panels, plastics and hard woods HL Solid 15 for wood-based panels, hard and soft woods HL Solid 40 for hard and soft woods		packing unit: 10 pieces

B	H	S	Ø d	Wedge∟	LEUCODUR	Ident-No.
14	14	2	6,3	60	HL Solid 40	003079
14	14	2	6,3	60	HL Board 05	180954
14	14	2	6,3	60	HL Board 03	180646
14,3	14.3	2.5	6,3	55	HL Solid 25	170248
[mm]	[mm]	[mm]	[mm]	[°]		

150558

Profile Turnover Knives HW with 4 cutting edges and chamfer - Ledinek Rotoles

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> planing machines Ledinek Rotoles for use in turnover knife holders for plain milling 	<ul style="list-style-type: none"> cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods HL Solid 25 for hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2	6,4	60	HL Solid 25	180933	180932
14,3	14.3	2.5	6,4	55	HL Solid 15	181144	181143
[mm]	[mm]	[mm]	[mm]	[°]			

150558

Profile Turnover Knives HW with 4 cutting edges and radius - Ledinek Rotoles

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> planing machines Ledinek Rotoles for use in turnover knife holders for plain milling 	<ul style="list-style-type: none"> cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods HL Solid 25 for hard and soft woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

B	H	S	Ø d	Wedge∠	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2	6,4	60	HL Solid 25	182442	182441
14,3	14.3	2.5	6,4	55	HL Solid 15	182444	182443
[mm]	[mm]	[mm]	[mm]	[°]			

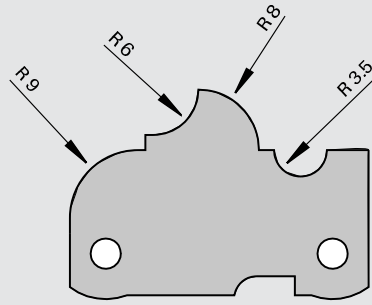
151527

SuperProfiler Knives HW „Multi-Profile“

Product



Drawing



tungsten carbide [HW]

Machine / Application

table shapers
for use in SuperProfiler
cutterheads Ident-No. 167897
and 167894

Design

cutting material: HW
HL Solid 25 for hard and soft
woods

Advantages

Notes

for cutting of various profiles
in one or more steps
profile examples see Technical
Appendix

PU

Ident-No.

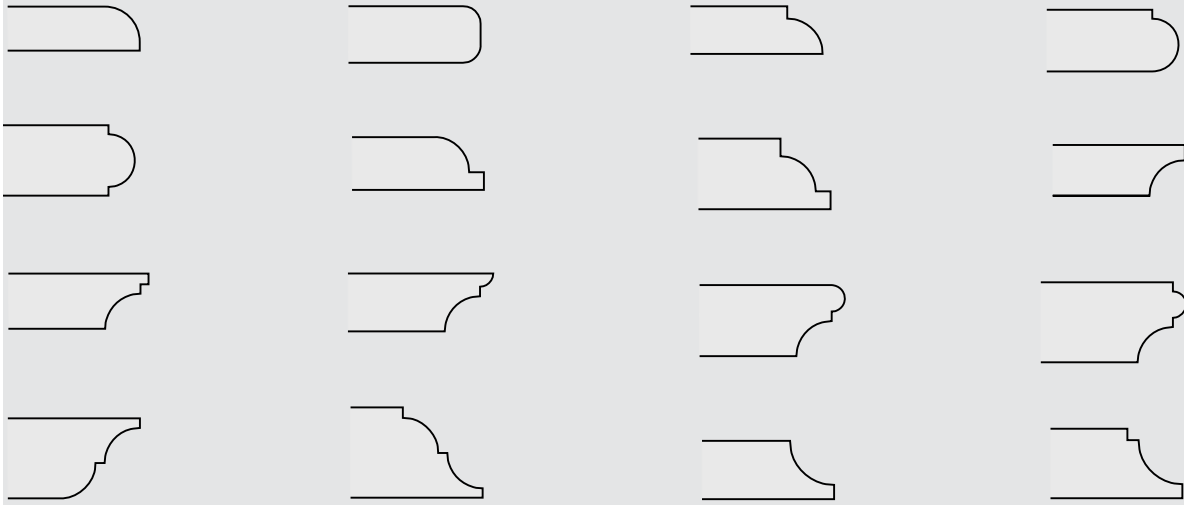
12

169273 s

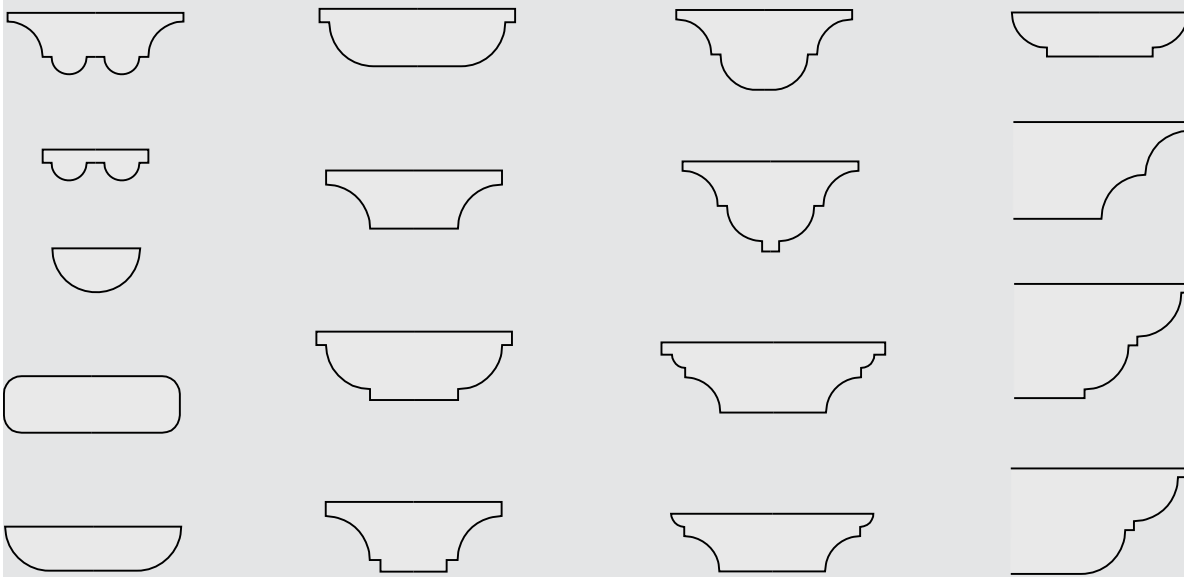
[pc.]

SuperProfiler „Multi-Profile“

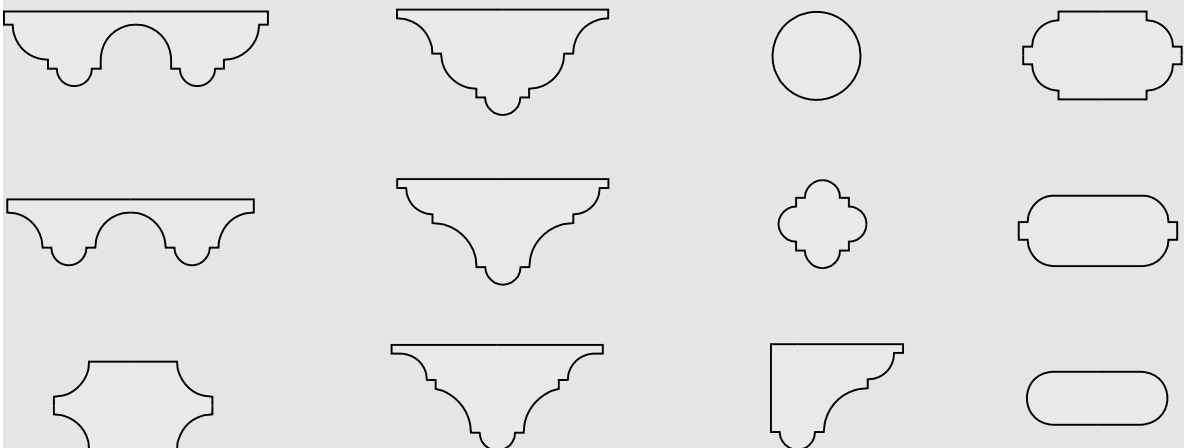
1 Operation



2 Operations

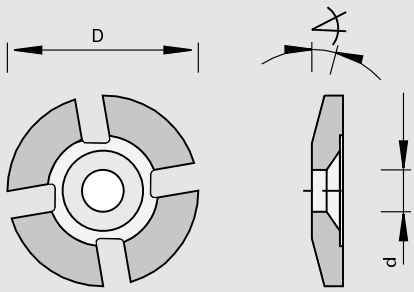


Several operations




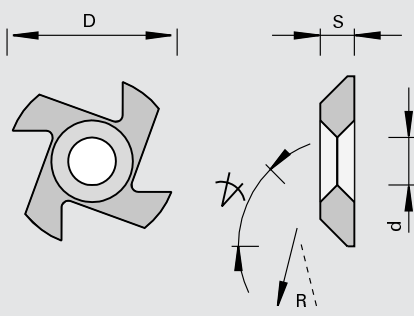
150508

Grooving Turnover Knives HW with 4 cutting edges - miter glue joint cutterheads

Product		Drawing		LEUCO DUR	
				tungsten carbide [HW]	
Machine / Application	Design	Advantages	Notes		
for use in miter glue joint cutterheads	cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods	very accurate profiling for optimum glue joints	in conjunction with profile knife Ident-No. 165916 packing unit: 10 pieces		
Chamfer \sphericalangle	$\varnothing D$	S	$\varnothing d$	Ident-No.	
15 [°]	25 [mm]	4.6 [mm]	5,4 [mm]	165918	

150578

Chamfering Turnover Knives HW with 4 cutting edges

Product		Drawing		LEUCO DUR	
				tungsten carbide [HW]	
Machine / Application	Design	Advantages	Notes		
for use in cutterheads for chamfering	cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods		packing unit: 10 pieces		
Chamfer \sphericalangle	$\varnothing D$	S	$\varnothing d$	Ident-No. [L]	Ident-No. [R]
45 [°]	25 [mm]	5 [mm]	7 [mm]	165966	165965

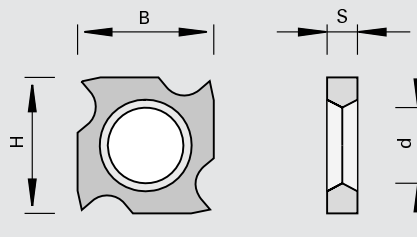
150508

Grooving Turnover Knives HW with 4 cutting edges - grooving cutterheads

Product



Drawing



tungsten carbide [HW]

Machine / Application

| for use in grooving cutterheads

Design

| cutting material: HW
| HL Solid 15 for wood-based panels, hard and soft woods

Advantages

Notes

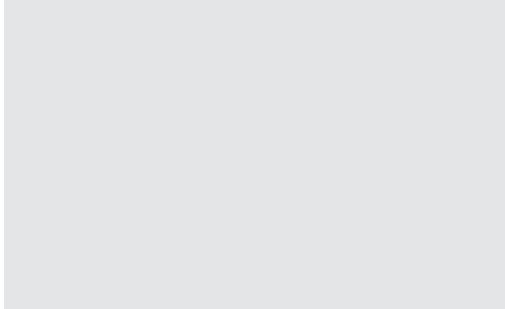
| Ident-No. 163699 for groove width 4 mm
| Ident-No. 165906 for groove width 5 mm
| Ident-No. 169250 for groove width > 7 mm
| packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
18	18	1.95	10	163699
18	18	2.5	10	165906
18	18	3.7	10	169250
[mm]	[mm]	[mm]	[mm]	

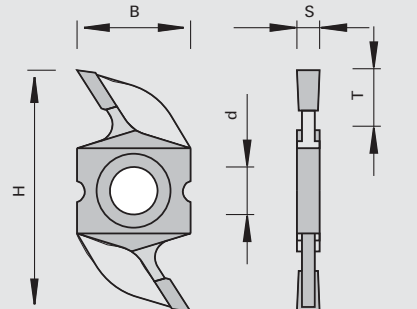
150509

Grooving Turnover Knives HW with 2 cutting edges and positioning groove

Product



Drawing



tungsten carbide [HW]

Machine / Application

| for use in cutterheads for grooving

Design

| bore countersunk 90 degrees
| cutting material: HW
| HL Solid 30 and HL Solid 40 for hard and soft woods

Advantages

| high accuracy thanks to radial positioning
| more simple handling

Notes

| spacer rings for the adjustment of the rounding knives see chapter replacement parts
| packing unit 10 pieces

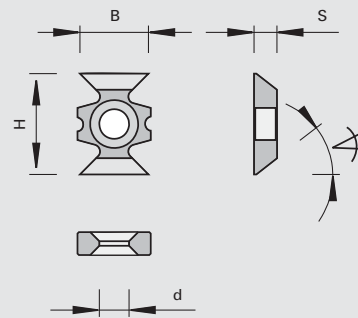
B	H	S	Ø d	Tmax	LEUCODUR	Ident-No.	
13	36	3.5	7,4	10	HL Solid 30	no radial positioning	165968
16	34	3.2	6,7	8	HL Solid 40		183663
16	34	3.5	6,7	8	HL Solid 40		183664
16	34	4	6,7	8	HL Solid 40		183665
16	34	5	6,7	8	HL Solid 40		183666
[mm]	[mm]	[mm]	[mm]	[mm]			

150578

Chamfering Turnover Knives HW with 4 cutting edges and positioning groove

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in cutterheads for chamfering

Design

cutting material: HW
HL Solid 15 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
more simple handling

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the chamfer knives see chapter replacement parts
packing unit: 10 pieces

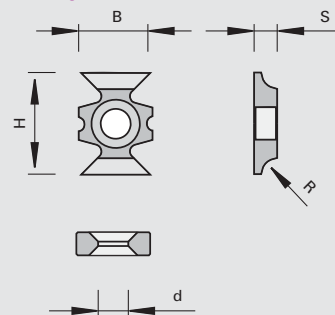
Chamfer [°]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Ident-No.
45	16	22	5	6,5	183668

150578

Rounding Turnover Knives HW with 4 cutting edges and positioning groove

Product

Drawing



tungsten carbide [HW]

Machine / Application

for use in cutterheads for rounding

Design

cutting material: HW
HL Solid 15 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
radii are interchangeable
more simple handling


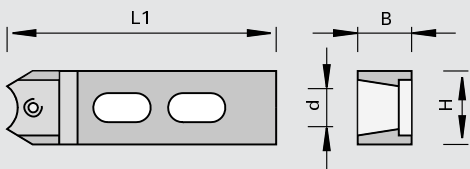

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the rounding knives see chapter replacement parts
packing unit: 10 pieces

R [mm]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Ident-No.
1,5	16	22	5	6,5	183669
2	16	22	5	6,5	183670
2,5	16	22	5	6,5	183671
3	16	22	5	6,5	183672

132891

Scrapper Holders - Homag, Reich, IMA

Product	Drawing	
		 tungsten carbide [HW]

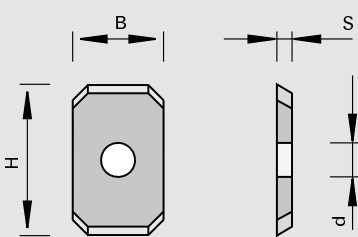

Machine / Application	Design	Advantages	Notes
edge banding machines Homag, Reich for installation of LEUCODUR radius-, chamfering- and scrapper turnover knives			

B	H	Ø d	L1		Ident-No.	
for R ≤ 5	15	16	6,5	131	Homag, Reich	169252
for R ≤ 5	22	14	6,5	118	Homag	179463
[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Round Head Screws	M4x5,9 T15	995195	167966
Screwdrivers	T15	985730	163161
Screwdrivers	T15x80	985730	171188
	[mm]		

151555

Scrapper Turnover Knives HW with 2 cutting edges and chamfer - Homag, IMA, Reich

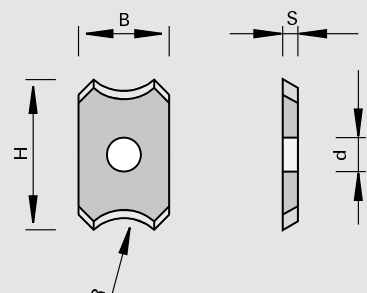

Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
edge banding machines Homag, IMA, Reich for use in scrapper holders	chamfer angle 45 degrees cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

B	H	S	Ø d		Ident-No.
12	20	2	4		171180
[mm]	[mm]	[mm]	[mm]		

15 1555

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag, HOLZ-HER, Reich

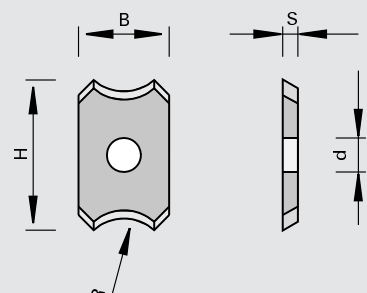


Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag, HOLZ-HER, Reich for use in scraper holders 	<ul style="list-style-type: none"> 6 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
0,8	12	20	2	4	171401 s
1	12	20	2	4	169253
1,5	12	20	2	4	169254
2	12	20	2	4	169255
2,5	12	20	2	4	169256
3	12	20	2	4	169257
4	12	20	2	4	169259 #
5	12	20	2	4	169261
[mm]	[mm]	[mm]	[mm]	[mm]	

15 1755

Scrapper Turnover Knives HW with 2 cutting edges and radius - Homag,HOLZ-HER, Reich (chamfer to prevent material fracturing)

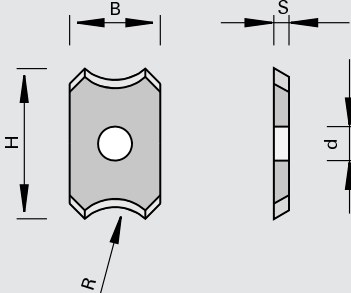

Product	Drawing	
		  tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag, HOLZ-HER, Reich for use in scraper holders 	<ul style="list-style-type: none"> 6 degree profile run-out special scraper which avoids material fracturing cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods 	<ul style="list-style-type: none"> no material fracturing also in the case of PP-edges no additional work steps needed 	<ul style="list-style-type: none"> packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	12	20	2	4	181234
2	12	20	2	4	181235
3	12	20	2	4	181237
[mm]	[mm]	[mm]	[mm]	[mm]	

151555

Scraper Turnover Knives HW with 2 cutting edges and radius - IMA

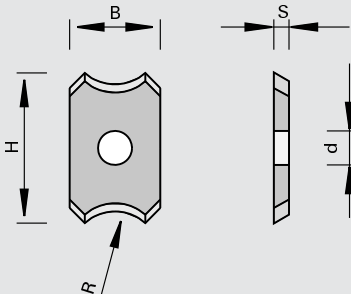


Product	Drawing	
		 tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
edge banding machines IMA for use in scraper holders	15 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
0,8	12	20	2	4	184788 s
1	12	20	2	4	178856
1,3	12	20	2	4	184791 s
1,5	12	20	2	4	185179
2	12	20	2	4	178957
2,5	12	20	2	4	184794 s
3	12	20	2	4	178857
[mm]	[mm]	[mm]	[mm]	[mm]	

151755

Scraper Turnover Knives HW with 2 cutting edges and radius - IMA (chamfer to prevent material fracturing)

Product	Drawing	
		  tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
edge banding machines IMA for use in scraper holders	15 degree profile run-out special scraper which avoids material fracturing cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods	no material fracturing also in the case of PP-edges no additional work steps needed	packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
0,8	12	20	2	4	184789 s
1	12	20	2	4	184790 s
1,3	12	20	2	4	184792 s
1,5	12	20	2	4	184793 s
2	12	20	2	4	181236
2,5	12	20	2	4	184795 s
3	12	20	2	4	181238
[mm]	[mm]	[mm]	[mm]	[mm]	

15 1586

Scrapper Turnover Knives HW with 2 cutting edges and radius - IMA (asymmetrical)

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines IMA for use in scraper holders 	<ul style="list-style-type: none"> asymmetrical 15 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods 		<ul style="list-style-type: none"> packing unit: 10 pieces

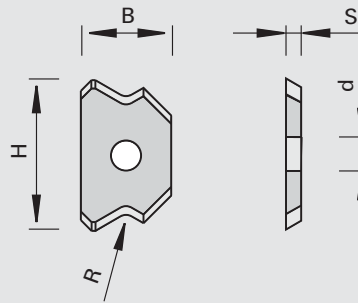
R	B	H	S	Ø d	Ident-No.
0,8	12	20	2	4	184796 s
1	12	20	2	4	184798 s
1,3	12	20	2	4	184800 s
1,5	12	20	2	4	184802 s
2	12	20	2	4	184804 s
2,5	12	20	2	4	184807 s
3	12	20	2	4	184809 s
[mm]	[mm]	[mm]	[mm]	[mm]	

151755

Scraper Turnover Knives HW with 2 cutting edges and radius - IMA (asymmetrical, chamfer to prevent material fracturing)

Product

Drawing



tungsten carbide [HW]

Machine / Application

edge banding machines IMA
for use in scraper holders

Design

asymmetrical
15 degree profile run-out
cutting edge with chamfer to prevent material fracturing
cutting material: HW
HL Board 05 for wood-based panels, plastics and hard woods

Advantages

no material fracturing also in the case of PP-edges
no additional work steps needed

Notes

packing unit: 10 pieces

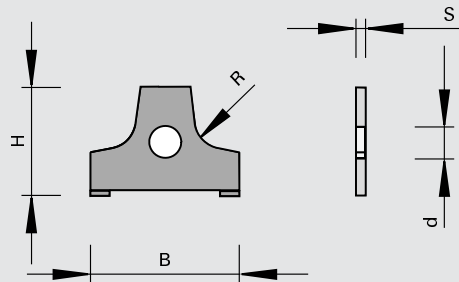
R	B	H	S	Ø d	Ident-No.
0,8	12	20	2	4	184797 s
1	12	20	2	4	184799 s
1,3	12	20	2	4	184801 s
1,5	12	20	2	4	184803 s
2	12	20	2	4	184806 s
2,5	12	20	2	4	184808 s
3	12	20	2	4	184810 s
[mm]	[mm]	[mm]	[mm]	[mm]	

15 1586

Scrapper Knives HW with 2 cutting edges and radius - working centers (avoids material fracturing)

Product

Drawing



tungsten carbide [HW]

Machine / Application

l machines Homag combined with flush-cutting unit No. 1-056-11-0621

Design

l 6 degree profile run-out
l cutting material: HW
l HL Board 06 for wood-based panels, plastics and hard woods
l special scrapper which avoids material fracturing

Advantages

l no material fracturing also in the case of PP-edges
l no additional work steps needed

Notes

l packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	20	11.5	2	5	180025 s
2	20	11.5	2	5	180020 s
2,5	20	11.5	2	5	180021 s
3	20	11.5	2	5	180022 s
4	20	11.5	2	5	185295 s
[mm]	[mm]	[mm]	[mm]	[mm]	

R	B	H	S	Ø d	Ident-No.
1	20	11.5	2	5	topline 185159 s
1,5	20	11.5	2	5	topline 185160 s
2	20	11.5	2	5	topline 185161 s
2,5	20	11.5	2	5	topline 185162 s
3	20	11.5	2	5	topline 185163 s
[mm]	[mm]	[mm]	[mm]	[mm]	

151586

Scaper Knives HW with 2 cutting edges and chamfer (glue joint) - working centers

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
machines Homag combined with flush-cutting unit No. 1-056-11-0621	cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

Chamfer \sphericalangle	B	H	S	\varnothing d	Ident-No.
3	20	11.5	2	5	180023 s
15	20	11.5	2	5	180210 s
30	20	11.5	2	5	180211 s
45	20	11.5	2	5	185296 s
[°]	[mm]	[mm]	[mm]	[mm]	

151586

Chip Breakers HW for Scaper Knives

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
machines Homag combined with flush-cutting unit No. 1-056-11-0621	6 degree profile run-out cutting material: HW HL Board 06 for wood-based panels, plastics and hard woods		packing unit: 10 pieces

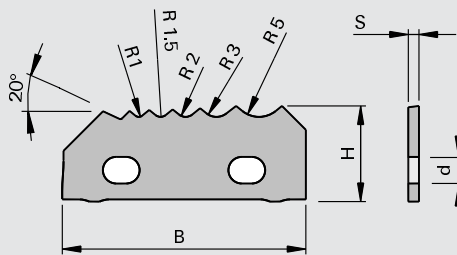
R	B	H	S	\varnothing d	Ident-No.
1,3 [mm]	20 [mm]	11.5 [mm]	2 [mm]	5 [mm]	180024

151586

Scraper Knives HW with 5 cutting edge and chamfer

Product

Drawing



tungsten carbide [HW]

Machine / Application

machines Homag with scraping unit Type MN 20

Design

chamfer 20 degrees, R1, R1,5, R2, R3, R5
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Notes

Ident-No. 180755 can be applied on the left lower or the right upper side
Ident-No. 180754 can be applied on the left upper or the right lower side
packing unit: 10 pieces

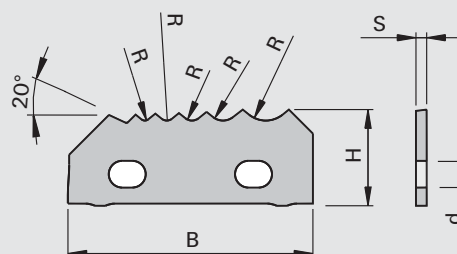
R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]
1-5	45,8	17.98	2	5	180755	180754
[mm]	[mm]	[mm]	[mm]	[mm]		

151786

Scraper Turnover Knives HW with 5 radii and chamfer - to prevent material fracturing

Product

Drawing



tungsten carbide [HW]

Machine / Application

machines Homag with scraping unit Type MN 20

Design

chamfer 20 degree, R1, R1,5, R2, R3, R5 or chamfer 20 degree, R1, R1,5, R2, R2,5, R3
cutting edge with chamfer to prevent material fracturing
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods
Topline (polished face and micro-ground clearance angle)

Advantages

no material fracturing also in the case of PP-edges
no additional work steps needed

Notes

Ident-No. 181239 and 184669 can be applied on the left lower or the right upper side
Ident-No. 181240 and 184670 can be applied on the left upper or the right lower side
packing unit 10 pieces

R	B	H	S	Ø d	Ident-No. [L]	Ident-No. [R]	
1; 1,5; 2; 3; 5	45,8	17.98	2	5	Topline	181240	181239
1; 1,5; 2; 2,5; 3	45,8	17.02	2	5		184670	184669
[mm]	[mm]	[mm]	[mm]	[mm]			

151548

Scaper Knives HW with 1 cutting edge and chamfer

Product	Drawing	
		tungsten carbide [HW]

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines IMA units 181.91 and 0.6126 (BAZ) with 30 mm width, unit 08.50 with 55 mm width 	<ul style="list-style-type: none"> cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods 		<ul style="list-style-type: none"> packing unit: 2 pieces

Chamfer \sphericalangle	B	H	S	\varnothing d	Ident-No. [L]	Ident-No. [R]
15	30	22.5	3	5,8	178859	178858
15	55	25	3	5,8	178861	178860
[°]	[mm]	[mm]	[mm]	[mm]		

132821

Glue Joint Scaper Turnover Knives (flat scaper) HW - Homag aggregate FA10, FA11, FA12


Product	Drawing	
		tungsten carbide [HW]

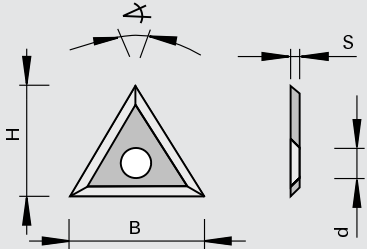
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines Homag aggregate FA10, FA11, FA12 	<ul style="list-style-type: none"> HW-tipped cutting material: HW HL Solid 15 for wood-based panels, hard and soft woods 		<ul style="list-style-type: none"> packing unit: 2 pieces

Chamfer \sphericalangle	B	H	S	\varnothing d	Ident-No. [L]	Ident-No. [R]
15	32	55	4.5	5,8	178223	178224
[°]	[mm]	[mm]	[mm]	[mm]		

132821


Scrapper Turnover Knives HW with 3 cutting edges - Biesse

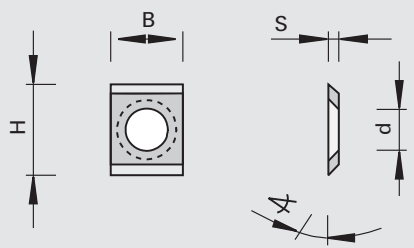
Product		Drawing			 tungsten carbide [HW]	
Machine / Application machines Biesse-Polymax		Design cutting material: HW HL Solid 30 for wood-based panels, hard and soft woods		Advantages 		Notes packing unit: 10 pieces
B	H	S	Ø d	Corner∠	LEUCODUR	Ident-No.
22,9 [mm]	19,8 [mm]	2,5 [mm]	6,4 [mm]	60 [°]	HL Solid 30	183685 o



150518

Scrapper Turnover Knives HW with 2 cutting edges - IMA

Product		Drawing			 tungsten carbide [HW]	
Machine / Application machines IMA		Design cutting material: HW HL Solid 25 for hard and soft woods		Advantages 		Notes packing unit: 10 pieces
B	H	S	Ø d			Ident-No.
11 [mm]	14,3 [mm]	2,5 [mm]	4 [mm]			184350



151515

Scrapper Turnover-Knives HW with 4 cutting edges - HOLZ-HER

Product		Drawing		LEUCO DUR tungsten carbide [HW]		
Machine / Application edge banding machines HOLZ-HER		Design cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		Advantages		
Notes packing unit: 10 pieces						
B	H	S	Ø d	Wedge◁	◁	Ident-No.
14	14	2	6,4	60	10	185180
[mm]	[mm]	[mm]	[mm]	[°]	[°]	

151586

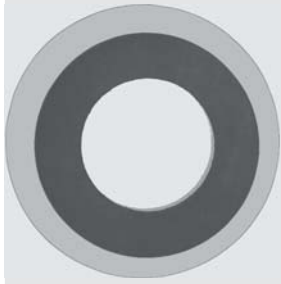
Scrapper Knives HW with 1 cutting edge and radius or chamfer - Ott

Product		Drawing		LEUCO DUR tungsten carbide [HW]		
Machine / Application edge banding machines Ott		Design 10 degree profile run-out cutting material: HW HL Board 05 for wood-based panels, plastics and hard woods		Advantages		
Notes packing unit: 2 pieces						
R	Chamfer◁	B	H	S		Ident-No.
1		12,29	13.49	3.3		185019
2		12,29	13.49	3.3		185020
3		12,29	13.49	3.3		185021
4		12,31	12.69	3.3		185022
5		12,31	12.4	3.3		185023
	30	12,83	12.86	3.3		185024
[mm]	[°]	[mm]	[mm]	[mm]		

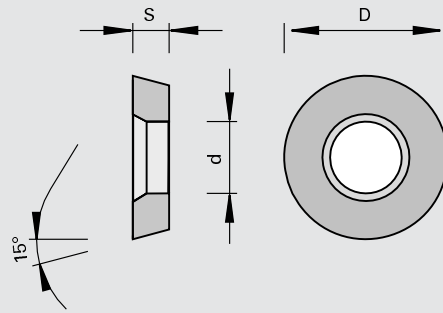
150503

Cup Knives HW

Product



Drawing



LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in side-and-face
cutterheads

Design

| cutting material: HW
| HL Board 03 for wood-based
panels and plastics

Advantages

| extremely long edge lives

Notes

| packing unit: 10 pieces

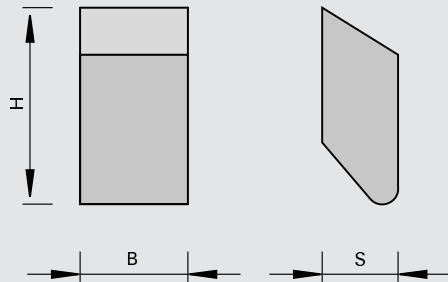
Ø D	S	Ø d	Ident-No.
11	4	5	173396
[mm]	[mm]	[mm]	

153306 / 153308

Saw Teeth HW for Circular Saw Blades - solder coated

Product

Drawing



LEUCODUR

tungsten carbide [HW]

Machine / Application

Design

- | solder-coated
- | cutting material: HW
- | HL Board 06 for wood-based panels, plastics and hard woods
- | HL Solid 15 for wood-based panels, hard and soft woods

Advantages

- | easy soldering during tooth installation thanks to solder coating

Notes

B	H	S	LEUCODUR	Ident-No.
2,7	7.1	2	HL Board 06	177493 s
2,8	8	2.3	HL Solid 15	177500 s
3,6	8	2.3	HL Board 06	177494
4,2	10.5	3.5	HL Solid 15	177501
4,5	8	2.3	HL Board 06	177495
4,3	10.5	3	HL Board 06	177496
5	10.5	3	HL Board 06	177497
5,4	10.5	3	HL Board 06	177498
6	12.5	4	HL Solid 15	177586
6,8	12.5	4	HL Board 06	177499
[mm]	[mm]	[mm]		

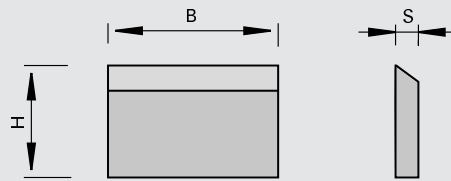
332121

Planing Knives HS

Product



Drawing



High Speed Steel [HS]

Machine / Application

| for use in planing cutterheads

Design

| cutting material: high speed steel (HS 18%) for soft woods
| wedge angle 40°

Advantages

Notes

| from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
| packing unit 2 pieces

B	H	S	Ident-No.
60	30	3	160593
80	30	3	160594
100	30	3	055647
110	30	3	160595 o
120	30	3	160596
130	30	3	006139
150	30	3	160597
170	30	3	160598
180	30	3	160599
210	30	3	160600
230	30	3	160601
260	30	3	006485
310	30	3	160602
310	35	3	165310
320	30	3	160603
320	35	3	165311 o
330	30	3	160604 o
330	35	3	165312
360	30	3	160605 o
360	35	3	165313 o
400	30	3	165307
400	35	3	165314 o
410	30	3	006486
410	35	3	006487
450	30	3	160606 o
450	35	3	165315 o
460	30	3	160607 o
460	35	3	165316 o
500	30	3	165308
500	35	3	165317
510	30	3	006488
510	35	3	006489
600	30	3	165309 o
600	35	3	165318 o
610	30	3	006490
610	35	3	006491
630	30	3	160608
630	35	3	165319
635	35	3	165320 o
640	30	3	160609
640	35	3	165321
[mm]	[mm]	[mm]	

B	H	S	Ident-No.
700	35	3	165322 o
710	30	3	160610 o
710	35	3	165323 o
740	35	3	165324 o
810	30	3	160612
810	35	3	165325
840	30	3	160613 o
1050	30	3	176331
1050	35	3	176332
1200	30	3	180535
[mm]	[mm]	[mm]	

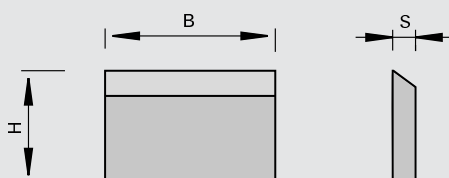
332121

Planing knife HS for hydro and jointing

Product



Drawing



High Speed Steel [HS]

Machine / Application

for use in hydro planing cutterheads

Design

cutting material: HS for soft woods
wedge angle 30° for jointing

Advantages

high run-out accuracy due to grinding the knives in the hydro planing cutterhead with following jointing process in the machine

Notes

from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
packing unit 2 pieces

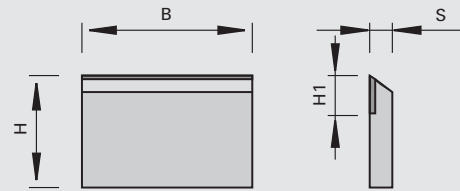
B	H	S	Ident-No.
130	30	3	182759 o
150	30	3	182760 o
170	30	3	182761 o
180	30	3	182762 o
190	30	3	182763 o
210	30	3	182764 o
230	30	3	182765 o
240	30	3	182766 o
270	30	3	182767 o
310	30	3	182768 o
[mm]	[mm]	[mm]	

132121

Planing Knives HW

Product

Drawing



tungsten carbide [HW]

Machine / Application

l for use in planing cutterheads

Design

l cutting material: HW-tipped for hard woods

Advantages

Notes

l from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
l packing unit 2 pieces

B	H	S	H1	Ident-No.
60	30	3	11	160586
80	30	3	11	006204
100	30	3	11	006205
110	30	3	11	165329 o
120	30	3	11	006206 o
130	30	3	11	006207
150	30	3	11	006208
170	30	3	11	006209
180	30	3	11	055649
210	30	3	11	006210 o
230	30	3	11	160588
240	30	3	11	182641
260	30	3	11	160589 o
310	30	3	11	055648
310	35	3	11	165338 o
320	30	3	11	165330 o
320	35	3	11	165339 o
330	30	3	11	165331 o
330	35	3	11	165340 o
360	30	3	11	165332 o
360	35	3	11	165341 o
400	35	3	11	165342 o
410	30	3	11	006211
410	35	3	11	165343 o
450	30	3	11	165333 o
450	35	3	11	165344 o
460	30	3	11	165334 o
460	35	3	11	165345 o
500	35	3	11	165346 o
510	30	3	11	006212
510	35	3	11	165347 o
600	35	3	11	165348 o
610	30	3	11	006704
610	35	3	11	165349 o
630	30	3	11	165335 o
630	35	3	11	165350 o
635	35	3	11	165351 o
640	30	3	11	165336 o
640	35	3	11	165352 o
700	35	3	11	165353 o
710	30	3	11	160590 o
[mm]	[mm]	[mm]	[mm]	

B	H	S	H1	Ident-No.
710	35	3	11	165354 o
740	30	3	11	165337 o
740	35	3	11	165355 o
810	30	3	11	160592
810	35	3	11	165356 o
[mm]	[mm]	[mm]	[mm]	

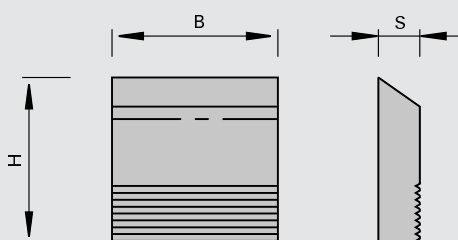
332511

Planing Knives with serrated back HS

Product



Drawing



High Speed Steel [HS]

Machine / Application

l for use in cutterheads with serration

Design

l cutting material: HS for soft woods

Advantages

Notes

- l from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
- l also for Weinig Powermat machines, RPM up to 12,000 min⁻¹
- l packing unit 2 pieces

B	H	S	Ident-No.
100	38	5	182096 s
130	38	5	182097 s
170	38	5	182098 s
190	38	5	182099 s
230	38	5	182100 s
240	38	5	182101 s
[mm]	[mm]	[mm]	

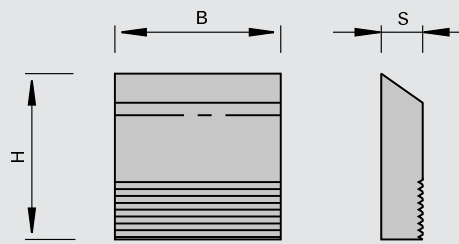
332511

Planing Knives with serrated back HS - Quicklock

Product



Drawing



High Speed Steel [HS]

Machine / Application

for use in hydro planing cutterheads Quicklock with serration

Design

cutting material: HS for soft woods

Advantages

Notes

from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
packing unit 2 pieces

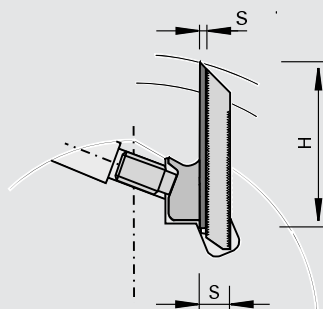
B	H	S	Ident-No.
100	30	4	183354 o
130	30	4	183355 o
150	30	4	183356 o
180	30	4	183357 o
210	30	4	183358 o
230	30	4	183359 o
240	30	4	183360 o
270	30	4	183361 o
310	30	4	183362 o
320	30	4	183363 o
100	35	4	183364 o
130	35	4	183365 o
150	35	4	183366 o
180	35	4	183367 o
210	35	4	183368 o
230	35	4	183369 o
240	35	4	183370 o
270	35	4	183371 o
310	35	4	183372 o
320	35	4	183373 o
[mm]	[mm]	[mm]	

152548

SetProfiler set - planing

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

- l molders
- l for use in profile cutterheads with serration

Design

- l n max = 12,000 min-1
- l cutting material: HW
- l HL Solid 30 Topline for hard and soft woods
- l HW Topcoat
- l Topline (polished face)

Advantages

- l significantly improved cutting edges
- l excellent cutting quality
- l compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
- l adjustable knives by means of serration between knife and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

- l from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
- l packing unit 2 pieces

B	H	S	Ident-No.
310	38	10	181974 o
[mm]	[mm]	[mm]	

Blanks	B	H	S	Class-No.	Ident-No.
HW Blanks	310	38	3.2	152548	181975 o
HW Topcoat Blanks	250	38	3.2	152548	181976 o
	[mm]	[mm]	[mm]		

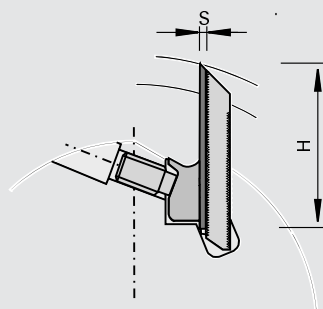
Support plates	B	Suitable for blank height	Class-No.	Ident-No.
	250	38	925400	181977 o
	310	38	925400	181978 o
	[mm]	[mm]		

152548

SetProfiler set - profiling

Product

Drawing

LEUCO
toplineLEUCO
DUR

tungsten carbide [HW]

Machine / Application

- | molders
- | for use in profile cutterheads with serration

Design

- | cutting material: HW
- | HL Solid 30 for hard and soft woods
- | HW Topcoat
- | Topline (polished face)

Advantages

- | significantly improved cutting edges
- | excellent cutting quality
- | compared to uncoated HW-Blanks the edge lives is 2 - 3 times as long
- | high economic efficiency thanks to reduced use of grinding wheels, as knives and support plates are profiled separately whereas only the knives are re-ground
- | adjustable knives by means of serration between knife and support plate; 5 adjustments of 1,6 mm = 8 mm sharpening area

Notes

- | serration 60 degrees and partition 1,6 mm for profiling of solid woods and wood-based panels
- | blank height 50 and 60 mm for RPM up to 12,000 min-2
- | T = profile depth
- | from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
- | packing unit 2 pieces

B	H	S	Tmax	Ident-No.
40	50	10	14	181637 o
50	50	10	14	181638 o
60	50	10	14	181639 o
70	50	10	14	181640 o
80	50	10	14	181641 o
100	50	10	14	182182 o
130	50	10	14	182183 o
150	50	10	14	182184 o
250	50	10	14	181642 o
40	60	10	24	181643 o
50	60	10	24	181644 o
60	60	10	24	181645 o
70	60	10	24	181646 o
80	60	10	24	181647 o
100	60	10	24	182322 o
130	60	10	24	182323 o
150	60	10	24	182324 o
250	60	10	24	181648 o
40	70	10	34	181649 o
50	70	10	34	181650 o
60	70	10	34	181651 o
70	70	10	34	181652 o
80	70	10	34	181653 o
250	70	10	34	181654 o
[mm]	[mm]	[mm]	[mm]	

HW Blanks Topline

B	H	S	T	Class-No.	Ident-No.
40	50	3.2	14	152548	181619
50	50	3.2	14	152548	181620 o
60	50	3.2	14	152548	181621
70	50	3.2	14	152548	181622 o
[mm]	[mm]	[mm]	[mm]		

HW Blanks Topline	B	H	S	T	Class-No.	Ident-No.
	80	50	3.2	14	152548	181623 o
	100	50	3.2	14	152548	182179
	130	50	3.2	14	152548	182180
	150	50	3.2	14	152548	182181 o
	250	50	3.2	14	152548	181624
	40	60	3.2	24	152548	181625
	50	60	3.2	24	152548	181626 o
	60	60	3.2	24	152548	181627
	70	60	3.2	24	152548	181628 o
	80	60	3.2	24	152548	181629
	100	60	3.2	24	152548	182319
	130	60	3.2	24	152548	182320 o
	150	60	3.2	24	152548	182321 o
	250	60	3.2	24	152548	181630
	40	70	3.2	34	152548	181631 o
	50	70	3.2	34	152548	181632 o
	60	70	3.2	34	152548	181633 o
	70	70	3.2	34	152548	181634 o
	80	70	3.2	34	152548	181635 o
	250	70	3.2	34	152548	181636
	[mm]	[mm]	[mm]	[mm]		
HW Topcoat Blanks	B	H	S	T	Class-No.	Ident-No.
	40	50	3.2	14	152548	181665 o
	50	50	3.2	14	152548	181666 o
	60	50	3.2	14	152548	181667 o
	70	50	3.2	14	152548	181668 o
	80	50	3.2	14	152548	181669 o
	100	50	3.2	14	152548	182188 o
	130	50	3.2	14	152548	182189 o
	150	50	3.2	14	152548	182190 o
	250	50	3.2	14	152548	181670 o
	40	60	3.2	24	152548	181671 o
	50	60	3.2	24	152548	181672 o
	60	60	3.2	24	152548	181673 o
	70	60	3.2	24	152548	181674 o
	80	60	3.2	24	152548	181675 o
	100	60	3.2	24	152548	182328 o
	130	60	3.2	24	152548	182329 o
	150	60	3.2	24	152548	182330 o
	250	60	3.2	24	152548	181676 o
	[mm]	[mm]	[mm]	[mm]		
Support plates	B	Suitable for blank height			Class-No.	Ident-No.
	40	50			925400	181820
	50	50			925400	181821 o
	60	50			925400	181822
	70	50			925400	181823
	80	50			925400	181824
	100	50			925400	182185
	130	50			925400	182186
	150	50			925400	182187 o
	250	50			925400	181825 o
	40	60			925400	181826
	50	60			925400	181827
	60	60			925400	181828
	70	60			925400	181829
	80	60			925400	181830
	100	60			925400	182325
	130	60			925400	182326 o
	150	60			925400	182327 o
	250	60			925400	181831 o
	40	70			925400	181832 o
	[mm]	[mm]				

Support plates	B	Suitable for blank height	Class-No.	Ident-No.
	50	70	925400	181833 o
	60	70	925400	181834 o
	70	70	925400	181835 o
	80	70	925400	181836 o
	250	70	925400	181837 o
	[mm]	[mm]		

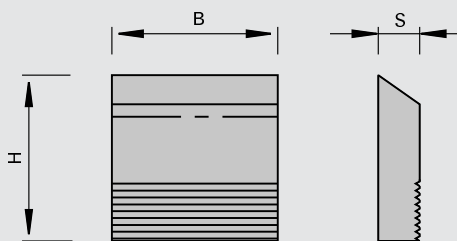
332511

Blanks with serrated back HS for profiling

Product



Drawing



High Speed Steel [HS]

Machine / Application

I for use in profile cutterheads with serration

Design

I cutting material: HS for soft woods

Advantages

Notes

I T = profile depth
 I from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
 I packing unit 2 pieces

B	H	S	Tmax	Ident-No.
40	50	8	12	163385
40	60	8	20	163386
40	70	8	30	163387
50	50	8	12	180533
50	60	8	20	180534
60	50	8	12	163388
60	60	8	20	163389
60	70	8	30	163390
80	50	8	12	163391
80	60	8	20	163392
80	70	8	30	163393
100	50	8	12	163394
100	60	8	20	163395
100	70	8	30	163396
130	50	8	12	163397
130	60	8	20	163398
130	70	8	30	163399
150	50	8	12	163400
150	60	8	20	163401
150	70	8	30	163402
180	50	8	12	163403
180	60	8	20	163404
180	70	8	30	163405
230	50	8	12	164495
230	60	8	20	164496 o
650	50	8	12	176318
650	60	8	20	176319
650	70	8	30	176320
[mm]	[mm]	[mm]	[mm]	

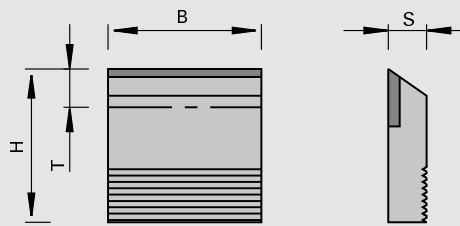
132511

Blanks with serrated back HW for profiling

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in profile cutterheads with serration

Design

HW-tipped for hard and exotic woods
tipping height 14 mm for blank height 50 mm, tipping height 20 mm for blank height 60 mm

Advantages

Notes

T = profile depth
from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
packing unit 2 pieces

B	H	S	Tmax	Ident-No.
40	50	10	13	165357
40	60	10	18	165365
60	50	10	13	165358
60	60	10	18	165366
80	50	10	13	165359 o
80	60	10	18	165367
100	50	10	13	165360
100	60	10	18	165368
130	50	10	13	165361 o
130	60	10	18	165369
150	50	10	13	165362 o
150	60	10	18	165370 o
180	50	10	13	165363 o
180	60	10	18	165371 o
230	50	10	13	165364 o
230	60	10	18	165372 o
[mm]	[mm]	[mm]	[mm]	

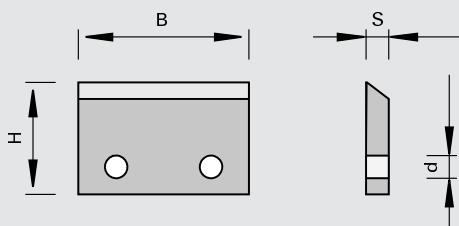
332521

Blanks HS and Deflector Blanks for profiling

Product



Drawing



High Speed Steel [HS]

Machine / Application

| for use in safety cutterheads

Design

| cutting material: HS for soft woods
| profile depth 15 mm max.

Advantages

Notes

| special steel deflector blanks

B	H	S	Ø d	Tmax	Ident-No.
40	45	4	6	15	163535
50	45	4	6	15	163513 o
[mm]	[mm]	[mm]	[mm]	[mm]	

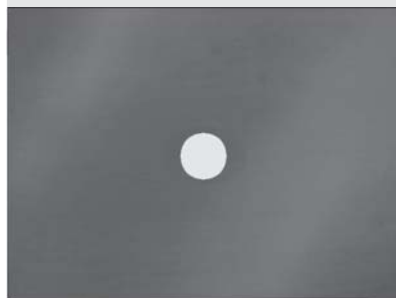
Deflectors for profiling

B	H	S	Ø d	T	Class-No.	Ident-No.
40	45	4	6	15	925400	163536
50	45	4	6	15	925400	163514 o
[mm]	[mm]	[mm]	[mm]	[mm]		

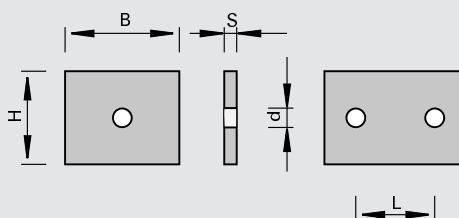
152555

Blanks HW - central bore

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
| precision ground
| cutting material: HW
| HL Board 05 for wood-based panels, plastics and hard woods

Advantages

Notes

| packing unit: 10 pieces

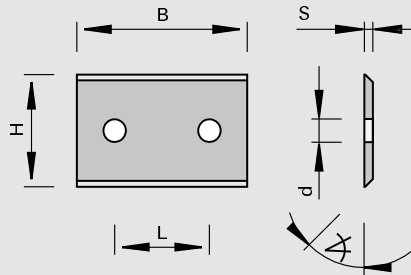
B	H	S	Ø d	L	Ident-No.
24	22	2	4,2		168821
28	24	2	4,2		168822 #
32	24	2	4,2		168823
36	28	2	4,2		168824
40	26	2	4,2		168825 #
42	32	2	4,2	24	168826
52	34	2	4,2	24	168828
[mm]	[mm]	[mm]	[mm]	[mm]	

152555

Blanks HW - central bore, ground on both sides

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
precision ground
| cutting material: HW
| HL Board 05 for wood-based
panels, plastics and hard
woods

Advantages

Notes

| packing unit: 10 pieces

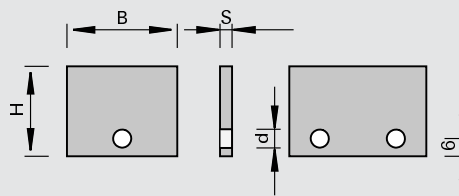
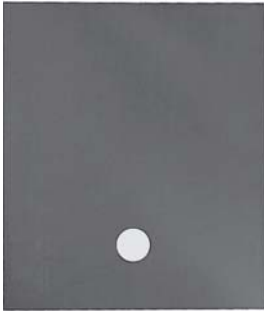
B	H	S	Ø d	L	Wedge	Ident-No.
30	25	2	4,2	20	55	168871 #
40	30	2	4,2	20	55	168872
50	45	2	4,2	34	55	168873
60	25	2	4,2	26	55	168836
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

152545

Blanks HW - bore not central

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
precision ground
| cutting material: HW
| HL Board 05 for wood-based
panels, plastics and hard
woods

Advantages

Notes

| packing unit: 10 pieces

B	H	S	Ø d	L	Ident-No.
18	18.3	2	4,2		168829
20	25.3	2	4,2		168830
24	28.3	2	4,2		168831
32	22.3	2	4,2		168832
40	30.3	2	4,2		168833
50	32.3	2	4,2	24	168834
[mm]	[mm]	[mm]	[mm]	[mm]	

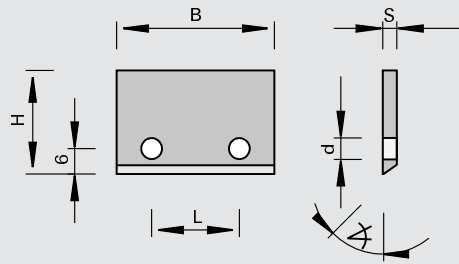
152545

Blanks HW - bore not central, ground seating surface

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

| for use in profile cutterheads

Design

| width, height, and thickness
 precision ground
 | cutting material: HW
 | HL Board 05 for wood-based
 panels, plastics and hard
 woods

Advantages

Notes

| packing unit: 10 pieces

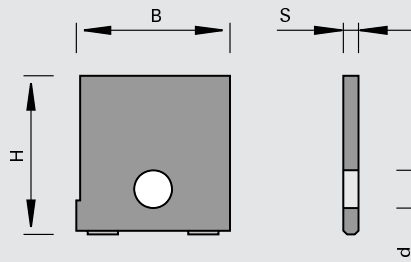
B	H	S	Ø d	L	Wedge α	Ident-No.
40	20.5	2	4,2	26	55	168838
52	27.5	2	4,2	26	55	168839
60	39.5	2	4,5	44	55	168840
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	

152586 / 152589

3P-Blanks HW (upright format)

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO EcoPro and special cutterheads

Design

two-point seating surface and point-stop
 optionally Topline (polished face)
 cutting material: HW
 HL Board 06 for wood-based panels, plastics and hard woods
 HL Solid 60 for soft woods

Advantages

precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead
 Topline design: highest cutting quality and significantly improved cutting edges

Notes

profile knife can be profiled per customer specifications
 packing unit: 10 pieces

B	H	S	Ø d	LEUCODUR	Ident-No.
12,5	20,5	2	5	HL Board 06	178509
15,5	20,5	2	5	HL Board 06	178510
15,5	25,5	2	5	HL Board 06	178511
16,4	20,5	2	5	HL Board 06	178512
16,7	25,9	2	5	HL Board 06	178513
18,4	18,9	2	5	HL Board 06	178514
18,4	25,9	2	5	HL Board 06	178515
18,4	36,3	2	5	HL Board 06	178516
20,3	20,5	2	5	HL Board 06	178517
20,3	25,5	2	5	HL Board 06	178518
20,3	30,4	2	5	HL Board 06	178519
22,3	25,5	2	5	HL Board 06	178520
24,3	20,9	2	5	HL Board 06	178521
24,3	28,4	2	5	HL Board 06	178522
25,3	25,9	2	5	HL Board 06	178523
25,3	35,3	2	5	HL Board 06	178524
28,2	25,5	2	5	HL Board 06	178525
28,2	35,3	2	5	HL Board 06	178526
12,5	20,5	2	5	HL Solid 60	179509
15,5	20,5	2	5	HL Solid 60	179510
15,5	25,5	2	5	HL Solid 60	179511
16,4	20,5	2	5	HL Solid 60	179512
16,7	25,9	2	5	HL Solid 60	179513
18,4	18,9	2	5	HL Solid 60	179514
18,4	25,9	2	5	HL Solid 60	179515
18,4	36,3	2	5	HL Solid 60	179516
20,3	20,5	2	5	HL Solid 60	179517
20,3	25,5	2	5	HL Solid 60	179518
20,3	30,4	2	5	HL Solid 60	179519
22,3	25,5	2	5	HL Solid 60	179520
24,3	20,9	2	5	HL Solid 60	179521 #
24,3	28,4	2	5	HL Solid 60	179522
25,3	25,9	2	5	HL Solid 60	179523
25,3	35,3	2	5	HL Solid 60	179524
28,2	25,5	2	5	HL Solid 60	179525
28,2	35,3	2	5	HL Solid 60	179526
[mm]	[mm]	[mm]	[mm]		

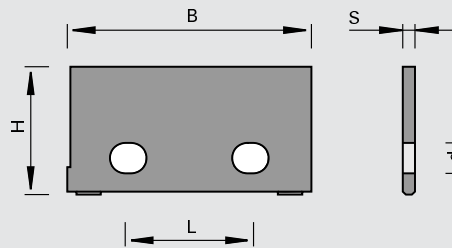
B	H	S	Ø d	LEUCODUR	Ident-No. [L]	Ident-No. [R]
12,5	20.5	2	5	HL Board 06 Topline	179547 &	179548
15,5	20.5	2	5	HL Board 06 Topline	179549 &	179550 &
15,5	25.5	2	5	HL Board 06 Topline	179551 &	179552 &
16,4	20.5	2	5	HL Board 06 Topline	179553 &	179554 &
16,7	25.9	2	5	HL Board 06 Topline	179555 &	179556 &
18,4	18.9	2	5	HL Board 06 Topline	179557 &	179558 &
18,4	25.9	2	5	HL Board 06 Topline	179559 &	179560 &
18,4	36.3	2	5	HL Board 06 Topline	179561 &	179562 &
20,3	20.5	2	5	HL Board 06 Topline	179563 &	179564 &
20,3	25.5	2	5	HL Board 06 Topline	179565 &	179566 &
20,3	30.4	2	5	HL Board 06 Topline	179567 &	179568 &
22,3	25.5	2	5	HL Board 06 Topline	179569 &	179570 &
24,3	20.9	2	5	HL Board 06 Topline	179571 &	179572 &
24,3	28.4	2	5	HL Board 06 Topline	179573 &	179574 &
25,3	25.9	2	5	HL Board 06 Topline	179575	179576
25,3	35.3	2	5	HL Board 06 Topline	179577 &	179578 &
28,2	25.5	2	5	HL Board 06 Topline	179579	179580
28,2	35.3	2	5	HL Board 06 Topline	179581 &	179582 &
12,5	20.5	2	5	HL Solid 60 Topline	179621 &	179622 &
15,5	20.5	2	5	HL Solid 60 Topline	179623 &	179624 &
15,5	25.5	2	5	HL Solid 60 Topline	179625 &	179626 &
16,4	20.5	2	5	HL Solid 60 Topline	179627 &	179628 &
16,7	25.9	2	5	HL Solid 60 Topline	179629 &	179630 &
18,4	18.9	2	5	HL Solid 60 Topline	179631 &	179632 &
18,4	25.9	2	5	HL Solid 60 Topline	179633 &	179634 &
18,4	36.3	2	5	HL Solid 60 Topline	179635 &	179636 &
20,3	20.5	2	5	HL Solid 60 Topline	179637 &	179638 &
20,3	25.5	2	5	HL Solid 60 Topline	179639 &	179640 &
20,3	30.4	2	5	HL Solid 60 Topline	179641 &	179642 &
22,3	25.5	2	5	HL Solid 60 Topline	179643 &	179644 &
24,3	20.9	2	5	HL Solid 60 Topline	179645 &	179646 &
24,3	28.4	2	5	HL Solid 60 Topline	179647 &	179648 &
25,3	25.9	2	5	HL Solid 60 Topline	179649 &	179650 &
25,3	35.3	2	5	HL Solid 60 Topline	179651 &	179652 &
28,2	25.5	2	5	HL Solid 60 Topline	179653 &	179654 &
28,2	35.3	2	5	HL Solid 60 Topline	179655 &	179656 &
[mm]	[mm]	[mm]	[mm]			

152586 / 152589

3P-Blanks HW (horizontal format)

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO EcoPro and special cutterheads

Design

two-point seating surface and point-stop
 optionally Topline (polished face)
 cutting material: HW
 HL Board 06 for wood-based panels, plastics and hard woods
 HL Solid 60 for soft woods

Advantages

precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead
 Topline design: highest cutting quality and significantly improved cutting edges

Notes

profile knife can be profiled per customer specifications
 packing unit: 10 pieces

B	H	S	Ø d	L	LEUCODUR	Ident-No.
30,2	25.5	2	5	11,8 - 13,8	HL Board 06	178527
30,2	30.4	2	5	11,8 - 13,8	HL Board 06	178528
32,2	22.8	2	5	11,8 - 13,8	HL Board 06	178529
32,2	35.4	2	5	11,8 - 13,8	HL Board 06	178530
32,8	47.2	2	5	11,8 - 13,8	HL Board 06	178531
35,2	26	2	5	11,8 - 13,8	HL Board 06	178532
40,1	20.9	2	5	21,7 - 25,5	HL Board 06	178533
40,1	30.4	2	5	21,7 - 25,5	HL Board 06	178534
40,8	36	2	5	21,7 - 25,5	HL Board 06	178535
42,8	31	2	5	21,7 - 25,5	HL Board 06	178536
42,8	36	2	5	21,7 - 25,5	HL Board 06	178537
45,8	36	2	5	21,7 - 25,5	HL Board 06	178538
49,9	20.9	2	5	21,7 - 25,5	HL Board 06	178539
49,9	33	2	5	21,7 - 25,5	HL Board 06	178540
49,9	40.2	2	5	21,7 - 25,5	HL Board 06	178541
60,6	25.8	2	5	26 - 22	HL Board 06	178542
59,8	35.4	2	5	25,5 + 43,2	HL Board 06	178543
80,6	35.8	2	5	44	HL Board 06	178544
30,2	25.5	2	5	11,8 - 13,8	HL Solid 60	179527
30,2	30.4	2	5	11,8 - 13,8	HL Solid 60	179528
32,2	22.8	2	5	11,8 - 13,8	HL Solid 60	179529
32,2	35.4	2	5	11,8 - 13,8	HL Solid 60	179530
32,8	47.2	2	5	11,8 - 13,8	HL Solid 60	179531
35,2	26	2	5	11,8 - 13,8	HL Solid 60	179532
40,1	20.9	2	5	21,7 - 25,5	HL Solid 60	179533
40,1	30.4	2	5	21,7 - 25,5	HL Solid 60	179534
40,8	36	2	5	21,7 - 25,5	HL Solid 60	179535
42,8	31	2	5	21,7 - 25,5	HL Solid 60	179536
42,8	36	2	5	21,7 - 25,5	HL Solid 60	179537
45,8	36	2	5	21,7 - 25,5	HL Solid 60	179538
49,9	20.9	2	5	21,7 - 25,5	HL Solid 60	179539
49,9	33	2	5	21,7 - 25,5	HL Solid 60	179540
49,2	40.2	2	5	21,7 - 25,5	HL Solid 60	179541
60,6	25.8	2	5	26 - 22	HL Solid 60	179542
59,8	35.4	2	5	25,5 + 43,2	HL Solid 60	179543
80,6	35.8	2	5	44	HL Solid 60	179544 #
[mm]	[mm]	[mm]	[mm]	[mm]		

B	H	S	Ø d	L	LEUCODUR	Ident-No. [L]	Ident-No. [R]
30,2	25.5	2	5	11,8 - 13,8	HL Board 06 Topline	179583 &	179584 &
30,2	30.4	2	5	11,8 - 13,8	HL Board 06 Topline	179585 &	179586 &
32,2	22.8	2	5	11,8 - 13,8	HL Board 06 Topline	179587 &	179588 &
32,2	35.4	2	5	11,8 - 13,8	HL Board 06 Topline	179589 &	179590 &
32,8	47.2	2	5	11,8 - 13,8	HL Board 06 Topline	179591 &	179592 &
35,2	26	2	5	11,8 - 13,8	HL Board 06 Topline	179593	179594 &
40,1	20.9	2	5	21,7 - 25,5	HL Board 06 Topline	179595 &	179596 &
40,1	30.4	2	5	21,7 - 25,5	HL Board 06 Topline	179597 &	179598 &
40,8	36	2	5	21,7 - 25,5	HL Board 06 Topline	179599 &	179600 &
42,8	31	2	5	21,7 - 25,5	HL Board 06 Topline	179601 &	179602 &
42,8	36	2	5	21,7 - 25,5	HL Board 06 Topline	179603 &	179604 &
45,8	36	2	5	21,7 - 25,5	HL Board 06 Topline	179605 &	179606 &
49,9	20.9	2	5	21,7 - 25,5	HL Board 06 Topline	179607 &	179608 &
49,9	33	2	5	21,7 - 25,5	HL Board 06 Topline	179609 &	179610 &
49,9	40.2	2	5	21,7 - 25,5	HL Board 06 Topline	179611 &	179612 &
60,6	25.8	2	5	22 - 26	HL Board 06 Topline	179613 &	179614 &
59,8	35.4	2	5	25,5 + 43,2	HL Board 06 Topline	179615 &	179616 &
80,6	35.8	2	5	44	HL Board 06 Topline	179617 &	179618 &
30,2	25.5	2	5	11,8 - 13,8	HL Solid 60 Topline	179657 &	179658 &
30,2	30.4	2	5	11,8 - 13,8	HL Solid 60 Topline	179659 &	179660 &
32,2	22.8	2	5	11,8 - 13,8	HL Solid 60 Topline	179661 &	179662 &
32,2	35.4	2	5	11,8 - 13,8	HL Solid 60 Topline	179663	179664 &
32,8	47.2	2	5	11,8 - 13,8	HL Solid 60 Topline	179665 &	179666 &
35,2	26	2	5	11,8 - 13,8	HL Solid 60 Topline	179667	179668
40,1	20.9	2	5	21,7 - 25,5	HL Solid 60 Topline	179669 &	179670 &
40,1	30.4	2	5	21,7 - 25,5	HL Solid 60 Topline	179671 &	179672 &
40,8	36	2	5	21,7 - 25,5	HL Solid 60 Topline	179673 &	179674 &
42,8	31	2	5	21,7 - 25,5	HL Solid 60 Topline	179675 &	179676 &
42,8	36	2	5	21,7 - 25,5	HL Solid 60 Topline	179677 &	179678 &
45,8	36	2	5	21,7 - 25,5	HL Solid 60 Topline	179679 &	179680 &
49,9	20.9	2	5	21,7 - 25,5	HL Solid 60 Topline	179681 &	179682 &
49,9	33	2	5	21,7 - 25,5	HL Solid 60 Topline	179683 &	179684 &
49,9	40.2	2	5	21,7 - 25,5	HL Solid 60 Topline	179685 &	179686 &
60,6	25.8	2	5	22 - 26	HL Solid 60 Topline	179687 &	179688 &
59,8	35.4	2	5	25,5 + 43,2	HL Solid 60 Topline	179689 &	179690 &
80,6	35.8	2	5	44	HL Solid 60 Topline	179691 &	179692 &
[mm]	[mm]	[mm]	[mm]	[mm]			

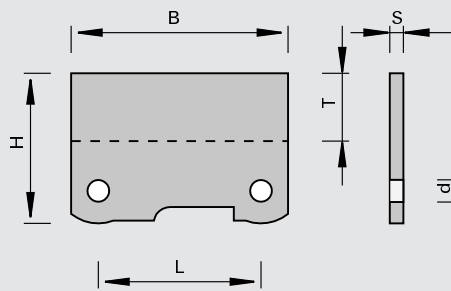
152526 / 152529

SuperProfiler Blanks HW

Product



Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO SuperProfiler cutterheads

Design

thickness ground
optionally Topline (polished face)
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods
HL Solid 60 for soft woods

Advantages

Topline design: highest cutting quality and significantly improved cutting edges

Notes

for concave and convex profiles
T = maximum profile depth

B	H	S	Ø d	L	Tmax	LEUCODUR	Ident-No.
30,6	25.5	1.5	4	16 - 20	13	HL Board 06	179114
30,6	25.5	1.5	4	16 - 20	13	HL Solid 60	177369
40,6	28.2	1.5	4	28	13	HL Board 06	179112
40,6	28.2	1.5	4	28	13	HL Solid 60	177367
40,6	40.6	2	5	28	20	HL Board 06	179115
40,6	40.6	2	5	28	20	HL Solid 60	178844
49,3	33.7	1.5	4	35	16	HL Board 06	180199
60,8	30.2	1.5	4	48	15	HL Board 06	179113
60,8	30.2	1.5	4	48	15	HL Solid 60	177368
60,6	45.6	2	5	45	25	HL Board 06	179999
60,6	45.6	2	5	45	25	HL Solid 60	178845
80,6	45.6	2	6	65	25	HL Board 06	180016
80,6	45.6	2	6	65	25	HL Solid 60	180017
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

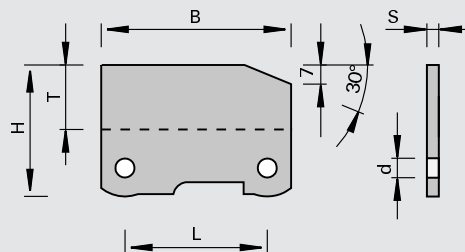
B	H	S	Ø d	L	Tmax	LEUCODUR	Ident-No. [L]	Ident-No. [R]
30,6	25.5	1.5	4	16 - 20	13	HL Board 06 topline	178701	178702
30,6	25.5	1.5	4	16 - 20	13	HL Solid 60 topline	177789	177790
40,6	28.2	1.5	4	28	13	HL Board 06 topline	178627	178626
40,6	28.2	1.5	4	28	13	HL Solid 60 topline	177791	177808
40,6	40.6	2	5	28	20	HL Board 06 topline	180030 &	180031
40,6	40.6	2	5	28	20	HL Solid 60 topline	180032 &	180033
49,3	33.7	1.5	4	35	16	HL Board 06 topline	180208	180209
60,8	30.2	1.5	4	48	15	HL Board 06 topline	178643	178628
60,8	30.2	1.5	4	48	15	HL Solid 60 topline	177809	177810
60,6	45.6	2	5	45	25	HL Board 06 topline	180034	180035
60,6	45.6	2	5	45	25	HL Solid 60 topline	180040 &	180041
80,6	45.6	2	6	65	25	HL Board 06 topline	180042	180043
80,6	45.6	2	6	65	25	HL Solid 60 topline	180044	180045
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

152526

SuperProfiler Blanks HW - B=50 mm

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO SuperProfiler cutterheads

Design

optionally Topline (polished face)
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

Topline design: highest cutting quality and significantly improved cutting edges

Notes

T = maximum profile depth

B	H	S	Ø d	L	Tmax	LEUCODUR	Ident-No.
49,4	44,5	2	5	35	22	HL Board 06	180218
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

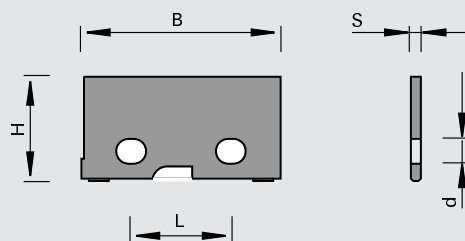
B	H	S	Ø d	L	Tmax	LEUCODUR	Ident-No. [L]	Ident-No. [R]
49,4	44,5	2	5	35	22	HL Board 06 topline	180219	180220
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

152536

PolyProfiler- / EcoPro-Blanks HW - B=40 mm

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

two-point seating surface and center stop for axial positioning
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

profile knife can be profiled per customer specifications
packing unit: 10 pieces

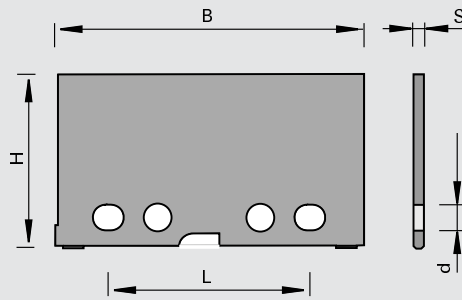
B	H	S	Ø d	L	Ident-No.
41	32,5	2	5	21,7-25,5	180197
[mm]	[mm]	[mm]	[mm]	[mm]	

152536

PolyProfiler- / EcoPro-Blanks HW - B=60 mm

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

- for use in LEUCO PolyProfiler and EcoPro cutterheads

Design

- two-point seating surface and center stop for axial positioning
- cutting material: HW
- HL Board 06 for wood-based panels, plastics and hard woods

Advantages

- precise positioning of the blanks for profiling and of the single-sided profile knife in the cutterhead

Notes

- profile knife can be profiled per customer specifications
- packing unit: 10 pieces

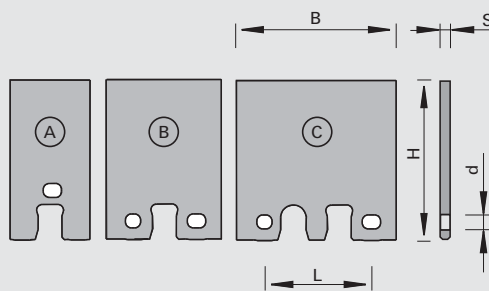
B	H	S	Ø d	L	Ident-No.
61 [mm]	34 [mm]	2 [mm]	5 [mm]	41,7-45,5 [mm]	180198

152516

UltraProfiler Blanks HW

Product

Drawing

LEUCO
DUR

tungsten carbide [HW]

Machine / Application

for use in LEUCO UltraProfiler cutterheads

Design

two-point seating and automatic positioning (axial and radial)
optionally Topline (polished face)
cutting material: HW
HL Board 06 for wood-based panels, plastics and hard woods

Advantages

precise and automatic positioning of the blanks for profiling and when changing the knives
no stop screw necessary
Topline design: highest cutting quality and significantly improved cutting edges

Notes

profile knife can be profiled per customer specifications
packing unit: 10 pieces

B	H	S	Ø d	L	Type	LEUCODUR	Ident-No.
15	30.4	2	3,5		A	HL Board 06	183056
20	40.4	2	3,5		A	HL Board 06	183057
25	40.4	2	3,5		A	HL Board 06	183058
32	40.4	2	3,5	15,8	B	HL Board 06	182419
40	40.4	2	3,5	26,8	C	HL Board 06	182420
50	40.4	2	3,5	32,8	C	HL Board 06	182421
60	40.4	2	3,5	36,8	C	HL Board 06	182422
[mm]	[mm]	[mm]	[mm]	[mm]			

B	H	S	Ø d	L	Type	LEUCODUR	Ident-No. [L]	Ident-No. [R]
15	30.4	2	3,5		A	HL Board 06 Topline	183680 o	183680 o
20	40.4	2	3,5		A	HL Board 06 Topline	183681 o	183681 o
25	40.4	2	3,5		A	HL Board 06 Topline	183682 o	183682 o
32	40.4	2	3,5	15,8	B	HL Board 06 Topline	182563	182562
40	40.4	2	3,5	26,8	C	HL Board 06 Topline	182565	182564
50	40.4	2	3,5	32,8	C	HL Board 06 Topline	182567	182566
60	40.4	2	3,5	36,8	C	HL Board 06 Topline	182569	182568
[mm]	[mm]	[mm]	[mm]	[mm]				





Clamping Systems

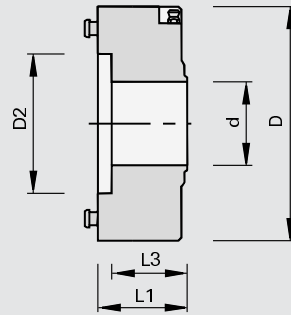
Product	Page
Quick-Clamping Systems	7-1
Attachment Sleeves and Flanges	7-16
Clamping Systems with cylindrical shank for shank-type tools	7-23
Clamping Systems with SK and BT shank for shank-type tools	7-31
Clamping Systems with SK and BT shank for tools with bore	7-41
Clamping Systems with HSK shank for shank-type tools	7-42
Clamping Systems with HSK shank for tools with bore	7-58
Clamping Systems with MK shank for shank-type tools	7-70
Clamping Systems for Drill Bits	7-72
LEUCO dusthoods	7-80
Mounting Devices	7-82
Technical Information	7-87

933011

Clamping Systems Ø 110 mm

Product

Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 110 mm

Design

- | hardened tool mounting area
- | n max = 9,000 min-1

Advantages

- | excellent balance quality
- | long tool life
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No. 997370
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: clamping part incl. cap for attachment on the machine spindle

Ø D	Ø D2	Ø d	L1	L3	DKN	Ident-No.
110	50	30	63	47.5	8x3	172399 &
110	50	30	63	47.5	8x3	Homag, Lehbrink, Torwegge, SPA, Wilmsmeyer 160836
110	50	35	63	47.5	10x4	Spanevello 162599
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

For Ident-No.

Class-No.

Ident-No.

Head Cap Screws	M12x30 DIN EN ISO 4762	172399	995111	001917
Covers		172399	997370	172397
Covers		160836	997370	181802
Covers		162599	997370	162602
Spacers	55x23,5x30	172399	955520	172398
pneumatic hose			994200	058250
	[mm]			

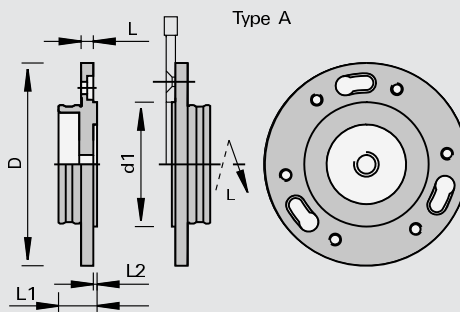
997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=65 mm

Product



Drawing



Machine / Application

for the mounting of saw blades up to Ø 250 mm with bore Ø 65 mm, 6 countersunk holes TK 90 mm for screw M 5

Design

Advantages

Notes

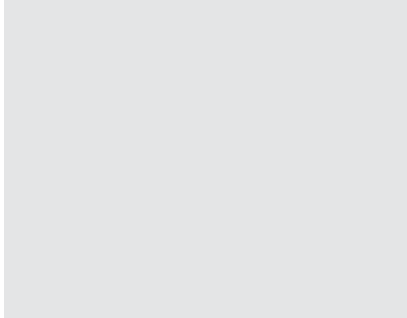
- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- for DP circular saw blades the cylindrical head screw Ident-No. 001869 is necessary (to be ordered separately)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	65	2,5	10	27	164770	164758
[mm]	[mm]	[mm]	[mm]	[mm]		
Spare parts	Dimension	Class-No.	Ident-No.			
Countersunk Flat Headed Screws	M5x12	995122	180007	for mounting of saw blade		
Head Cap Screws	M5x12 DIN 912	995111	001869	for mounting of DP saw blades		
	[mm]					

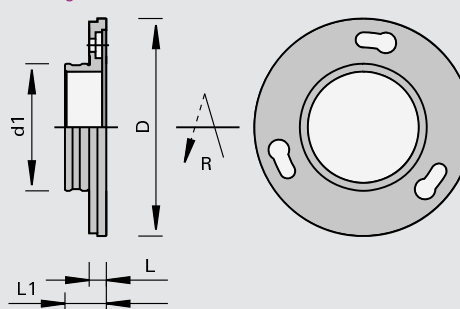
997370

Mounting Flanges for Clamping System Ø 110 mm - saw blades d=50 mm

Product



Drawing



Machine / Application

for the mounting of saw blades up to Ø 250 mm and saw plate thickness 1.8 - 2.2 mm with bore Ø 50 mm, 3 NL - Ø 22 mm, TK Ø 80 mm

Design

Advantages

Notes

- for clockwise and counter-clockwise rotation
- especially suited for the mounting of scoring saw blades

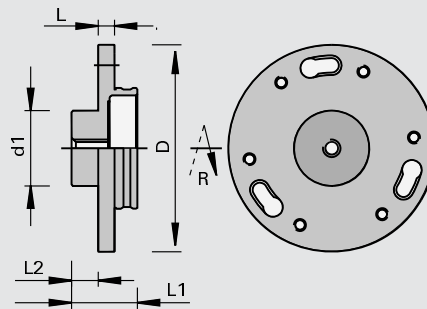
Ø D	Ø d1	L	L1	Ident-No.
107	50	10	26.5	160849
[mm]	[mm]	[mm]	[mm]	

997370

Mounting Flanges for Clamping System Ø 110 mm - tools with bore d=30 mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of light tools with bore Ø 30 mm, 6 countersunk holes for M 5, TK Ø 90 mm

for clockwise and counter-clockwise rotation
at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
110	30	15,5	10	40	163705	163226
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws	M5x12	995122	180007
Head Cap Screws	M5x12 DIN 912	995111	001869
	[mm]		

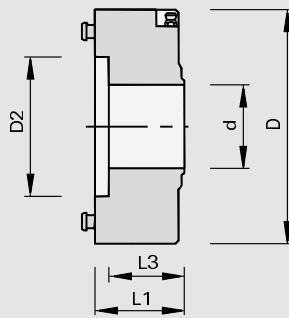
933011

Clamping Systems Ø 140 mm

Product



Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 140 mm

Design

- | n max = 9,000 min-1

Advantages

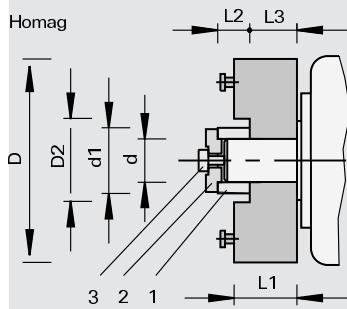
- | excellent balance quality
- | long tool life thanks to hardened tool mounting area
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

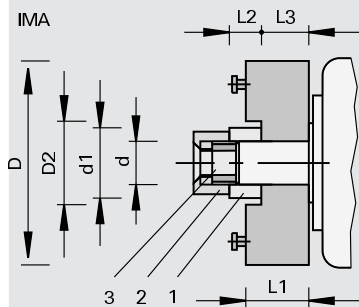
- | for clockwise and counter-clockwise rotation
- | mounting examples (see drawings): shaft with internal thread, shaft with external thread
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No. 997370
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

Ø D	Ø D2	Ø d	L1	L3	DKN		Ident-No.
140	80	30	57	41.5	8x3	Homag	167453
140	80	35	57	41.5	10x4	Homag, IMA	167451
140	80	40	57	41.5	12x5		167452
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Ø D	Ø D1	Ø d	For Ident-No.	Class-No.	Ident-No.
Covers	40	30	17	167453	997370	181802
Covers	45	35	22	167451	997370	180082
Covers	48	40	22	167452	997370	180121
Special Nuts	58		M30 x 1,5		995290	170364
	[mm]	[mm]	[mm]			



Spare parts	Dimension	Ø D	Ø d1	Ø D	For Ident-No.	Class-No.	Ident-No.
1 centering adapter				30	167453	997370	168457 s
2 caps		40	30	17	167453	997370	181802
1 centering adapter				35	167451	997370	180540
2 caps		45	35	22	167451	997370	180082
3 cylindrical head screws for Ød=30	M12x55R					995111	80068438
3 cylindrical head screws for Ød=30	M16x35L					995111	80068436
	[mm]	[mm]	[mm]	[mm]			



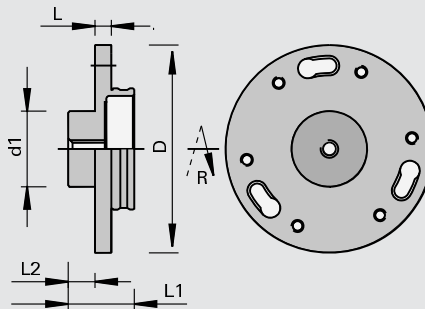
Spare parts	Ø D	Ø d	Dimension	Class-No.	Ident-No.
1 centering adapter		35		997370	180540
2 special nuts			M35x1,5	995290	IMA3
3 countersunk flat headed screws				995121	IMA4
4 spacers	70	35	70x25x35	955520	170363
	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System Ø 140 mm - tools with bore d=30 mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of medium-weight tools with bore Ø 30 mm, 6 countersunk holes for M 8, TK Ø 110 mm

- for clockwise and counter-clockwise rotation
- for S-System on shaft with internal thread
- indicate shaft design when placing an order
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)

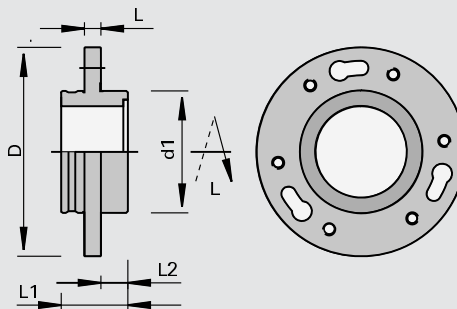
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	30	17,4	10,8	43,4	163946	163945
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System Ø 140 mm - tools with bore d=80 mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of medium-weight tools with bore Ø 80 mm, 6 countersunk holes for M 8, TK Ø 110 mm

- for clockwise and counter-clockwise rotation
- for S-System on shafts with external thread
- indicate shaft design when placing an order
- at least two separate tool/ flange assemblies should be used per clamping element (reduced downtimes)

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
137	80	17,5	11,8	44,7	168401	168400
[mm]	[mm]	[mm]	[mm]	[mm]		

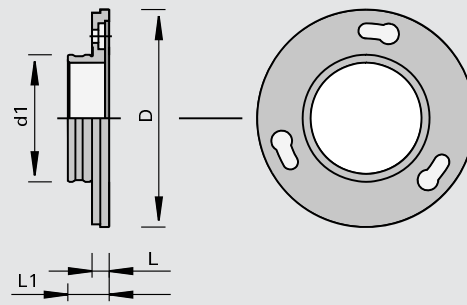
997370

Mounting Flanges for Clamping System Ø 140 mm - saw blades d=80 mm

Product



Drawing



Machine / Application

for the mounting of saw blades up to Ø 400 mm and saw plate thickness 1.8 - 2.2 mm with bore Ø 80 mm, 3 NL - Ø 22 mm, TK Ø 110 mm

Design

Advantages

Notes

for clockwise and counter-clockwise rotation

Ø D	Ø d1	L	L1	Ident-No.
137 [mm]	80 [mm]	10 [mm]	28 [mm]	177050

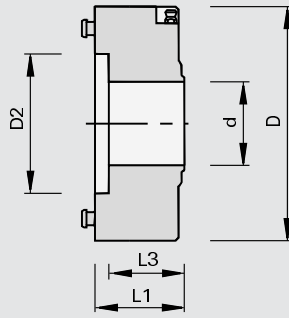
933011

Clamping Systems Ø 160 mm

Product



Drawing



Machine / Application

- double end tenoners
- through feed machines
- for mounting of tools with bore

Design

- $n_{max} = 9,000 \text{ min}^{-1}$

Advantages

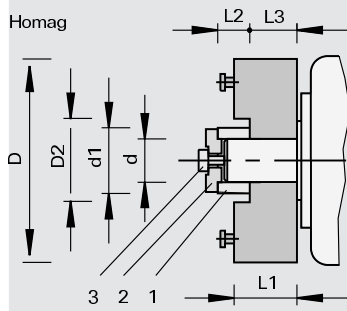
- excellent balance quality
- long tool life thanks to hardened tool mounting area
- consistent runout accuracy after each tool change
- minimization of setup-times thanks to easy and quick tool change
- maintenance-free and protected from dust

Notes

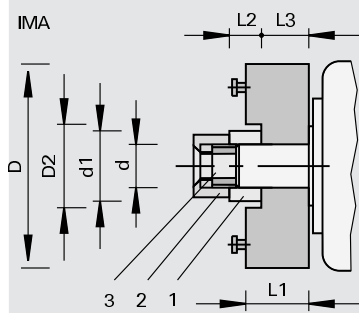
- for clockwise and counter-clockwise rotation
- mounting examples (see drawing): shaft with internal thread, shaft with external thread
- indicate machine type and shaft design when placing an order
- required tool adapters Class-No. 997370
- for changing the tools the pneumatic part Ident-No. 058250 is necessary
- operational pressure 6 bar
- included in delivery: clamping part incl. cap for attachment on the machine spindle (spare parts for Homag and IMA not included in delivery)

Ø D	Ø D2	Ø d	L1	L3	DKN		Ident-No.	
160	80	35	60	44.5	10x4	Homag, IMA	167462	
160	80	40	60	44.5	12x4		167463	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
Spare parts			Ø D	Ø D1	Ø d		Class-No.	Ident-No.
Covers			40	30	17		997370	181802
Covers			45	35	22		997370	180082
Covers			48	40	22		997370	180121
Special Nuts			58		M30 x 1,5		995290	170364
			[mm]	[mm]	[mm]			





Spare parts	Dimension	Ø D	Ø D1	Ø d	Class-No.	Ident-No.
1 centering adapter				30	997370	168457 s
2 caps		40	30	17	997370	181802
1 centering adapter				35	997370	180540
2 caps		45	35	22	997370	180082
3 cylindrical head screws for Ød=35	M16x55R				995111	80068439
3 cylindrical head screws for Ød=35	M20x35L				995111	80068437
4 spacers		60		35	955520	180647
	[mm]	[mm]	[mm]	[mm]		



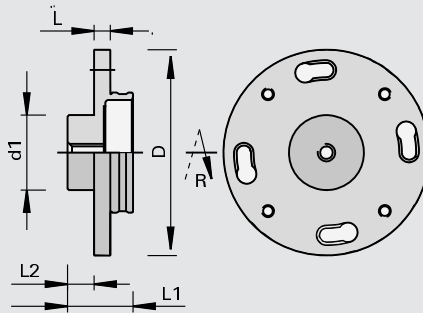
Spare parts	Ø D	Ø d	Dimension	Class-No.	Ident-No.
1 centering adapter		35		997370	180540
2 special nuts			M35x1,5	995290	IMA3
3 countersunk flat headed screws				995121	IMA4
4 spacers	70	35	70x25x35	955520	170363
	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System Ø 160 mm - tools with bore d=30 mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of heavy tools with bore Ø 30 mm with 4 countersunk holes M 8, TK Ø 130 mm

- for S-System on shaft with external thread
- for clockwise and counter-clockwise rotation
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- sense of rotation see drawing

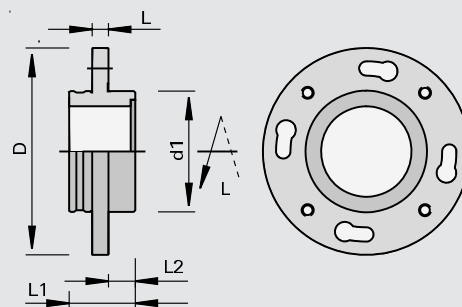
Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	30	17,4	10,8	43,4	167465	167464
[mm]	[mm]	[mm]	[mm]	[mm]		

997370

Mounting Flanges for Clamping System Ø 160 mm - tools with bore d=80 mm

Product

Drawing



Machine / Application

Design

Advantages

Notes

for mounting of heavy tools with bore Ø 80 mm with 4 countersunk holes M 8, TK Ø 130 mm

- for S-System on shaft with external thread
- for clockwise and counter-clockwise rotation
- indicate shaft design when placing an order
- at least two separate tool/flange assemblies should be used per clamping element (reduced downtimes)
- sense of rotation see drawing

Ø D	Ø d1	L2	L	L1	Ident-No. [L]	Ident-No. [R]
157	80	18	11,8	45	168399	168398
[mm]	[mm]	[mm]	[mm]	[mm]		

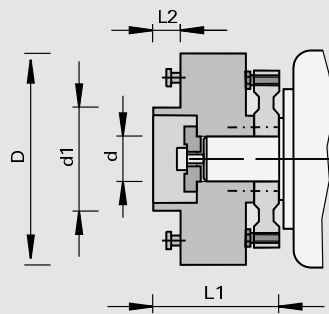
933011

Zeroplan Clamping Systems Ø 160 mm

Product



Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of tools with bore and for combination with mounting flanges Ø 160 mm

Design

- | n max = 7,200 min-1

Advantages

- | high runout accuracy almost as good as on hydro motors, now available for standard-motor shafts d = 35
- | distinct increase of edge life and quality thanks to precise run-out-adjustment
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar

Ø D	Ø d	Ø d1	L2	L1	DKN		Ident-No.
160	35	60	17,5	95	10x4	Homag	180654
160	35	60	17,5	102	10x4	IMA	180655
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

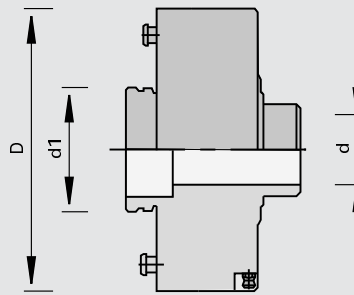
Covers (IMA)	45x25x35 DKN	997370	180656 o
Engineers Wrenches	SW10/13 DIN 895	985720	171060 o
	[mm]		

933011

Clamping Systems Ø 192 mm

Product

Drawing



Machine / Application

- | double end tenoners
- | through feed machines
- | for mounting of hogsers with Ø 250 mm

Design

- | n max = 7,200 min-1

Advantages

- | excellent balance quality
- | long tool life thanks to hardened tool mounting area
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free and protected from dust

Notes

- | for clockwise and counter-clockwise rotation
- | mounting example (see drawing)
- | indicate machine type and shaft design when placing an order
- | required tool adapters Class-No.
- | operational pressure 6 bar
- | included in delivery: see accessory list

Ø D	Ø d	Ø d1	KN	DKN		Ident-No.	
192	35	80		10x4	clamping part, spacer ring	IMA, B+G, Hüllhorst	161363 &
192	35	80		10x4	clamping part, spacer ring	B+G (flat nut)	161364 &
192	40	80		12x5	clamping part, spacer ring	B+G, SCM-Stefani	161365 &
192	35	80		10x4	clamping part, spacer ring	Celaschi	161366 &
192	35	80		10x4	clamping part, spacer ring, cover disk	Danckaert	161367 &
192	40	80	10x4		clamping part, spacer ring	Gabbiani	161257 &
192	35	80		10x4	clamping part, spacer ring	Festo	161256 &
192	35	80		10x4	clamping part, spacer ring, cover disk	Frommia	161258 &
192	35	80		10x4	clamping part	Homag, Lehbrink, Torwegge, SPA, Wilmsmeyer	161259
192	35	80		10x4	clamping part, spacer ring, cover disk	Kuhlmann	161260 &
192	40	80		12x5	clamping part, spacer ring, cover disk	M+S, Schwabedissen	161251 &
192	35	80		10x4	clamping part, cover disk	Raimann	161252 &
192	30	80			clamping part	SPA	161253 s
[mm]	[mm]	[mm]	[mm]	[mm]			

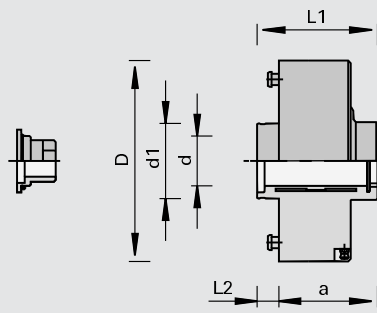
933011

Hydro Clamping System Ø 160 mm - hoggers

Product



Drawing



Machine / Application

| for mounting of tools with bore

Design

| hardened tool mounting area
 | n max = 9,000 min-1
 | closed hydraulic expansion clamping chuck with one clamping zone for tight-tolerance fit on the motor shaft

Advantages

| high cutting quality thanks to distinctly increased runout accuracy and concentricity
 | consistent runout accuracy after each tool change
 | minimization of setup-times thanks to easy and quick tool change
 | maintenance-free

Notes

| for clockwise and counter-clockwise rotation
 | specifically designed for high-precision motors with hexagonal spindle base
 | for changing the tools the pneumatic part Ident-No. 058250 is necessary
 | operational pressure 6 bar
 | included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	L1	a		Ident-No.
160	40	60	17,5	96	78.5	Hoggers	172677
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

	Class-No.	Ident-No.
Covers with O-Rings	997300	172679
Head Cap Screws	995111	184251
pneumatic hose	994200	058250
Screwdrivers	985730	167817
Cranked Wrench Keys	985730	177106

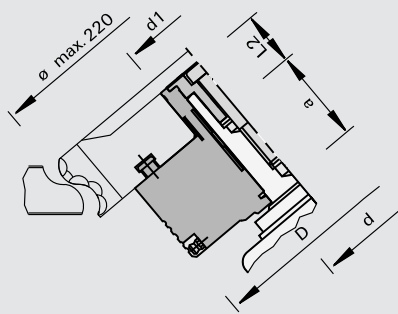
933011

Hydro Clamping System Ø 160 mm - cutters

Product



Drawing



Machine / Application

| for mounting of tools with bore

Design

- | hardened tool mounting area
- | n max = 9,000 min-1
- | closed hydraulic system with two clamping zones
- | clamping zone 1: for tight-tolerance fit on the motor shaft (runout)
- | clamping zone 2: for tight-tolerance fit of milling tools on the clamping element (concentricity)

Advantages

- | high cutting quality thanks to distinctly increased runout accuracy and concentricity
- | consistent runout accuracy after each tool change
- | minimization of setup-times thanks to easy and quick tool change
- | maintenance-free

Notes

- | for clockwise and counter-clockwise rotation
- | specifically designed for high-precision motors with hexagonal spindle base
- | for changing the tools the pneumatic part Ident-No. 058250 is necessary
- | operational pressure 6 bar
- | included in delivery: hydro quick-clamping system incl. Screwdrivers

Ø D	Ø d	Ø d1	L2	a		Ident-No.
160	40	60	35	53	milling tools	176829
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

	Class-No.	Ident-No.
Covers with O-Rings	997300	172679
Head Cap Screws	995111	184251
pneumatic hose	994200	058250
Screwdrivers	985730	167817
Cranked Wrench Keys	985730	177106

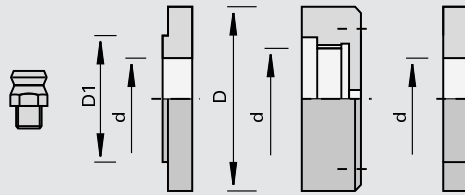


Accessories for Quick-Clamping Systems

Product



Drawing



Machine / Application

for engaging or releasing the LEUCO quick-clamping systems

Design

Advantages

Notes

- | anti-twist bolt Ident-No. 160875 for mounting
- | ring Ident-No. 170363 is required for L = 68 mm if no centering adapter is used
- | nut Ident-No. 170364 is required for IMA machines with short shaft
- | the pneumatic hose is required to change the tools; must be ordered separately before first delivery of clamping systems

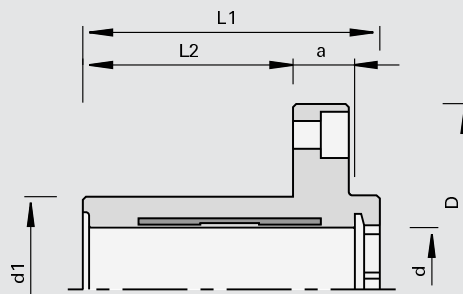
					Class-No.	Ident-No.
hydraulic connector R 1/8" (old design)					994400	160632
hydraulic connector M10x1 (new design)					994400	180084
fitting					997800	161289
pneumatic hose complete					994200	058250
Spare parts	For S-Sytem Ø D/d	Ø D	Ø D1	Ø d	Class-No.	Ident-No.
Covers	110/140/160/30	40	30	17	997370	181802
Covers	110/35	40	35	17	997370	162602
Covers	140/160/35	45	35	22	997370	180082
Covers	140/160/40	48	40	22	997370	180121
Special Nuts	140/160/35	58		M30 x 1,5	995290	170364
Spacers	140/160/35	70		35	955520	170363
Bolts	110/140/160			10x120	995322	160875
		[mm]	[mm]	[mm]		

933030

Hydro Clamping Bushings with hexagonal adapter bottom- tools with bore

Product

Drawing



Machine / Application

| for mounting of tools with bore

Design

| hardened tool mounting area
 | Ident-No. 172678 with one clamping zone
 | Ident-No. 182103 with two clamping zones and for use with adjustment unit
 | closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft

Advantages

| optimum cutting quality when milling and hogging
 | maintenance-free and inured to dirt

Notes

| for clockwise and counter-clockwise rotation
 | specifically designed for high-precision motors with hexagonal spindle base
 | included in delivery: hydro clamping bushing without screwdrivers

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	20	4/M8/100	172678
120	40	60	68	96	20	4/M8/100	182103
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Class-No.

Ident-No.

Covers with O-Rings	for axial locking or bores 40 mm	997300	172679
Head Cap Screws	M14x60 DIN 6912 for 172679	995111	184251
Screwdrivers	SW6 for hydro pressure build-up	985730	167817
Cranked Wrench Keys	SW12 DIN 6911	985730	177106
Spacers	119,5x51x60 NL	955520	179471

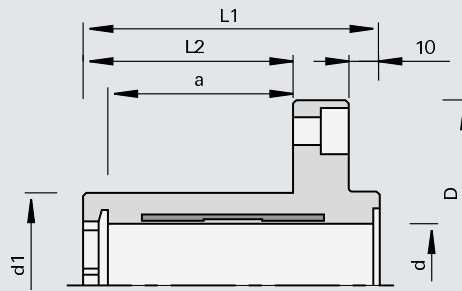


933030

Hydro Clamping Bushings with hexagonal adapter top- tools with bore

Product

Drawing



Machine / Application

for mounting of tools with bore and for combination with Postforming radius panel raising cutters und LEUCODIA CompactTec hoggers

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft

Advantages

excellent cutting quality when milling and hogging
maintenance-free

Notes

for clockwise and counter-clockwise rotation
specifically designed for high-precision motors with hexagonal spindle base
included in delivery:
Hydro Clamping Bushing incl. screwdriver SW 6

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
120	40	60	68	96	60	4/M8/100	173724
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Class-No.

Ident-No.

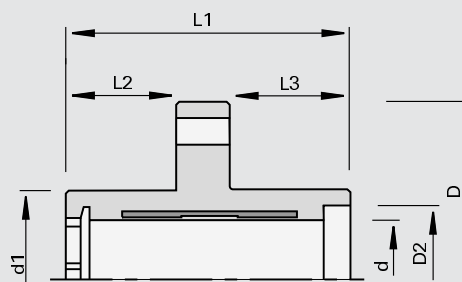
Covers with O-Rings		for axial locking or bores 40 mm	997300	172679
Head Cap Screws		M14x60 DIN 6912 for 172679	995111	184251
Screwdrivers		SW6 for hydro pressure build-up	985730	167817
Cranked Wrench Keys		SW12 DIN 6911	985730	177106
Spacers		119,5x51x60 NL	955520	179471

933030

Hydro Clamping Bushings - tools with bore progressively adjustable

Product

Drawing



Machine / Application

for mounting of milling tools with progressive adjustment of the cutting width

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft

Advantages

excellent cutting quality when milling
maintenance-free

for clockwise and counter-clockwise rotation
specifically designed for high-precision motors with hexagonal spindle base

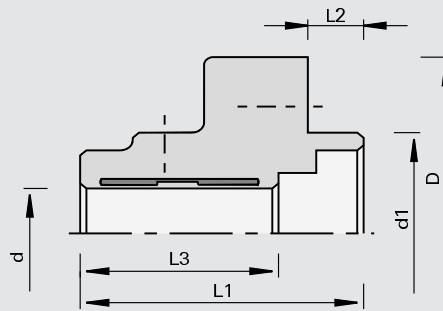
Ø D	Ø D2	Ø d	Ø d1	L2	L1	L3	NL	Ident-No.
120	50	40	60	39	101	44	4/M8/100	180181
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933030

Hydro Clamping Bushings - hoggers

Product

Drawing



Machine / Application

for mounting of tools with bore with LEUCO hoggers \varnothing 200 mm and \varnothing 250 mm

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft

Advantages

Notes

for clockwise and counter-clockwise rotation
fits conventional motors with shaft 35 mm and keyway

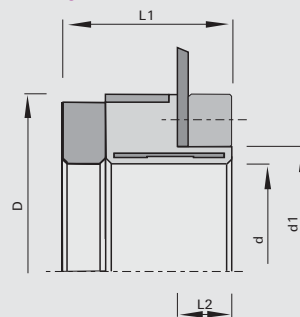
\varnothing D	\varnothing d	\varnothing d1	L2	L1	L3	DKN	NL	Ident-No.
120	35	80	17,7	90	63	10x4	4/M8/100	170264 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933030

Hydro Clamping Bushings - gang-rip saw blades and hoggers (Paul, Homag)

Product

Drawing



Machine / Application

machines Paul, Homag
for mounting of of multi-rip saw blades and hoggers

Design

hardened tool mounting area
with one clamping zone
closed hydraulic expansion clamping chuck for tight-tolerance fit on the motor shaft

Advantages

high smoothness of running
short retool-times of panel-widths thanks to quick adjustment of tools
maintenance-free

Notes

for clockwise and counter-clockwise rotation
mounting arrangements: 1. saw blade with spacer, 2. hogger without spacer
positive locking between machine and sleeve
tap holes on PCD for fixing of tools

\varnothing D	\varnothing d	\varnothing d1	L2	L1	NL	Ident-No.
145	100	110	18	65.5	4/M8/130	183829
150	100	110	18	49.5	4/M8/130	183821 s
[mm]	[mm]	[mm]	[mm]	[mm]		

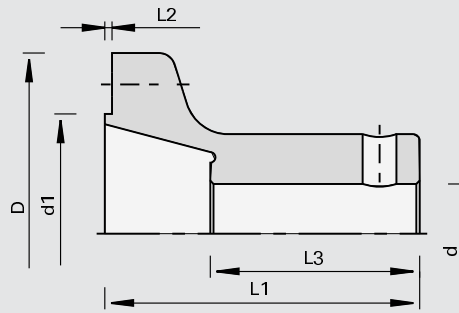
997300

Mounting Flanges - scoring saw blades (Homag, Brandt, IMA)

Product



Drawing



Machine / Application

- | double end tenoners
- | edge banding machines
Homag, Brandt, IMA
- | for mounting of HW scoring
saw blades and DP scoring saw
blades

Design

- | tempered design
- | mating and seating surfaces
ground

Advantages

Notes

- | for clockwise and counter-
clockwise rotation
- | for DP circular saw blades the
cylindrical head screw Ident-
No. 001869 is necessary (to
be ordered separately)
- | countersink screw included in
delivery

Ø D	Ø d	Ø d1	L2	L1	L3	DKN	NL	Ident-No.
109	30	65	2,2	95	63	8x4	6/M5/90	006480
109	35	65	2,2	95	63	10x3,3	6/M5/90	182128
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Ø D

Ø D1

Ø d

Class-No.

Ident-No.

Covers	40	30	17	997370	181802
Countersunk Flat Headed Screws	for mounting of saw blade			995122	180007
Head Cap Screws	for mounting of DP saw blades			995111	001869
	[mm]	[mm]	[mm]		

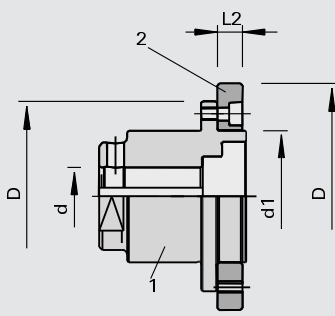
997300

Attachment Sleeves and Flanges - grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Product



Drawing



Machine / Application

for mounting of grooving saw blades, scoring saw blades, clipping saw blades and hoggers

Design

Advantages

Notes

for clockwise and counter-clockwise rotation
 1 = hogger sleeve
 2 = flange
 for horizontally tilted motor when working in small distance to chain track

Ø D	Ø d	Ø d1	L2	L1	DKN	NL	Ident-No.
115	30	80	17,7	96	8x3	8/M8/100	006309
115	35	60	17,7	90	10x4	8/M8/100	180062
115	35	80	17,7	90	10x4	8/M8/100	055997
115	40	60	17,7	90	12x5	8/M8/100	180120
115	40	80	17,7	96	12x5	8/M8/100	006308
145	35	110	17	89.4	10x4	4/M8/130	189750 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Flange

Ø D

B

Ø d

Ø NL

Class-No.

Ident-No.

137

80

15

6/M5/105

997300

819300 s

[mm]

[mm]

[mm]

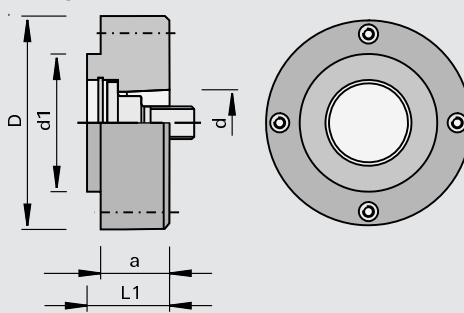
997300

Mounting Flanges - clipping saw blades (Homag, IMA)

Product



Drawing



Machine / Application

edge banding machines
 Homag, IMA
 for mounting of clipping saw blades

Design

machine interface HSK 25R

Advantages

optimum cutting quality thanks to high radial running accuracy and precise tool balancing

Notes

for clockwise and counter-clockwise rotation
 countersunk screw and screwdrivers are not included in delivery

Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
55	HSK 25R	34	22	20	4/M4/44+4/M5/42	179025
62	HSK 25R	40	24	20	4/M5/52	177788
66	HSK 25R	40	24	15	4/M5/52	183817
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
Countersunk Flat Headed Screws	M5x10 T20	995125	171236
Screwdrivers	T20x100	985730	166092
	[mm]		

997300

Mounting Flanges - clipping saw blades (Homag Power-Line)

Product	Drawing	

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> machines Power-Line Homag for mounting of clipping saw blades 	<ul style="list-style-type: none"> machine interface HSK 25R 	<ul style="list-style-type: none"> optimum cutting quality thanks to high radial running accuracy and precise tool balancing 	<ul style="list-style-type: none"> for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L1	a	NL	Ident-No.
105	HSK 25R	30	23	14	4/M5/52	181590
[mm]	[mm]	[mm]	[mm]	[mm]		

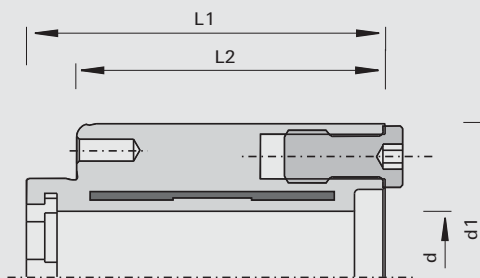
Spare parts	Dimension	Class-No.	Ident-No.
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
Head Cap Screws	M5x12 DIN 912	995111	001869
Screwdrivers	SW4x100	985730	166091
	[mm]		

933030

Hydro Clamping Bushings - tools with bore on spindle 30 mm

Product

Drawing



Machine / Application

- for Homag and IMA jointing aggregat with spindle 30 mm and hexagon adapter
- for mounting of tools with bore

Design

- hardened tool mounting area
- with one clamping zone
- axial impressurement
- closed hydraulic expansion clamping chuck for tight-tolerance fit on the 30 mm motor shaft

Advantages

- reduced machine downtimes thanks to axial impressurement
- excellent cutting quality when milling and hogging
- maintenance-free

Notes

- for clockwise and counter-clockwise rotation
- specifically designed for high-precision motors with hexagonal spindle base
- included in delivery: hydro clamping bushing without screwdrivers

Ø d	Ø d1	L2	L1	NL	Ident-No.
30 [mm]	70 [mm]	70,5 [mm]	86 [mm]	6/M6/58	184310

Spare parts

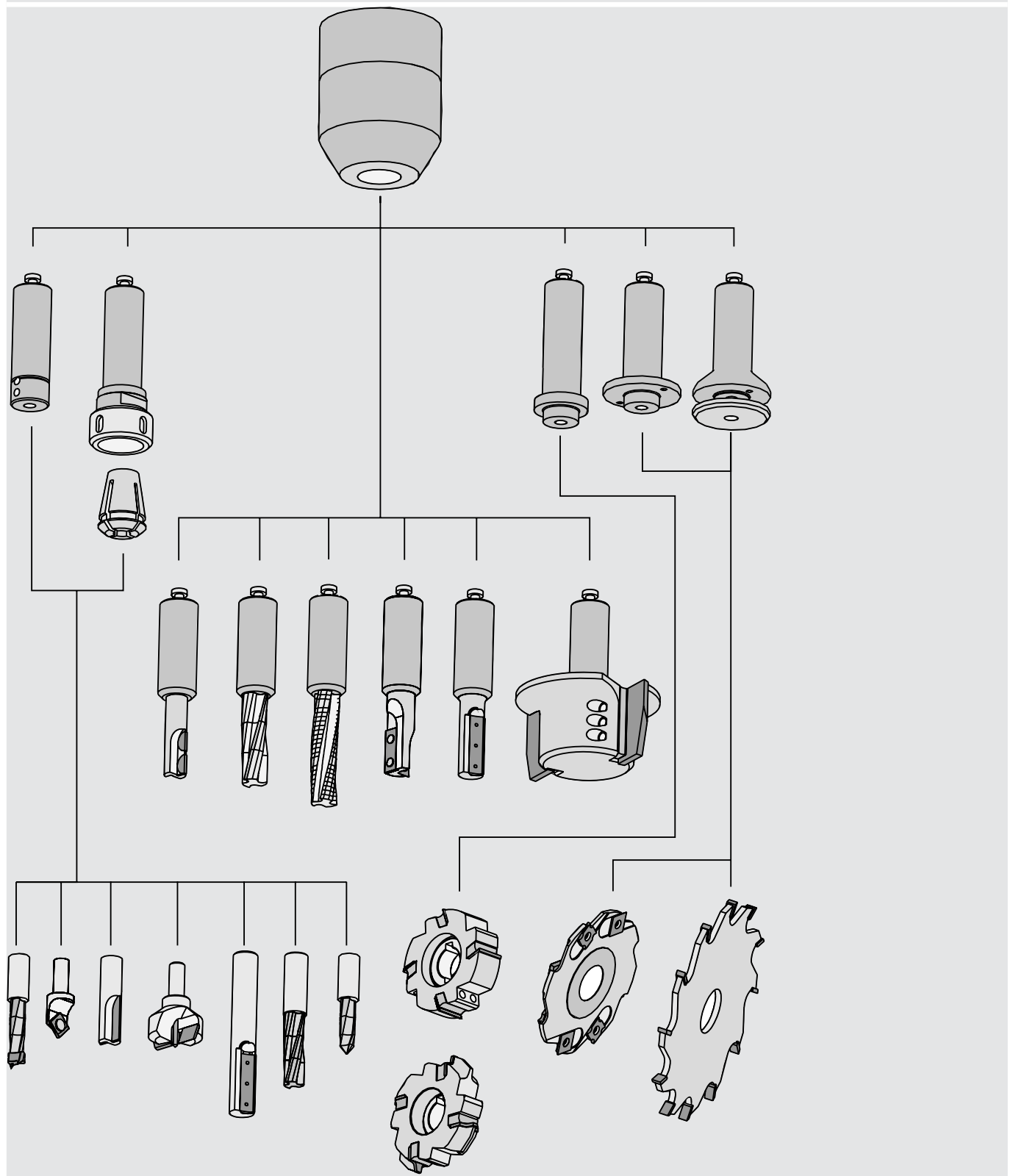
Class-No.

Ident-No.

Covers with O-Rings	for axial locking or bores 30 mm	997300	184317
Head Cap Screws	M10x50 DIN EN ISO 4762 for 184317	995111	001909
Screwdrivers	SW4 for hydro pressure build-up	985730	166091
Cranked Wrench Keys	SW8 DIN ISO 2936	985730	009677



Chart Tool Holders machine interface PS 2000-E



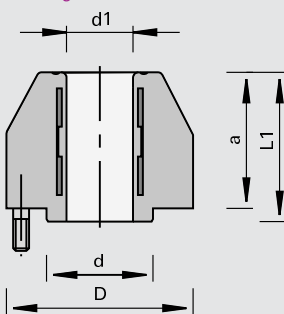
933240

Hydro Clamping Chucks - tool directly attached by screws

Product



Drawing



LEUCO
CNC

Machine / Application

for precise clamping of shank-type tools with cylindrical shank

Design

n max = 25,000 min -1

Advantages

optimum cutting quality and long tool life thanks to exact radial running accuracy
minimization of setup-times thanks to easy and quick tool change

Notes

for clockwise and counter-clockwise rotation
integral part of machine spindle
initial purchase through the machine manufacturers
axial locking of the tools

Ø D	Ø d	Ø d1	L1	a	Weight	Ident-No.
70	40	25	56	51	1.327	173752
[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Accessories

Safety Screws

Dimension

M8x19
[mm]

Class-No.

997870

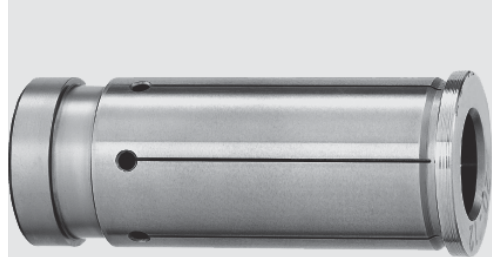
Ident-No.

172921

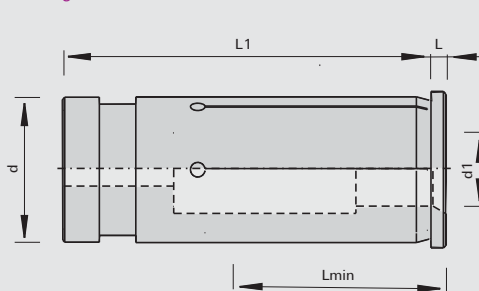
933280

Universal Reducing Bushings

Product



Drawing



LEUCO
CNC

Machine / Application

for mounting of shank-type tools in Sino, Tribos, ps-System

Design

shank diameter tolerance h7 or g7

Advantages

Notes

Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
3		27	12	45	2	183022 o
4		27	12	45	2	183023 o
5		27	12	45	2	183024 o
6		27	12	45	2	183025
8		27	12	45	2	183026
3		27	20	50.5	2	183027 o
4		27	20	50.5	2	183028 o
5		27	20	50.5	2	183029 o
6		27	20	50.5	2	183030 o
7		27	20	50.5	2	183031 o
8		27	20	50.5	2	183032
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

Ø d1	Ø d1	Lmin	Ø d	L1	L	Ident-No.
9		27	20	50.5	2	183033 o
10		32	20	50.5	2	183034
11		37	20	50.5	2	183035 o
12		37	20	50.5	2	183036
13		37	20	50.5	2	183037 o
14		37	20	50.5	2	183038 o
15		38	20	50.5	2	183039 o
16		38	20	50.5	2	183040
17		38	20	50.5	2	183041 o
6		27	25	54.5	3	182304
8		27	25	54.5	3	182305
10		32	25	54.5	3	182306
12		37	25	54.5	3	182307
14		37	25	54.5	3	182308
16		38	25	54.5	3	182309
18		38	25	54.5	3	182310
20		42	25	54.5	3	182311
	1/2	37	25	54.5	3	182653
	5/8	38	25	54.5	3	182654 o
	3/4	42	25	54.5	3	182655
[mm]	[inch]	[mm]	[mm]	[mm]	[mm]	

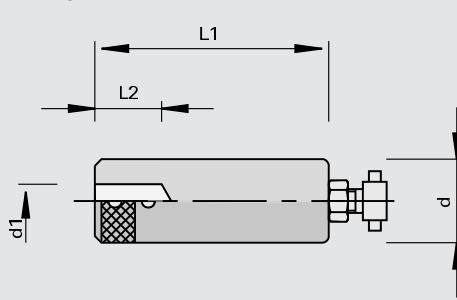
933243

Adapters with cylindrical shank - shank-type tools

Product



Drawing



Machine / Application

for mounting of shank-type tools in PS 2000-E for shank diameter 6 - 12 mm

Design

Advantages

Notes

- the tool shanks must feature a flat clamping area
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- with length adjusting screw for ps-System Ø 16 mm Ident-No. 172115, Ø 25 mm Ident-No. 172113

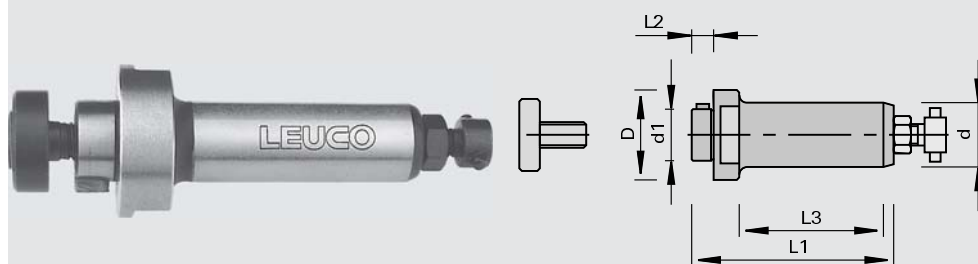
Ø d	Ø d1	L2	L1	Ident-No.
16	6,35	20	61	172112
16	8	20	61	172117
16	9,5	20	61	172118
16	10	20	61	172119
25	6	20	70	172103
25	8	20	70	172104
25	9,5	20	70	172105
25	10	20	70	172101
25	12	20	70	172102
[mm]	[mm]	[mm]	[mm]	

997300

Adapters with cylindrical shank - tools with bore

Product

Drawing

LEUCO
CNC

Machine / Application

for PS 2000-E and draw-in
collet chuck for the mounting
of tools with bore

Design

tool held in place by set screws

Advantages

Notes

for clockwise and counter-
clockwise rotation
length adjusting screw
Ident-No. 172921 is required
for PS 2000-E
included in delivery: mounting
arbor, set screws and length
adjusting screw for ps-System
for shank \varnothing 16 Ident-No.
172115, shank \varnothing 25 Ident-
No. 172113

$\varnothing D$	$\varnothing d$	$\varnothing d1$	L2	L1	L3	Ident-No.
35	16	20	8,5	68	43	171389 o
35	25	20	8,5	78,5	55	171391 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

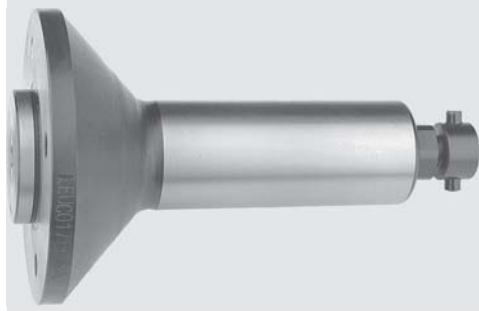
Ident-No.

Cutter Retaining Bolts	$\varnothing 20 \times M8 \times 23$	995190	171393
Cutter Retaining Bolts	$\varnothing 28 \times M10 \times 26$	995190	171392
Engineers Wrenches	24x27 DIN 3110 [mm]	985730	009193 o

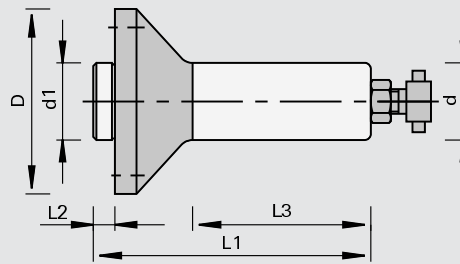
933061

Adapters with cylindrical shank - saw blades, grooving cutters and cutters

Product



Drawing



LEUCO
GNC

Machine / Application

for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

tool attached and secured against rotation with screws

Advantages

Notes

- for clockwise and counter-clockwise rotation
- length adjusting screw Ident-No. 172921 is required for PS 2000-E
- clamping length L2 = 30 and 36 mm for single- and multi-piece cutters and cutterheads
- clamping length L2 = 4 and 5 mm for circular saw blades and grooving cutters
- included in delivery: mounting arbor and PS length adjusting screw for shank Ø 25 Ident-No. 172113

Ø D	Ø d	Ø d1	L2	L1	L3	NL	Ident-No.
50	16	22	4	68	45	4/M5/34 + 4/M4/36	184277
50	25	22	4	92	60	4/M5/34 + 4/M4/36	184276
60	16	30	4	80	60	4/M6/48	Lamello Clamex P 184304
60	25	30	4	90	70	4/M6/48	Lamello Clamex P 184305
60	25	25	30	111	60	6/M6/48	168814 o
60	25	30	36	117	60	6/M6/48	168815
66	25	30	5	92	60	4/M5/48	171386
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

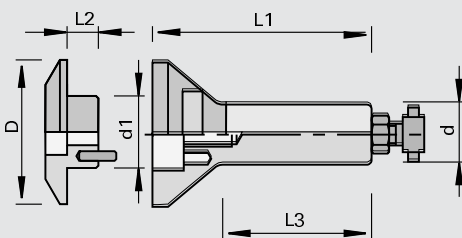
997300

Adapters with cylindrical shank - saw blades and grooving cutters

Product



Drawing



Machine / Application

for PS 2000-E and draw-in collet chuck for mounting of circular saw blades and grooving cutters

Design

secured against rotation with drive pin

Advantages

Notes

for clockwise and counter-clockwise rotation
 length adjusting screw Ident-No. 172921 is required for PS 2000-E
 included in delivery: clamping arbor, clamping flange, cap screw and length adjusting screw for ps-System for shank Ø 16 Ident-No. 172115, shank Ø 25 Ident-No. 172113

Ø D	Ø d	Ø d1	L2	L1	L3	Ident-No.
60	16	30	8	78	43	for plate thickness max. 6 mm 171394
60	25	30	9	94	55	for plate thickness max. 8 mm 167826
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

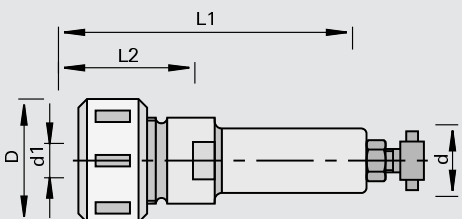
933250

Draw-In Collet Chucks with cylindrical shank

Product



Drawing



Machine / Application

for mounting of shank-type tools in PS 2000-E

Design

for shank diameter 2-16 mm
 collet chucks DIN 6388 Type 415E/OZ16
 lock nut with sleeve bearing

Advantages

Notes

for clockwise and counter-clockwise rotation
 length adjusting screw Ident-No. 172921 is required for PS 2000-E
 included in delivery: collet chuck adapter with nut and length adjusting screw for ps-System for shank Ø 16 Ident-No. 172115, shank Ø 25 Ident-No. 172113

Ø D	Ø d	Ø d1	L2	L1	Ident-No.
43	16	2-16	50	95	170181
43	25	2-16	50	105	170182
[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	Ident-No.
Ball-bearing lock nuts	M30x1,5R	995290	178763
Hook Wrenches	SW40/42 DIN 1810	985720	169298
Engineers Wrenches	24x27 DIN 3110 [mm]	985730	009193 o

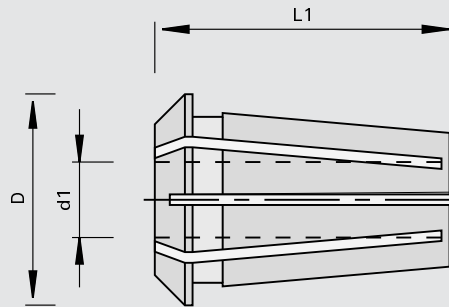
933280

Precision collets - 415E/OZ16

Product



Drawing



LEUCO
CNC

Machine / Application

for use in draw-in collet chucks
Type 415E/OZ16

Design

slotted from top and bottom
clamping tolerance 0.5 mm
according to DIN 6388 415E/
OZ16

Advantages

Notes

for Ident-No. 170181,
170182

Ø D	Ø d1	L1	Ident-No.
25.5	2,5	40	820753 o
25.5	3	40	820754 o
25.5	4	40	820494 o
25.5	4,5	40	830236 o
25.5	5	40	820495 o
25.5	6	40	170779 o
25.5	6,35	40	821421 o
25.5	7	40	829692 o
25.5	8	40	170780
25.5	9	40	825190 o
25.5	9,5	40	168739 o
25.5	10	40	170781
25.5	12	40	168740
25.5	12,7	40	830156 o
25.5	13	40	821221 o
25.5	16	40	168741
[mm]	[mm]	[mm]	

933250

StarterKit for Weeke BHX series

Product

Drawing

**Machine / Application**

- | for use in hydro expansion chuck on WEEKE BHX machines, especially BHX 050/055 series
- | for tools with shank diameter up to 1-16 mm

Design

- | adapters with high-precision collet chucks, especially adapted to the hydro clamping system of the BHX milling spindle
- | with internal lock nut

Advantages

- | flexible, quick clamping
- | low building height
- | individual tool pre-setting outside of the machine is possible
- | time saving tool changes

Notes

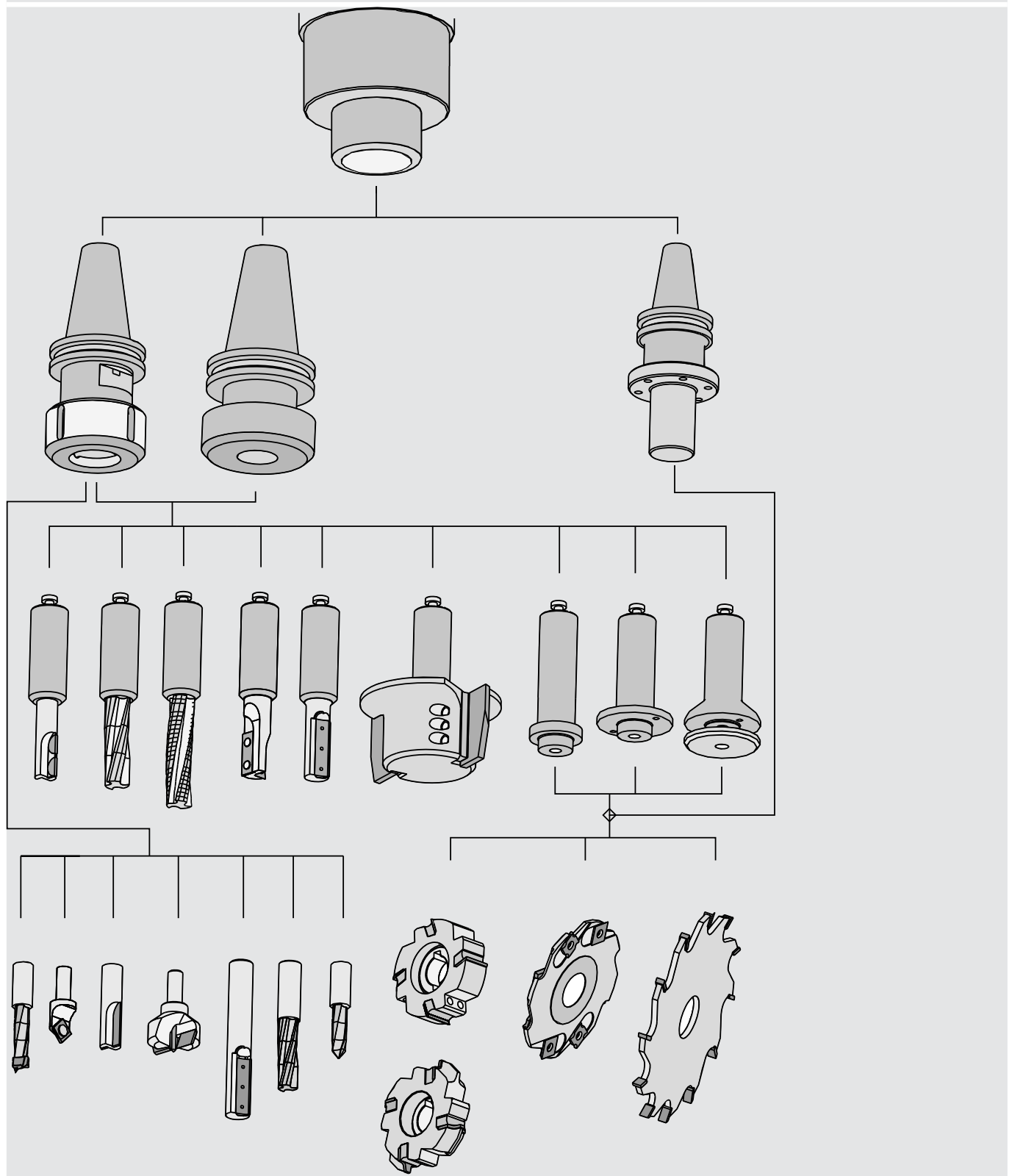
- | for Weeke BHX machines grooving cutters HW "g5-System" are also available

		Ident-No.
StarterKit SET1	[d]+[f] 3 clamping adapter incl. lock nuts [e] 3 collet chucks (8, 10, 12 mm) [c] 1 mounting device [a] 1 hook wrench [g] 1 wrench	184359 o
StarterKit SET2	[d]+[f] 5 clamping adapter incl. lock nuts [e] 5 collet chucks (6, 8, 10, 12, 16 mm) [c] 1 mounting device [a] 1 hook wrench [b] 1 wrench socket	184360 o

Spare parts	Content StarterKit	Class-No.	Ident-No.
[f]+[d] clamping adapter D25x16 mm incl. lock nut	For all	933250	184362 o
[c] mounting devices	For all	985202	184363 o
[a] hook wrench D25 L=200	For all	985720	184364 o
[g] wrench D30 SW27 H20	184359	985720	184365 o
[b] wrench socket D30 SW22 H96	184360	985720	184366 o
[e] collet chucks 411E D=6	184360	933280	184372 o
[e] collet chucks 411E D=8	For all	933280	184373 o
[e] collet chucks 411E D=10	For all	933280	184374 o
[e] collet chucks 411E D=12	For all	933280	184375 o
[e] collet chucks 411E D=16	184360	933280	184376 o

Accessories	Class-No.	Ident-No.
[e] collet chucks 411E D=1	933280	184367 o
[e] collet chucks 411E D=2	933280	184368 o
[e] collet chucks 411E D=3	933280	184369 o
[e] collet chucks 411E D=4	933280	184370 o
[e] collet chucks 411E D=5	933280	184371 o
[e] collet chucks 411E D=6	933280	184372 o
[e] collet chucks 411E D=16	933280	184376 o
torque wrench 40-200 Nm	985720	184377 o
[d] lock nut s M43x1,5	995290	184378 o

Chart Tool Holders machine interface SK- and BT-Mounting



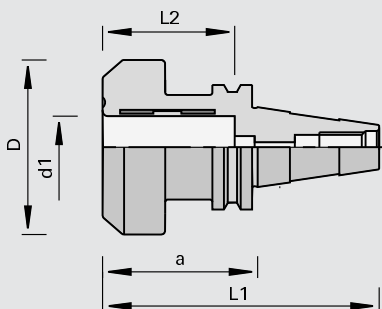
933240

Hydro Clamping Chucks PS 2000-E - tool changer

Product



Drawing


LEUCO
CNC

Machine / Application

| CNC machining centers with automatic tool changer
 | for precise clamping of shank-type tools with cylindrical shank

Design

| n max = 25,000 min -1
 | quick-release taper BT 30 and quick-release taper BT 35 with retaining bolt according to standard MAS 403
 | quick-release taper SK 30 according to ISO 7388-3 (without retaining bolt - must be ordered separately)
 | quick-release taper SK 30 and SK 40 according to DIN 69871A (with retaining bolt)

Advantages

| minimization of setup-times thanks to easy and quick tool change
 | high cutting quality and long edge lives thanks to high concentricity

Notes

| for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	Weight	Ident-No.	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		
70	SK 30 (ISO)25		55	111	63	1.1	CMS	173774
70	SK 30 (DIN)	25	55	111	63	1.1	IMA, Maka, Biesse, Reichenbacher, Weeke	173754
70	SK 40 (DIN)	25	55	128	60	1.39	IMA, Maka, Reichenbacher, Stegherr	173756
70	BT 35	25	55	120	63	1.25	Heian	175796

Retaining Bolts

Mach.

Class-No.

Ident-No.

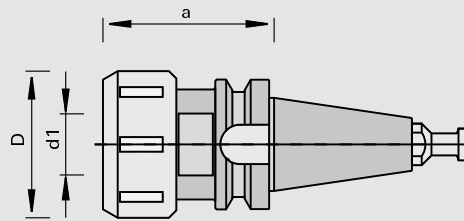
for SK 30	DIN 69872 A	IMA, Maka, Reichenbacher, Weeke	997870	169293
for SK 40	DIN 69872 A	IMA, Reichenbacher, Stegherr	997870	169294
for SK 30	ISO 7388-3	CMS, Masterwood	997870	177021
for SK 30		Rover old, Biesse up to 08/92	997870	175637
for SK 30		Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	997870	173641
for SK 30	ISO 7388-3	Alberti	997870	177020
for BT 35	PT 35T-2	Heian	997870	176103

933289

Draw-In Collet Chucks with SK shank

Product

Drawing



LEUCO
GNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to DIN 69871 resp. ISO 7388-3 (without dog and locating grooves)
- | quick-release taper according to Japanese standard MAS - 403 (for Ident-No. 176102)
- | lock nut with sleeve bearing (except for Ident-No. 177304 with ball bearing)

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | included in delivery: collet chuck, clamping nut and retaining bolt

Ø D	Ø d	Norm number	Ø d1	a			Ident-No.
43	SK 30 (DIN)	415E/ OZ16	2-16	55	SW 41	Weeke	177304 o
60	SK 30 (DIN)	462E/ OZ25	2-25	70	SW 41	IMA, Maka, Reichenbacher	173794
50	SK 30 (ISO)	470E/ ER32	2-20	58	SW 41	CMS	180360 o
60	SK 40 (DIN)	462E/ OZ25	2-25	70	SW 46	IMA, Maka, Stegherr, Reichenbacher	173795
60	BT 35	462E/ OZ25	2-25	70	SW 41	Heian	176102
[mm]	[mm]		[mm]	[mm]			

Spare parts

Class-No.

Ident-No.

Ball-bearing lock nuts	M30x1,5R	for Ø D = 43	995290	178763
Lock Nut with sleeve bearing	M48x2R	for Ø D = 60	995290	178764
Retention knobs	DIN 69872 A	for SK 30	997870	169293
Retention knobs	DIN 69872 B	for SK 40	997870	179339
Retention knobs	ISO 7388-3	for SK 30	997870	177021
Retention knobs	PT 35T-2	for BT 35	997870	176103
Hook Wrenches	SW58/62 DIN 1810	for Ø D = 60	985720	169299
Hook Wrenches	SW40/42 DIN 1810	for Ø D = 43	985720	169298
Single-Head Engineers Wrenches	SW46x10 DIN 894		985720	178760
Single-Head Engineers Wrenches	SW41 DIN 894		985720	169297
	[mm]			

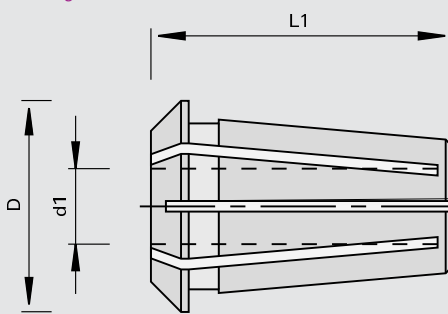
933280

Precision collets - 462E/OZ25

Product



Drawing



LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 462E/OZ25

Design

clamping tolerance 0.5 mm
according to DIN 6388 Type
462E/OZ25

Advantages

optimum transmission of
clamping force thanks to 12
slots from top and bottom

Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4	35.05	52	175815
7		35.05	52	183807
8		35.05	52	180358
9,5		35.05	52	175817
	3/8	35.05	52	185275
10		35.05	52	170782
12		35.05	52	168742
	1/2	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8	35.05	52	175823
15		35.05	52	183808
16		35.05	52	168743
18		35.05	52	180216
	3/4	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	



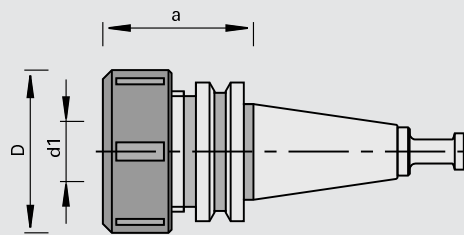
933289

Draw-In Collet Chucks with SK shank - Biesse, CMS

Product



Drawing



LEUCO
GNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to DIN 69871 and ISO (without dog and locating grooves)
- | lock nut with sleeve bearing

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | collet chucks according to Type 470E/ER32 Ø 2..20 mm
- | collet chucks according to Type 472E/ER40 Ø 4..25 mm
- | included in delivery:collet chuck, clamping nut and retaining bolt

Ø D	Ø d	Ø d1	a	Type		Ident-No.
50	SK 30 (DIN)	2-20	50	470E/ER32	Biesse	173639
63	SK 30 (DIN)	4-25	57	472E/ER40	Biesse	175790
63	SK 30 (ISO)	4-25	64	472E/ER40	CMS	180361
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

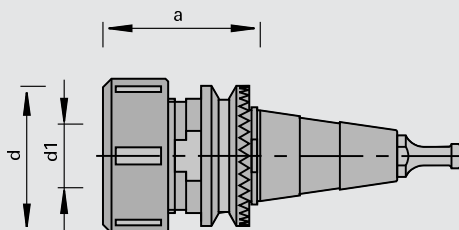
Lock Nuts	M40x1,5R	for Ø D = 50	995290	178761
Lock Nuts with sleeve bearing	M50x1,5R	for Ø D = 63	995290	178762 o
Retention knobs		HSD motor for Biesse as from 09/92	997870	173641
Retention Knobs		for Biesse up to 08/92	997870	175637
Retention knobs	ISO 7388-3	for SK 30	997870	177021
Hook Wrenches	SW45/50 DIN 1810	for Ø D = 50	985720	175851
Hook Wrenches	SW58/62 DIN 1810	for Ø D = 63	985720	169299
	[mm]			

933289

Draw-In Collet Chucks with SK shank with ring gear

Product

Drawing


LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of shank-type tools with cylindrical shank

Design

- | quick-release taper according to SK 30 with ring gear
- | lock nut with sleeve bearing

Advantages

- | minimization of setup-times thanks to easy and quick tool change
- | high cutting quality and long edge lives thanks to high concentricity

Notes

- | for clockwise and counter-clockwise rotation
- | replaceable retaining bolt
- | collet chucks according to Type 462E/OZ25 Ø 4..25 mm
- | collet chucks according to Type 470E/ER32 Ø 2..20 mm
- | included in delivery: collet chuck, clamping nut and retaining bolt

Ø D	Ø d	Ø d1	a	Type		Ident-No.
50	SK 30	2-20	55	470E/ ER32	SCM, Morbidelli	173644
60	SK 30	4-25	72	462E/ OZ25	SCM, Morbidelli	175792
[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Lock Nuts	M40x1,5R	for Ø D = 50	995290	178761
Lock Nut with sleeve bearing	M48x2R	for Ø D = 60	995290	178764
Retention Knobs	Ø8,5		997870	173646
Hook Wrenches	SW45/50 DIN 1810	for Ø D = 50	985720	175851
Hook Wrenches	SW58/62 DIN 1810	for Ø D = 60	985720	169299
Single-Head Engineers Wrenches	SW36 DIN 894	for Ø D = 50	985720	169296
Single-Head Engineers Wrenches	SW46x10 DIN 894	for Ø D = 60	985720	178760
	[mm]			

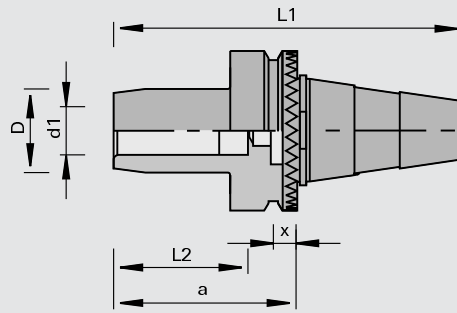
933299

Tribos Pressure Shrinking Chucks with SK shank

Product



Drawing

LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l quick-release taper according to SK 30 with ring gear
- l $n_{max} = 40,000 \text{ min}^{-1}$

Advantages

- l low weight is easy on machine bearing
- l suitable for high RPM's
- l optimum chip extraction thanks to slim design
- l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy ($< 0.003 \text{ mm}$)

Notes

- l for clockwise and counter-clockwise rotation
- l different diameters upon request
- l allowed projection: clamping of the tools by means of the clamping device
- l can also be done at LEUCO upon request
- l delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

$\emptyset d1$	L2	$\emptyset d$	$\emptyset D$	L1	a	x	Weight	Ident-No.
20	52	SK 30	30	127.85	80	10	0.7	180897
25	55	SK 30	35	127.85	80	10	0.7	180898
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Spare parts

	Class-No.	Ident-No.
Mounting Devices (manual)	985201	180261
Mounting Devices (automatic)	985201	181159 o
Adjustment Inserts	955530	180264
Adjustment Inserts	955530	180711
Length adjusting device Tribos system	985300	180828 o
Interface Cables for Adjusting Gauges	985300	180829 o

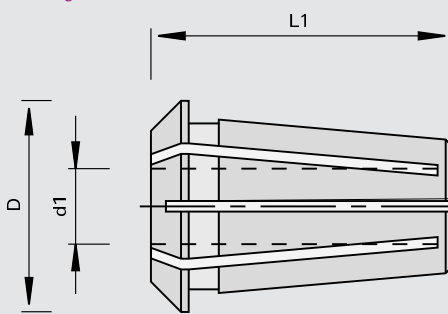
933280

Precision collets - 430E/ER25, 470E/ER32, 472E/ER40

Product



Drawing

LEUCO
CNC

Machine / Application

for use in draw-in collet chuck
Type 430E/ER25, 470E/ER32,
472E/ER40

Design

slotted from top and bottom
clamping tolerance 1 mm

Advantages

Notes

Type 430E/ER25 \varnothing 6 - 16
mm for special chuck
Type 470E/ER32 \varnothing 3 - 20
mm
Type 472E/ER40 \varnothing 6 - 25
mm

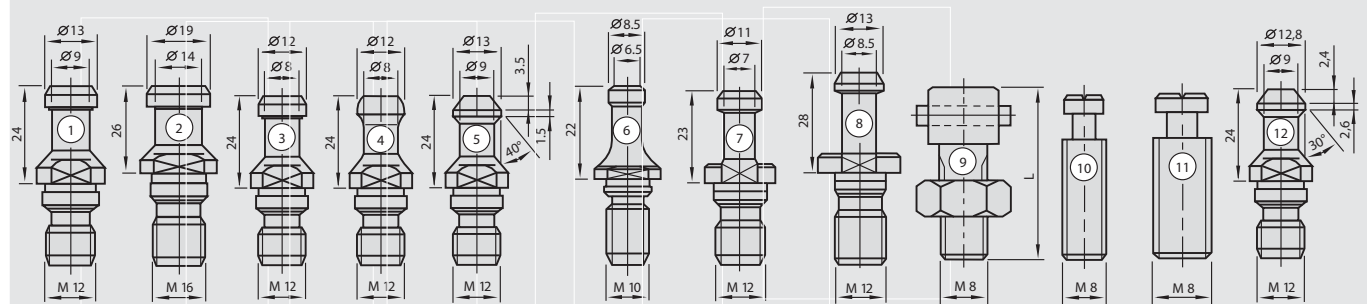
\varnothing D	\varnothing d1	\varnothing d1	L1	Type	Ident-No.
33	3		40	470E/ER32	173647 o
33	4		40	470E/ER32	173648 o
33	5		40	470E/ER32	173649 o
33	6		40	470E/ER32	173650
33	7		40	470E/ER32	173651 o
33	8		40	470E/ER32	173652
33	10		40	470E/ER32	173653
33	12		40	470E/ER32	173654
33	13		40	470E/ER32	173655 o
33	14		40	470E/ER32	173656 o
33	16		40	470E/ER32	173657
33	18		40	470E/ER32	173658 o
33	19		40	470E/ER32	173659 o
33	20		40	470E/ER32	173660
33		1/4	40	470E/ER32	175829
33		1/2	40	470E/ER32	175830
33		5/8	40	470E/ER32	175831 o
33		3/4	40	470E/ER32	175832 o
41	6		46	472E/ER40	180912 o
41	8		46	472E/ER40	180913 o
41	10		46	472E/ER40	180914 o
41	12		46	472E/ER40	175833
41	16		46	472E/ER40	175834
41	18		46	472E/ER40	175835 o
41	20		46	472E/ER40	175836
41	25		46	472E/ER40	175837
41		1/4	46	472E/ER40	175838 o
41		1/2	46	472E/ER40	175839 o
41		5/8	46	472E/ER40	175840 o
41		3/4	46	472E/ER40	175841 o
41		1	46	472E/ER40	175842 o
26	6		34	430E/ER25	181986 o
26	8		34	430E/ER25	181987
26	10		34	430E/ER25	181988
26	12		34	430E/ER25	181989
26	14		34	430E/ER25	181990 o
26	16		34	430E/ER25	181991
[mm]	[mm]	[inch]	[mm]		

997870

Retaining Bolts

Product

Drawing



Machine / Application

Design

Advantages

Notes

I for use in Hydro clamping chuck PS 2000-E, adapter and draw-in collet chuck with SK + BT-shank

I attachment screw for tools with shank diameter 25 mm

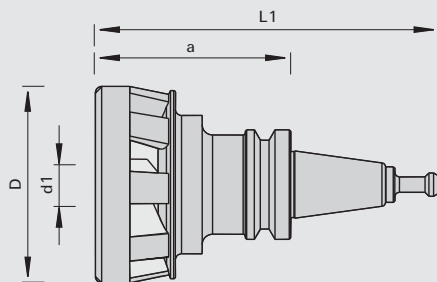
	Norm number	Type		Ident-No.
for SK 30	DIN 69872 A	1	IMA, Maka, Reichenbacher, Weeke	169293
for SK 40 with ventilation	DIN 69872 A	2	IMA, Reichenbacher, Stegherr	169294
for SK 40	DIN 69872 B	2	IMA, Reichenbacher, Stegherr, Maka	179339
for SK 30		3	Rover old, Biesse up to 08/92	175637
for SK 30		4	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	173641
for SK 30	ISO 7388-3	5	Alberti	177020
for SK 30 (ISO)	ISO 7388-3	12	CMS, Masterwood	177021
Retaining Bolt Ø 8.5 mm		6	Morbidelli, SCM	173646
for BT 30	P 30T-2	7	Shoda	176200
for BT 35	PT 35T-2	8	Heian	176103
for ps-System 25 mm Ident-No. 167738		9	ps-System	172113
for PS-2000 E Ident-No. 173352		10	PS 2000-E	172921
stop screw		11	draw-in collet chuck	172828

933285

AEROTECH SYSTEM with SK30 (DIN) with hydro expansion clamping

Product

Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers
- | for clamping of shank-type tools and simultaneous chip guide when working
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processes e.g. with Nesting applications

Design

- | monolithic tool clamping system
- | 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- | tool mounting by means of hydro expansion clamping technology
- | balance quality G<2,5

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance
- | minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- | high cutting quality and long edge lives thanks to high concentricity
- | optimum torque transfer

Notes

- | sufficient vacuum performance is necessary
- | impresseurement via hexagonal screwdriver (included in delivery)
- | delivery with retaining bolts for Biesse Ident-No. 173641
- | retaining boltt Ident-No. 169293 for IMA, Maka, Reichenbacher and Weeke must be ordered separately
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
20	SK30 (DIN) 95		143.2	92.2	9 wings	185153
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Screwdrivers with sliding handle for hexagon socket SW4x100		985730	166091
	[mm]		

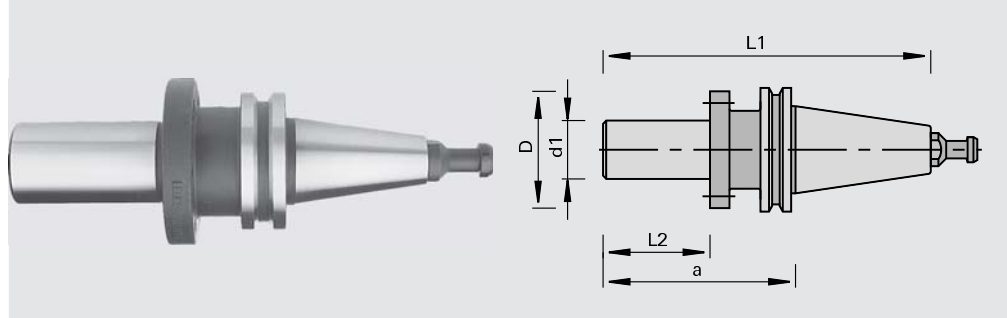


997300

Adapters with SK shank

Product

Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise mounting of tools with bore

Design

- | clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- | quick-release taper according to DIN 69871 (without dog and locating grooves)
- | tool attached and secured against rotation with screws

Advantages

Notes

- | for clockwise and counter-clockwise rotation
- | with retaining bolt according to DIN 69872 for SK 30 type A, SK 40 type B
- | machines SK 30: IMA, Maka, Reichenbacher, Weeke
- | machines DK 40: IMA, Maka, Reichenbacher, Stegherr

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
60	SK 30	25	55	147.8	100	6/M6/48	168800 #
60	SK 30	30	55	147.8	100	2/M6/48+2/6/48	182167 o
60	SK 40	30	55	168.4	100	2/M6/48+2/6/48	182168 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

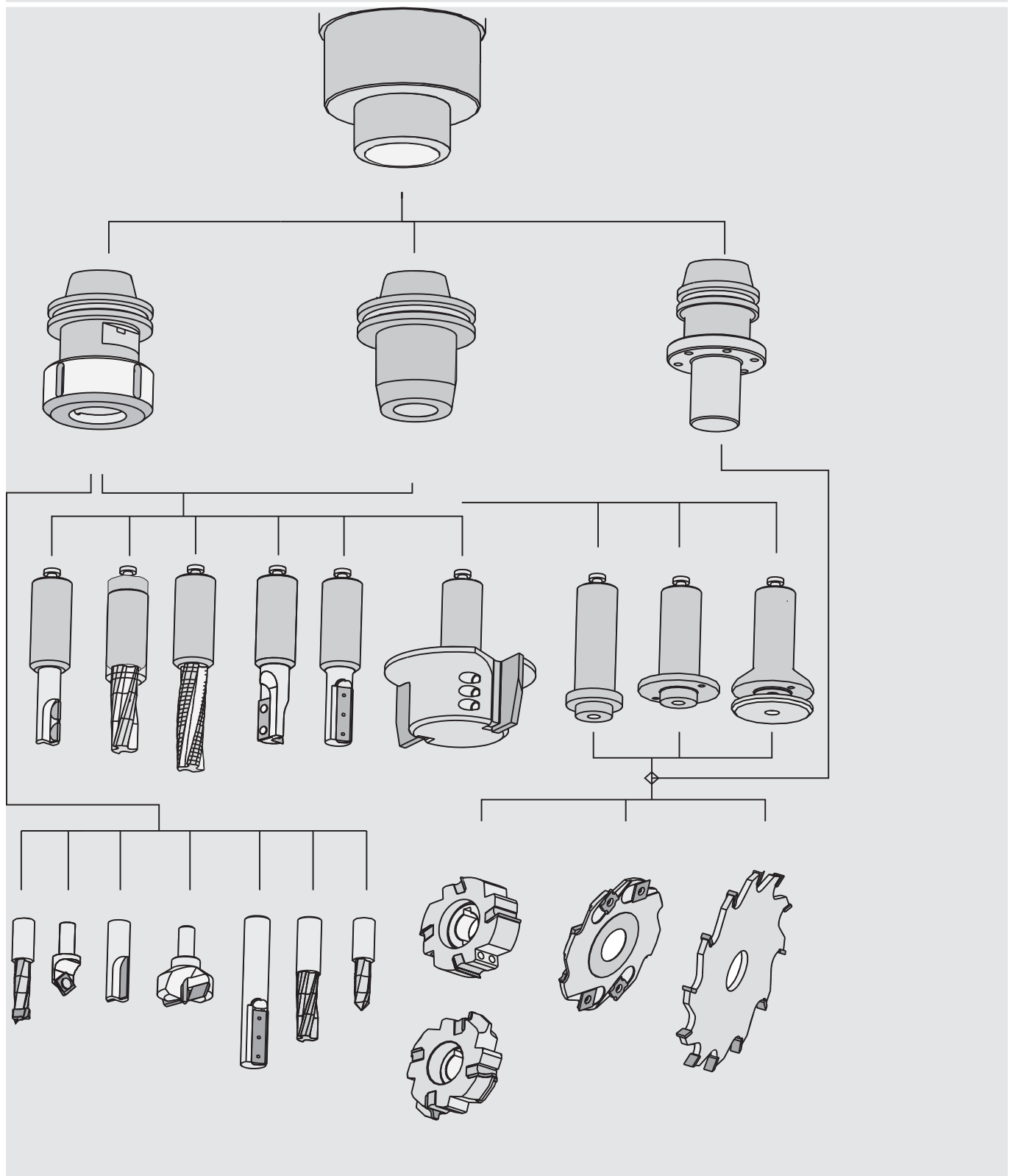
Spare parts

Class-No.

Ident-No.

Retention knobs	DIN 69872 A	for SK 30	997870	169293
Retention knobs	DIN 69872 B	for SK 40	997870	179339

Chart Tool Holders machine interface HSK-Mounting



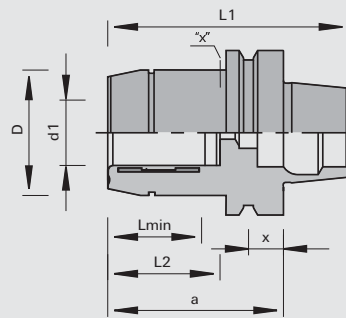
933240

Hydro Clamping Chucks ps-System with HSK 63F shank

Product



Drawing



LEUCO
ps-System

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise clamping of shank-type tools with cylindrical shank

Design

- l n max = 30,000 min -1
- l interface DIN 69893 HSK 63 F

Advantages

- l minimization of setup-times thanks to easy and quick tool change
- l high cutting quality and long edge lives thanks to high concentricity
- l optimum torque transfer

Notes

- l for right- and lefthand rotation
- l with bore for installation of micro chips for electronic tool detection
- l x = impressurement by means of screwdriver
- l hexagonal screwdriver is not included in delivery
- l Lmin minimum clamping length = minimum shaft length

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
10	31	41	HSK 63F	30	105	80	18	1.2	184725
12	36	46	HSK 63F	32	105	80	18	1.16	184306
16	39	49	HSK 63F	38	105	80	18	1.20	184307
20	41	51	HSK 63F	52.5	105	80	18	1.30	184308
25	47	57	HSK 63F	52.5	109	84	18	1.28	184309
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	Lmin	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
3/8	31	41	HSK 63F	30	105	80	18	1.2	184724
1/2	36	47,5	HSK 63F	32	105	80	18	1.2	184726
[inch]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Suitable for

Class-No.

Ident-No.

Screwdrivers	SW4x100	184306, 184724, 184725, 184726	985730	166091
Screwdrivers	SW5x150	184307, 184308, 184309	985730	168703
	[mm]			

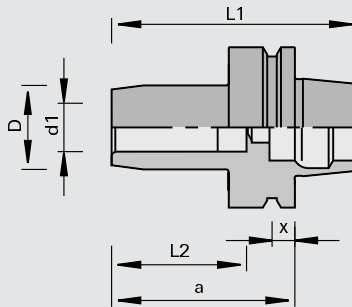
933299

Tribos Pressure Shrinking Chucks

Product



Drawing

LEUCO
CNC

Machine / Application

l CNC machining centers with automatic tool changer
l for precise clamping of shank-type tools with cylindrical shank

Design

l n max = 40,000 min-1

Advantages

l low weight is easy on machine bearing
l suitable for high RPM's
l optimum chip extraction thanks to slim design
l increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

l for right- and lefthand rotation
l different diameters upon request
l allowed projection: 4 x d1
l clamping of the tools by means of the clamping device
l can also be done at LEUCO upon request
l Tribos chuck with reinforced design especially for heavy roughing can be delivered upon request
l delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Ø d1	L2	Ø d	Ø D	L1	a	x	Weight	Ident-No.
12	48,5	HSK 63F	19	100	75	18	0.69	180257
16	48,5	HSK 63F	26	100	75	18	0.74	180899
20	52,9	HSK 63F	30	100	75	18	0.77	180258
25	55	HSK 63F	35	100	75	18	0.79	180710
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Ø d1	L2	Ø d	Ø D	L1	a	Ident-No.
20	55	SK 30 (DIN)	30	127	80	180888
25	55	SK 30 (DIN)	35	127	80	180836
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

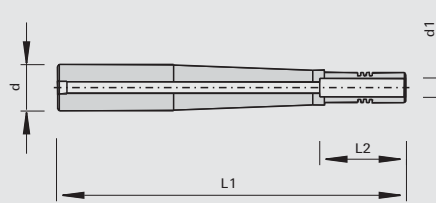
	Class-No.	Ident-No.
Mounting Devices (manual)	985201	180261
Mounting Devices (automatic)	985201	181159 o
Adjustment Inserts for Ø d = 6	955530	183719 o
Adjustment Inserts for Ø d = 8	955530	183720 o
Adjustment Inserts for Ø d = 10	955530	183721 o
Adjustment Inserts for Ø d = 12	955530	180263
Adjustment Inserts for Ø d = 16	955530	180902
Adjustment Inserts for Ø d = 20	955530	180264
Adjustment Inserts for Ø d = 25	955530	180711
Length adjusting device Tribos system without interface cable	985300	180828 o
Interface Cables for Adjusting Gauges for RS 232C interface	985300	180829 o

933299

Tribos extension

Product

Drawing



LEUCO
CNC

Machine / Application

for mounting of shank-type tools with cylindrical shank in Sino, Tribos, PS 2000-E

Design

shank diameter tolerance h7 or g7

Advantages

Notes

minimum clamping length = L2
clamping and unclamping of the tools with Tribos clamping device

Ø d1	L2	Ø d	L1	Ident-No.
6	27	20	100	182800 o
8	27	20	100	182801 o
10	32	20	100	182802 o
12	37	20	100	182803 o
6	27	20	150	182804 o
8	27	20	150	182805 o
10	32	20	150	182806 o
12	37	20	150	182807 o
6	27	20	250	182808 o
8	27	20	250	182809 o
10	32	20	250	182810 o
12	37	20	250	182811 o
[mm]	[mm]	[mm]	[mm]	

Spare parts

Class-No.

Ident-No.

Adjustment Inserts	for Ø d = 6	955530	183719 o
Adjustment Inserts	for Ø d = 8	955530	183720 o
Adjustment Inserts	for Ø d = 10	955530	183721 o
Adjustment Inserts	for Ø d = 12	955530	180263

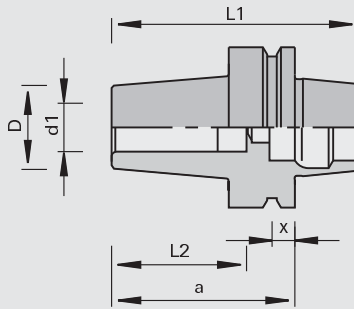
933297

Heat-Shrinking Chucks

Product



Drawing

LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | $n_{max} = 30,000 \text{ min}^{-1}$
- | interface DIN 69893 HSK 63 F
- | from high-quality hot work tool steel

Advantages

- | increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy ($< 0.003 \text{ mm}$)

Notes

- | for clockwise and counter-clockwise rotation
- | can be clamped and unclamped with all conventional shrinking devices

$\varnothing d1$	L2	$\varnothing d$	$\varnothing D$	L1	a	x	Weight	Ident-No.
10	41	HSK 63F	26	100	75	18	0.840	183081
12	47	HSK 63F	28	100	75	18	0.830	183082
14	47	HSK 63F	28	100	75	18	0.870	183083
16	51	HSK 63F	28	100	75	18	0.850	183084
18	51	HSK 63F	30	100	75	18	0.960	183085
20	51	HSK 63F	30	100	75	18	0.930	183086
25	51	HSK 63F	30	100	75	18	0.860	183087
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	



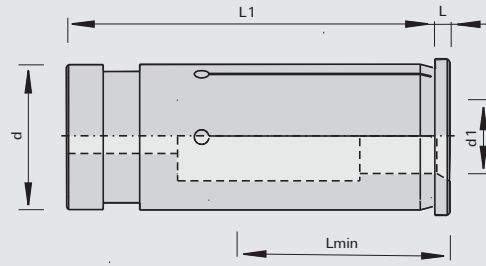
933280

Universal Reducing Bushings

Product



Drawing



LEUCO
GNC

Machine / Application

for mounting of shank-type tools in Sino, Tribos, ps-System

Design

shank diameter tolerance h7 or g7

Advantages

Notes

Lmin minimum clamping length = minimum shaft length

Ø d1	Ø d1	Lmin	Ø d	L1	Ident-No.
3		27	12	45	183022 o
4		27	12	45	183023 o
5		27	12	45	183024 o
6		27	12	45	183025
8		27	12	45	183026
3		27	20	50.5	183027 o
4		27	20	50.5	183028 o
5		27	20	50.5	183029 o
6		27	20	50.5	183030 o
7		27	20	50.5	183031 o
8		27	20	50.5	183032
9		27	20	50.5	183033 o
10		32	20	50.5	183034
11		37	20	50.5	183035 o
12		37	20	50.5	183036
13		37	20	50.5	183037 o
14		37	20	50.5	183038 o
15		38	20	50.5	183039 o
16		38	20	50.5	183040
17		38	20	50.5	183041 o
6		27	25	54.5	182304
8		27	25	54.5	182305
10		32	25	54.5	182306
12		37	25	54.5	182307
14		37	25	54.5	182308
16		38	25	54.5	182309
18		38	25	54.5	182310
20		42	25	54.5	182311
	1/2	37	25	54.5	182653
	5/8	38	25	54.5	182654 o
	3/4	42	25	54.5	182655
[mm]	[inch]	[mm]	[mm]	[mm]	

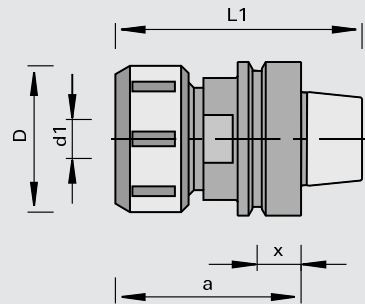
933289

Draw-In Collet Chucks with HSK shank

Product



Drawing


LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | interface according to DIN 69893 HSK 50F, HSK 63F and HSK 63E
- | lock nut with sleeve bearing

Advantages

- | flexible utilization by collet chucks

Notes

- | for right- and lefthand rotation
- | Ident-No. 175795 for IMA (up to 12/94) similar to DIN 69893
- | $\varnothing d1$ = collet chuck diameter 2 - 25 mm
- | collet chucks according to DIN 6388: 1) type 462E/OZ25/ 2) type 472E/ER40
- | included in delivery: collet chuck, clamping nut without spanner wrench
- | attention: different interfaces in case of CMS machines, according to spindle performance (KW)

$\varnothing d1$	$\varnothing d$	$\varnothing D$	L1	a	x	Type	Ident-No.	
2-25	HSK 63F	60	101	76	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, SCM, CMS (12+15 KW)	173293
2-25	HSK 63E	63	103	78	18	2	CMS (18 KW)	180359
2-25	HSK 63F	60	101	76	9	1	IMA up to 12/94	175795
2-25	HSK 63F	60	140	115	18	1	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, CMS (12+15 KW)	179170
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

Class-No.

Ident-No.

Lock Nut with sleeve bearing	M48x2R	995290	178764
Hook Wrenches	SW58/62 DIN 1810	985720	169299
Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	178760
	[mm]		

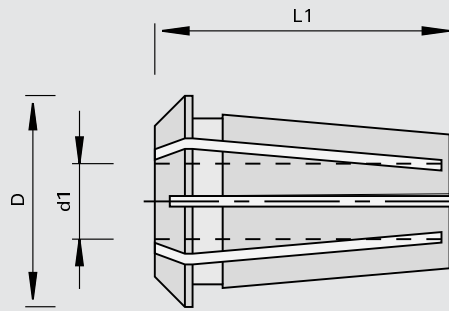
933280

Precision collets - 462E/OZ25

Product



Drawing



LEUCO
GVC

Machine / Application

for use in draw-in collet chuck
Type 462E/OZ25

Design

clamping tolerance 0.5 mm
according to DIN 6388 Type
462E/OZ25

Advantages

optimum transmission of
clamping force thanks to 12
slots from top and bottom

Notes

Ø d1	Ø d1	Ø D	L1	Ident-No.
2		35.05	52	183803 o
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4	35.05	52	175815
7		35.05	52	183807 o
8		35.05	52	180358
9,5		35.05	52	175817
	3/8	35.05	52	185275
10		35.05	52	170782
12		35.05	52	168742
	1/2	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8	35.05	52	175823
15		35.05	52	183808 o
16		35.05	52	168743
18		35.05	52	180216
	3/4	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	

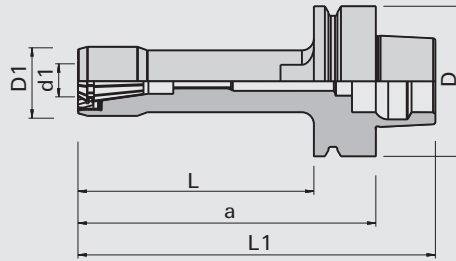
933289

draw-in collet chuck system 426E/ER16 with HSK 63F - clamping zone \varnothing 1-10 mm

Product



Drawing

LEUCO
CNC

Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 36,000 min-1

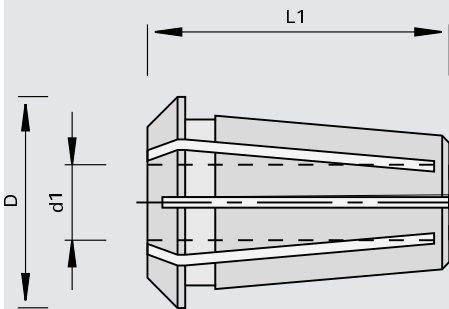
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 426E/ER16: 25 - 60 Nm (30 - 44 Lbf.ft)

\varnothing d1	\varnothing D1	\varnothing d	\varnothing D	L	L1	a	Ident-No.
1-10	29	HSK 63F	63	50	101	76	184847
1-10	29	HSK 63F	63	74	125	100	184848
1-10	29	HSK 63F	63	99	150	125	184849
1-10	29	HSK 63F	63	124	175	150	184850
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 426E / ER 16

\varnothing d1	\varnothing D	L1	Ident-No.
1	17.25	27.5	184865 o
2	17.25	27.5	184866 o
3	17.25	27.5	184867 o
4	17.25	27.5	184868 o
5	17.25	27.5	184869 o
6	17.25	27.5	184870
7	17.25	27.5	184871 o
8	17.25	27.5	184872
9	17.25	27.5	184873 o
10	17.25	27.5	184874
[mm]	[mm]	[mm]	

Accessories	Class-No.	Ident-No.
[a] Lock Nuts	995290	184875
[b] hand spanner	985720	184878
[c] screw-in aid	985720	184881
[d] torque nut	985720	184884
[e] torque adapter	985300	184887
[f] torque wrench 20-200Nm	985300	184890



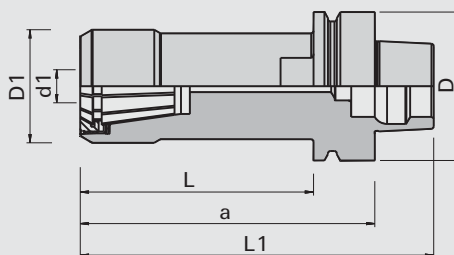
933289

draw-in collet chuck system 470E/ER32 with HSK 63F - clamping zone \varnothing 2-20 mm

Product



Drawing


LEUCO
CNC

Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 36,000 min-1

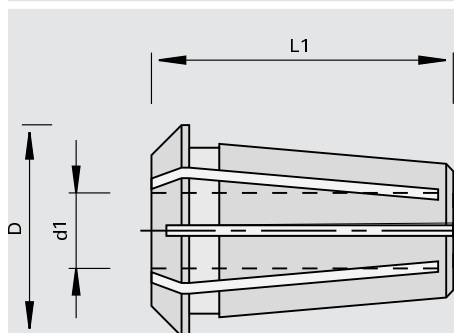
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 470E/ER32: 80 - 130 Nm (70 - 96 Lbf.ft)

\varnothing d1	\varnothing D1	\varnothing d	\varnothing D	L	L1	a	Ident-No.
2-20	48	HSK 63F	63	34	85	60	184851
2-20	48	HSK 63F	63	44	95	70	184852 o
2-20	48	HSK 63F	63	89	140	115	184853
2-20	48	HSK 63F	63	99	150	125	184854
2-20	48	HSK 63F	63	124	175	150	184855 o
2-20	48	HSK 63F	63	154	205	180	184856
2-20	48	HSK 63F	63	174	225	200	184857
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



Collets 470E / ER 32

\varnothing d1	\varnothing D	L1	Ident-No.
3	33	40	173647 o
4	33	40	173648 o
5	33	40	173649 o
6	33	40	173650
7	33	40	173651 o
8	33	40	173652
10	33	40	173653
12	33	40	173654
13	33	40	173655 o
14	33	40	173656 o
16	33	40	173657
18	33	40	173658 o
19	33	40	173659 o
20	33	40	173660
[mm]	[mm]	[mm]	

Accessories	Class-No.	Ident-No.
[a] Lock Nuts	995290	184876
[b] hand spanner	985720	184879
[c] screw-in aid	985720	184882
[d] torque nut	985720	184885
[e] torque adapter	985300	184888
[f] torque wrench 20-200Nm	985300	184890



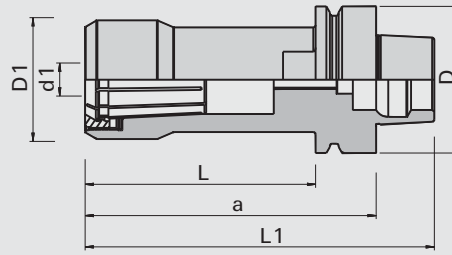
933289

draw-in collet chuck system 462E/OZ25 with HSK 63F - clamping zone \varnothing 2-25 (1") mm

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers, especially 5-axis
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | internal collet nut
- | hardened and ground
- | for double-slotted collets
- | with anticorrosive coating
- | n max = 36,000 min-1

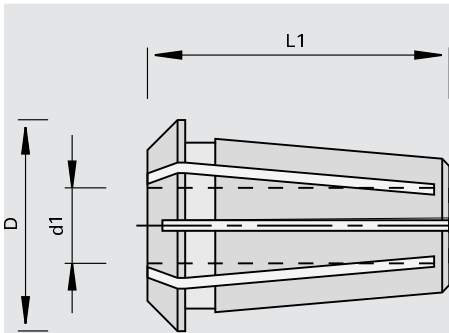
Advantages

- | slim design
- | high stability even with large projection
- | high concentric accuracy
- | high clamping force

Notes

- | also available for left-hand sense of rotation
- | included in delivery: collet chuck with clamping nut, without collet and mounting accessories
- | torques: 462E/OZ25: 100 - 150 Nm (75 - 110 Lbf.ft)

\varnothing d1	\varnothing D1	\varnothing d	\varnothing D	L	L1	a	Ident-No.
2-25	51	HSK 63F	63	50	101	76	184858
2-25	51	HSK 63F	63	89	140	115	184860
2-25	51	HSK 63F	63	124	175	150	184861 o
2-25	51	HSK 63F	63	149	200	175	184862 o
2-25	51	HSK 63F	63	174	225	200	184863
2-25	51	HSK 63F	63	199	250	225	184864
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	



HSK-F63 Collet chucks 462E / OZ 25 /

\varnothing d1	\varnothing d1	\varnothing D	L1	Ident-No.
2		35.05	52	183803 o
3		35.05	52	183804
4		35.05	52	183805
5		35.05	52	183806
6		35.05	52	180213
	1/4	35.05	52	175815
7		35.05	52	183807 o
8		35.05	52	180358
9,5		35.05	52	175817
10		35.05	52	170782
12		35.05	52	168742
	1/2	35.05	52	175820
13		35.05	52	180215
14		35.05	52	170783
	5/8	35.05	52	175823
[mm]	[inch]	[mm]	[mm]	

HSK-F63 Collet chucks 462E / OZ 25 /

$\varnothing d1$	$\varnothing d1$	$\varnothing D$	L1	Ident-No.
15		35.05	52	183808
16		35.05	52	168743
18		35.05	52	180216
	3/4	35.05	52	175826
20		35.05	52	168744
25		35.05	52	168745
[mm]	[inch]	[mm]	[mm]	

Accessories	Class-No.	Ident-No.
[a] Lock Nuts	995290	184877
[b] hand spanner	985720	184880
[c] screw-in aid	985720	184883
[d] torque nut	985720	184886
[e] torque adapter	985300	184889
[f] torque wrench 20-200Nm	985300	184890



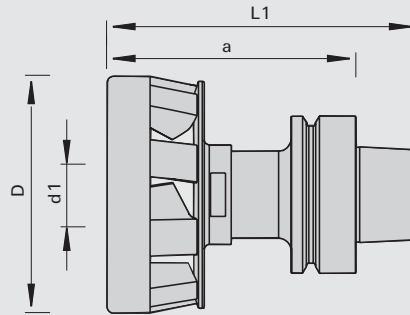
933285

AEROTECH SYSTEM with HSK 63F with collet chuck adapter

Product



Drawing

LEUCO
CNC**Machine / Application**

- | CNC machining centers
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production process e.g. with Nesting applications
- | for tools with shank diameter up to 16 mm

Design

- | tool adapter with high-precision collet chucks
- | 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- | 7 wing design for low-density materials (e.g. soft wood) as well as gypsum boards etc.
- | tool mounting by means of clamping key or pre-adjusted torque wrench (recommended)

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance

Notes

- | balance quality G=2.5
- | n max. = 24,000 min-1
- | sufficient vacuum performance is necessary
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-16	HSK 63F	95	125	100	9 wings	184652
6-16	HSK 63F	95	125	100	7 wings	184665 o
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts**Dimension****Class-No.****Ident-No.**

collet chucks	Ø 6 mm	933280	184653 o
collet chucks	Ø 8 mm	933280	184654 o
collet chucks	Ø 10 mm	933280	184655
collet chucks	Ø 12 mm	933280	184656
collet chucks	Ø 14 mm	933280	184657
collet chucks	Ø 16 mm	933280	184658
collet chucks	Ø 1/4"	933280	184659 o
collet chucks	Ø 3/8"	933280	184660
collet chucks	Ø 1/2"	933280	184661
collet chucks	Ø 5/8"	933280	184662 o
set screw for 184665		995191	185155
set screw for 184652		995191	185154
torque wrench 40 Nm		985730	184667
mounting devices incl. torque wrench 40 Nm		985202	184666
	[mm]		

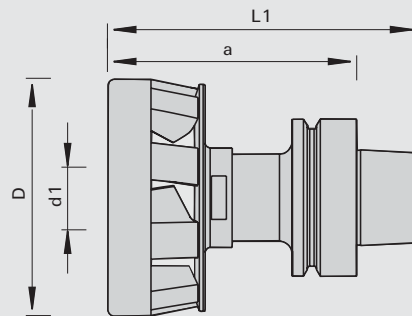
933285

AEROTECH SYSTEM with HSK 63F with hydro expansion clamping

Product



Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers
- | for clamping of shank-type tools and simultaneous chip guide when working
- | for grooving, rabbeting in the case of pocket milling and dividing cuts as well as for the optimization of production processes e.g. with Nesting applications

Design

- | monolithic tool clamping system
- | 9 wing design for the machining of particle board, MDF, OSB, hard wood etc.
- | tool mounting by means of hydro expansion clamping technology
- | balance quality G<2,5

Advantages

- | stopping of the chip flow
- | cooling of the tool
- | reduction of the dust quantity
- | reduced efforts for cleaning and maintenance
- | minimization of setup-times thanks to easy and quick tool change with hydro expansion clamping
- | high cutting quality and long edge lives thanks to high concentricity
- | optimum torque transfer

Notes

- | sufficient vacuum performance is necessary
- | impressurement via hexagonal screwdriver (included in delivery)
- | Ident-No. 184757: clamping of smaller shank diameters is possible by means of LEUCO universal reducing sleeves
- | please observe the information in the Operating Instructions

Ø d1	Ø d	Ø D	L1	a		Ident-No.
6-25	HSK 63F	105	131	106	9 wings	184757
[mm]	[mm]	[mm]	[mm]	[mm]		
Spare parts			Dimension		Class-No.	Ident-No.
Screwdrivers with sliding handle for hexagon socket SW4x100					985730	166091
			[mm]			

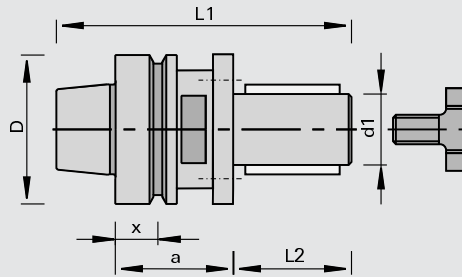
997300

Mounting Arbors with HSK shank

Product



Drawing

LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise mounting of tools with bore with double keyway

Design

- | with 6 pin holes M6 - 8 mm deep TK 48 mm
- | interface DIN 69893 HSK 63 F
- | clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- | secured against rotation with double key

Advantages

- | high feed rates thanks to optimum torque transfer

Notes

- | for clockwise and counter-clockwise rotation
- | spacer ring Ident-No. 181193 consists of: 1 piece 20 mm thick, 1 piece 10 mm thick, 3 piece 5 mm thick, 2 piece 2 mm thick, 1 piece 1 mm thick
- | spacer ring set Ident-No. 181194 additionally 1 piece 20 mm thick, 1 piece 10 mm thick
- | tool attached with retaining bolt
- | included in delivery: clamping arbor with retaining bolt

Ø D	Ø d	Ø d1	L2	L1	a	x	DKN	Weight		Ident-No.
63	HSK 63F	30	50	120	45	18	8 x 3	1.4	Homag, IMA from 01/95	183748
63	HSK 63F	30	80	150	45	18	8 x 3	1.5	Homag, IMA from 01/95, HOLZHER	183749
63	HSK 63F	30	110	180	45	18	8 x 3	1.4	Homag, IMA from 01/95, HOLZHER	183747
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kg]		

Spare parts

Dimension

Class-No.

Ident-No.

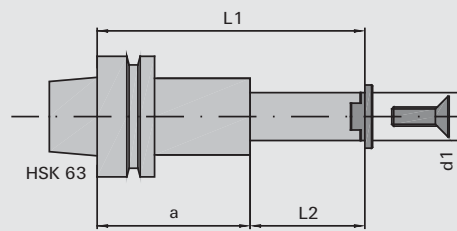
Single-Head Engineers Wrenches	SW46x10 DIN 894	985720	178760
Cutter Retaining Bolts	M16x26xØ42	995190	173592
Spacer Sets	60x50x30	955521	181193
Spacer Sets	60x80x30	955521	181194
	[mm]		

997300

Mounting Arbors HSK 63F

Product

Drawing



LEUCO
CNC

Machine / Application

l CNC machining centers with automatic tool changer
l for mounting of Modula sets or single cutters

Design

l interface DIN 69893 HSK 63 F
l secured against rotation with double key

Advantages

Notes

l for right- and lefthand rotation
l included in delivery: mounting arbor with cover and countersunk screw

Ø d	Ø d1	L2	L1	a	Weight	Ident-No.
HSK 63F	25	37	119	45	1.1	183768
HSK 63F	25	85	167	45	1.2	183769
HSK 63F	25	37	149	80	1.3	183770
HSK 63F	25	75	187	80	1.5	183771
[mm]	[mm]	[mm]	[mm]	[mm]	[kg]	

Accessories

Dimension

Class-No.

Ident-No.

Spacers	40x0,1x25	955520	183756
Spacers	40x0,2x25	955520	183757
Spacers	40x0,5x25	955520	183758
Spacers	40x1x25	955520	183759
Spacers	40x2x25	955520	183760
Spacers	40x4x25	955520	183761
Spacers	40x6x25	955520	183762
Spacers	40x10x25	955520	183763
Spacers	40x20x25	955520	183764
	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

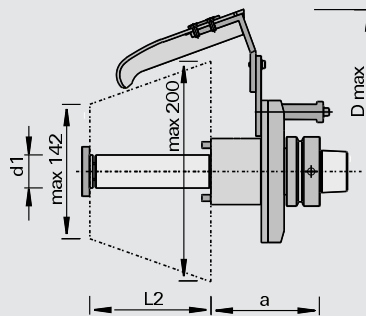
Covers	33x11x25	997300	183772	o
Countersunk Flat Headed Screws	M10x30 DIN EN ISO 10642	995121	183773	o
Screwdrivers	SW6x200	985730	167817	
	[mm]			

997300

Milling Assemblies with chip directing steel sheet

Product

Drawing

LEUCO
CNC

Machine / Application

- | CNC-machining centers with C-axis Homag
- | for precise mounting of tools with bore

Design

- | milling aggregate with integrated chip directing steel sheet
- | Ident-No. 182049 and 182050 with double keyway
- | Ident-No. 182075 and 182076 with lid and retaining bolt; 2 carrier pins Ø6 TK 48
- | n max = 11,000 min-1 (stock design)
- | shank 30 mm, shank length 105 mm

Advantages

- | optimized chip removal

Notes

- | weight of the component approx. 2 kg (depending on design)
- | max. weight of the clamped tool 3,8 kg

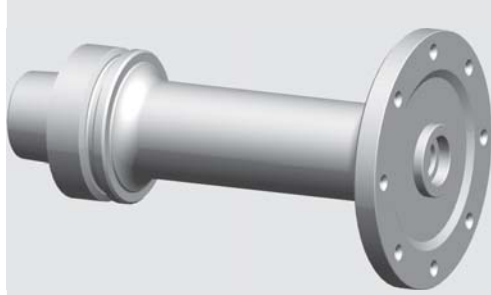
Ø Dmax	Ø d	Ø d1	L2	a	DKN		Ident-No. [L]	Ident-No. [R]
300	HSK 63F	30	105	80	8 x 4	Homag	182049 o	182050 o
300	HSK 63F	30	105	80		Homag	182075 o	182076 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			



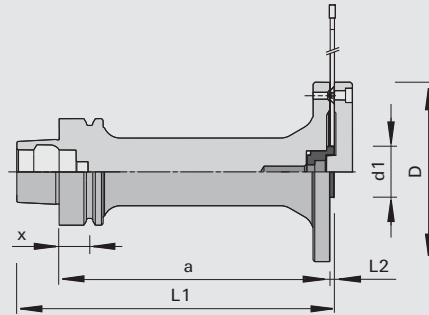
997300

CNC Combi Saw Blade Adapters HSK 63F

Product



Drawing



LEUCO
CNC

Machine / Application

- l CNC machining centers with automatic tool changer
- l for precise mounting of circular saw blades

Design

- l interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

- l exchangeable centering adapter can be obtained separately; thus saw blades with different bore diameters can be used on the same mounting device
- l the mounting of the saw blade can be made with or without lid
- l adapter available with different a measures

Notes

- l for right- and lefthand rotation
- l mounting of the saw directly by means of countersunk screws or lid by means of cylinder head screw
- l included in delivery: lid, countersunk screws, cylinder head screws and centering adapter for saw blade bore Ø 30 mm

Ø D	Ø d	Ø d1	L2	L1	a	x	NL	Ident-No.
106	HSK 63F	30	2,5	65	40	18	8/M5/90	184835
106	HSK 63F	30	2,5	75	50	18	8/M5/90	184836
106	HSK 63F	30	2,5	125	100	18	8/M5/90	184837
106	HSK 63F	30	2,5	155	130	18	8/M5/90	184838
106	HSK 63F	30	2,5	185	160	18	8/M5/90	184839
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Options

Dimension

Class-No.

Ident-No.

Covers	106x15x20	997300	184845
Adapter	Ø 30 mm	997300	184840
Adapter	Ø 31,75 mm	997300	184841
Adapter	Ø 32 mm	997300	184842
Adapter	Ø 35 mm	997300	184843
Adapter	Ø 40 mm	997300	184844
	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

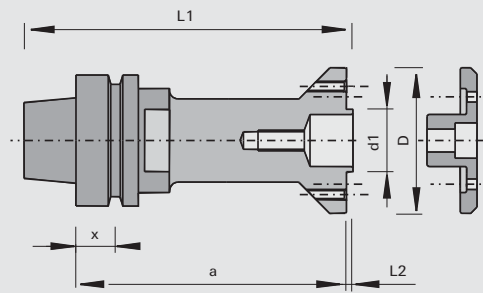
Countersunk Flat Headed Screws	M5x8 T20	995125	164005
Head Cap Screws	M5x16 DIN EN ISO 4762	995111	001870
Cylinder head screws for adapters	M8x12 DIN 7984	995111	184846
	[mm]		

933061

Saw Blade Adapters HSK 63F modified

Product

Drawing

LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for precise mounting of circular saw blades and grooving cutters

Design

- | interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

Notes

- | for clockwise and counter-clockwise rotation
- | mounting of the saw directly by means of countersunk screw or lid 183310 by means of cylinder head screw
- | included in delivery:
 - | adapter with countersunk screws
 - | lid with cylinder head screws to be ordered separately

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
70	HSK 63F	30	2,5	157,5	130	8/M5/52	183309
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M5x8 T20
[mm]

995125

164005

Accessories

Dimension

Class-No.

Ident-No.

Lid with cylinder head screws

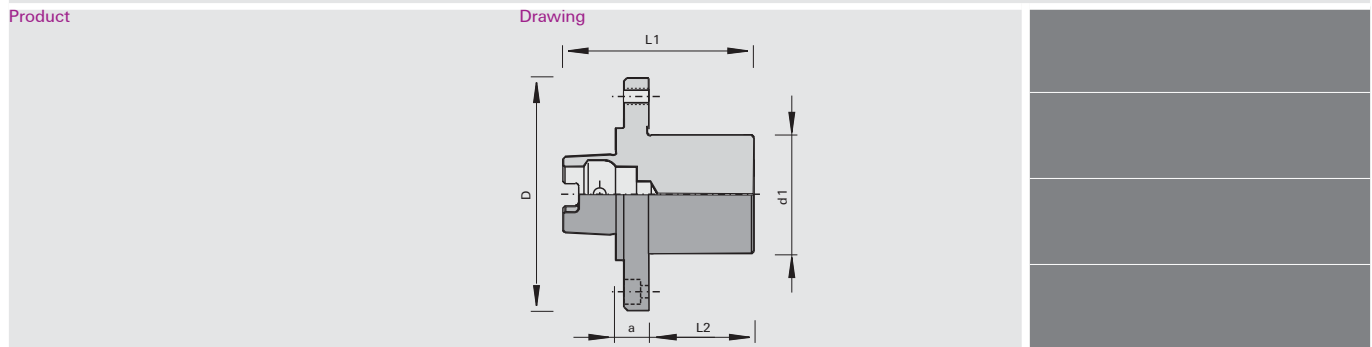
70x24x8
[mm]

997300

183310

933061

Mounting Arbors HSK 63F modified - without gripper groove

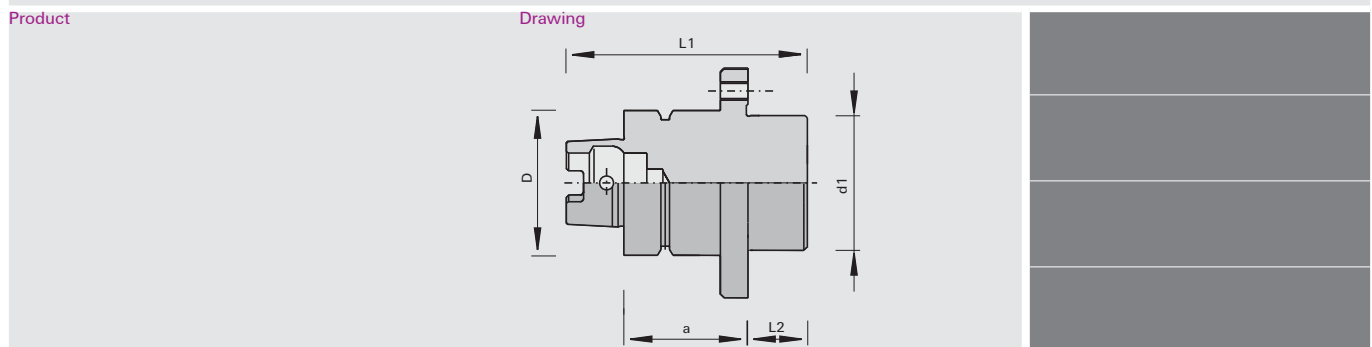


Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> through-feed machines with tool changer Homag d1=30 mm especially for Homag and IMA jointing aggregates d1=60 mm especially for flooring manufacturing for precise clamping of tools with bore 	<ul style="list-style-type: none"> interface DIN 69893 HSK 63 F modified for highly precise mounting on the machine spindle 	<ul style="list-style-type: none"> quick tool change maintenance-free 	<ul style="list-style-type: none"> for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
94	HSK 63F	30	25	66	16	4/M8/80	furniture 184787
120	HSK 63F	60	68	113	20	4/M8/100 + 4/9/100	Flooring 183616 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933061

Mounting Arbors HSK 63F modified - with gripper groove



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> through-feed machines with tool changer Homag for precise clamping of tools with bore 	<ul style="list-style-type: none"> with pulling grooves flange with fastening screw thread interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle 	<ul style="list-style-type: none"> quick tool change 	<ul style="list-style-type: none"> for clockwise and counter-clockwise rotation

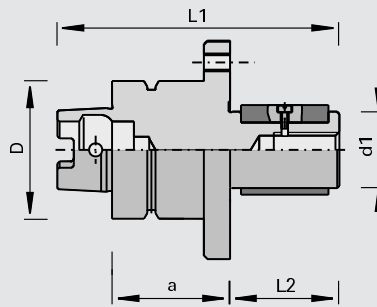
Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
63	HSK 63F	60	23,5	102.5	54	4/M8/80	183615 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

933061

Mounting Arbors HSK 63F modified - 35 DKN, with lid and screws

Product

Drawing



Machine / Application

- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design

- with pulling grooves
- flange with fastening screw thread
- interface DIN 69893 HSK 63 F for highly precise mounting on the machine spindle

Advantages

- quick tool change

Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
63	HSK 63F	35	40	119	54	8/M8/80	182689
63	HSK 63F	35	50	129	54	8/M8/80	182124
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

Head Cap Screws

M16x30

995111

182126 o

Covers

60x15x17
[mm]

997370

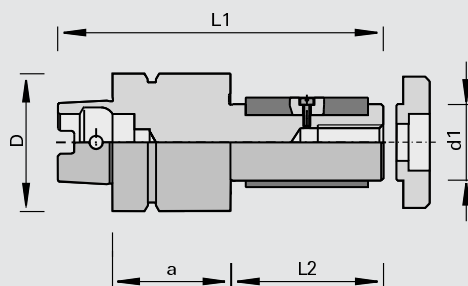
182127 o

933069

Mounting Arbors HSK 63F modified - 35 DKN, tool directly attached by screws

Product

Drawing



Machine / Application

- through-feed machines with tool changer Homag
- for precise clamping of tools with bore

Design

- with pulling grooves
- with lid and screw (included in delivery)
- interface DIN 69893 HSK 63 F modified for high-precision adapter to the machine spindle

Advantages

- quick tool change

Notes

- for clockwise and counter-clockwise rotation

Ø D	Ø d	Ø d1	L2	L1	a	Ident-No.
63	HSK 63F	35	40	119	54	182123
63	HSK 63F	35	70	149	54	182125
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dimension

Class-No.

Ident-No.

Head Cap Screws

M16x30

995111

182126 o

Covers

60x15x17
[mm]

997370

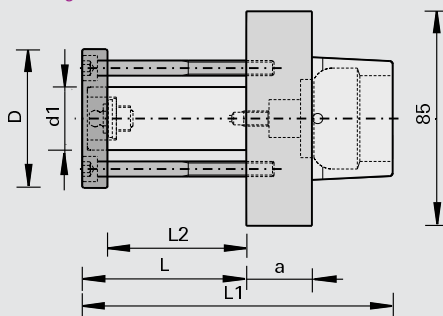
182127 o

997300

Hydro Tensile Spindles Weinig HSK - clamping length 40-55 mm

Product

Drawing



Machine / Application

l planing machines Weinig Powermat
l for precise clamping of tools with bore

Design

l with hydro-tensile spindle

Advantages

l precise mounting of tools with bore thanks to hydro-tensile spindle

Notes

l for clockwise and counter-clockwise rotation
l accessories: dummy piece for covering the HSK-interface on spindles not used

Ø D	Ø d	Ø d1	L2	L1	a	Ident-No.
85	Weinig HSK	30	40	108	26	181872 o
85	Weinig HSK	30	55	123	26	181873 o
85	Weinig HSK	40	55	123	26	181874 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dummy Pieces (cover)

Class-No.

997300

Ident-No.

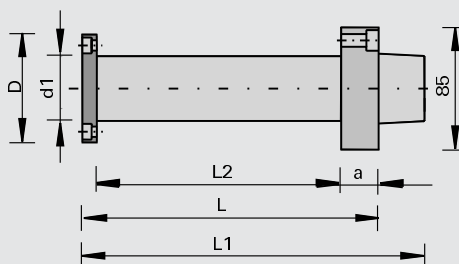
182286 o

997300

Hydro Tensile Spindles Weinig HSK - clamping length 170-210 mm

Product

Drawing



Machine / Application

l planing machines Weinig Powermat
l for precise clamping of tools with bore

Design

l with hydro-tensile spindle

Advantages

l precise mounting of tools with bore thanks to hydro-tensile spindle

Notes

l for clockwise and counter-clockwise rotation
l accessories: dummy piece for covering the HSK-interface on spindles not used

Ø D	Ø d	Ø d1	L2	L1	a	Ident-No.
85	Weinig HSK	40	170	238	26	181875 o
85	Weinig HSK	50	170	238	26	181877 o
85	Weinig HSK	50	210	278	26	181973 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts

Dummy Pieces (cover)

Class-No.

997300

Ident-No.

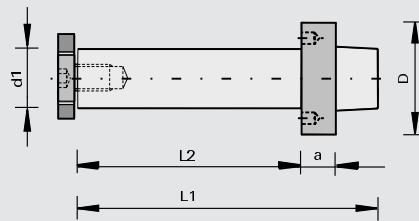
182286 o

997300

Mounting Arbors Weinig HSK

Product

Drawing



Machine / Application

Design

Advantages

Notes

l profile machines Weinig
Powermat
l for mounting of tools with bore

l for clockwise and counter-clockwise rotation
l other dimensions upon request
l for permissible RPM please refer to diagram

Ø D	Ø d	Ø d1	L2	L1	a	NL	Weight	Ident-No.
85	Weinig HSK	30	40	98	26	2/6/48+2/M6/48	1.7	182056 o
85	Weinig HSK	30	60	118	26	2/6/48+2/M6/48	1.8	182057 o
85	Weinig HSK	30	80	138	26	2/6/48+2/M6/48	1.9	182058 o
85	Weinig HSK	30	130	188	26	2/6/48+2/M6/48	2.2	182059 o
85	Weinig HSK	30	170	228	26	2/6/48+2/M6/48	2.4	182060 o
85	Weinig HSK	30	240	298	26	2/6/48+2/M6/48	2.8	182061 o
85	Weinig HSK	40	40	98	26	2/6/54+2/M6/54	1.9	182062 o
85	Weinig HSK	40	60	118	26	2/6/54+2/M6/54	2.1	182063 o
85	Weinig HSK	40	80	138	26	2/6/54+2/M6/54	2.3	182064 o
85	Weinig HSK	40	130	188	26	2/6/54+2/M6/54	2.8	182065 o
85	Weinig HSK	40	170	228	26	2/6/54+2/M6/54	3.2	182066 o
85	Weinig HSK	40	240	298	26	2/6/54+2/M6/54	3.9	182067 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

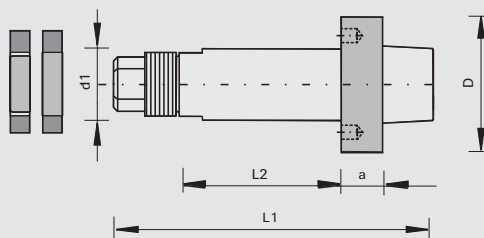


997300

Mounting Arbors Weinig HSK - with spindle nut

Product

Drawing



Machine / Application

Design

Advantages

Notes

l profile machines Weinig Powermat
l for mounting of tools with bore

l for clockwise and counter-clockwise rotation
l other dimensions on request
l for permissible RPM please refer to diagram
l included in delivery: mounting arbor incl. ring and spindle nut

Ø D	Ø d	Ø d1	L2	L1	a	NL	Weight	Ident-No.
85	Weinig HSK	40	40	143	26	2/6/54+2/M6/54	1.9	183281 s
85	Weinig HSK	40	60	163	26	2/6/54+2/M6/54	2.1	183282 s
85	Weinig HSK	40	80	183	26	2/6/54+2/M6/54	2.3	183283 s
85	Weinig HSK	40	100	203	26	2/6/54+2/M6/54	2.5	183284 s
85	Weinig HSK	40	130	233	26	2/6/54+2/M6/54	2.8	183285 s
85	Weinig HSK	40	150	253	26	2/6/54+2/M6/54	2.95	183286 s
85	Weinig HSK	40	170	273	26	2/6/54+2/M6/54	3.2	183287 s
85	Weinig HSK	40	180	283	26	2/6/54+2/M6/54	3.3	183288 s
85	Weinig HSK	40	210	313	26	2/6/54+2/M6/54	3.6	183289 s
85	Weinig HSK	40	230	333	26	2/6/54+2/M6/54	3.8	183290 s
85	Weinig HSK	40	240	343	26	2/6/54+2/M6/54	3.9	183291 s
85	Weinig HSK	40	270	373	26	2/6/54+2/M6/54	4.2	183292 s
85	Weinig HSK	40	310	413	26	2/6/54+2/M6/54	4.6	183293 s
85	Weinig HSK	50	40	143	26	2/6/74+2/M6/64	2.1	183294 s
85	Weinig HSK	50	60	163	26	2/6/74+2/M6/64	2.4	183295 s
85	Weinig HSK	50	80	183	26	2/6/74+2/M6/64	2.7	183296 s
85	Weinig HSK	50	100	203	26	2/6/74+2/M6/64	3.0	183297 s
85	Weinig HSK	50	130	233	26	2/6/74+2/M6/64	3.5	183298 s
85	Weinig HSK	50	150	253	26	2/6/74+2/M6/64	3.75	183299 s
85	Weinig HSK	50	170	273	26	2/6/74+2/M6/64	4.1	183300 s
85	Weinig HSK	50	180	283	26	2/6/74+2/M6/64	4.3	183301 s
85	Weinig HSK	50	210	313	26	2/6/74+2/M6/64	4.7	183302 s
85	Weinig HSK	50	230	333	26	2/6/74+2/M6/64	5.0	183303 s
85	Weinig HSK	50	240	343	26	2/6/74+2/M6/64	5.13	183304 s
85	Weinig HSK	50	270	373	26	2/6/74+2/M6/64	5.6	183305 s
85	Weinig HSK	50	310	413	26	2/6/74+2/M6/64	6.3	183306 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

Spare parts

Dimension

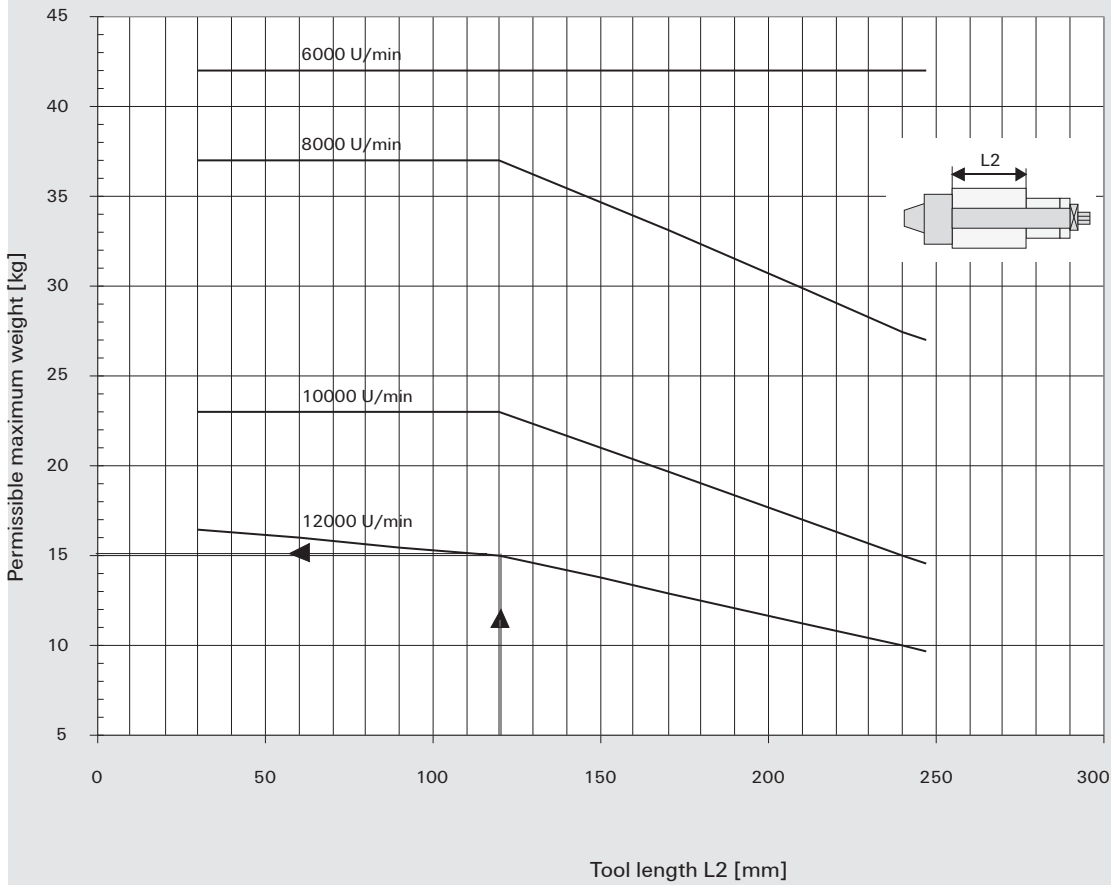
Class-No.

Ident-No.

Set Screws	M6x16 SW3	995161	001617
rings	60x15x35	995520	183308 o
spindle nuts	M33x1,5	995210	183307 o
	[mm]		

Adapter Weinig HSK

Diagram for PowerLock-Adapter



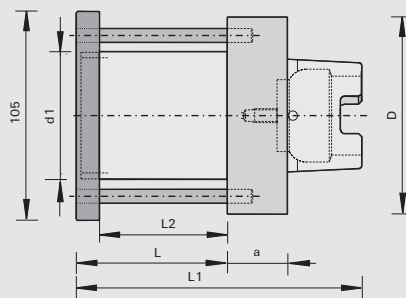
997300

Saw Blade Adapters Weinig HSK

Product



Drawing



Machine / Application

- ! Weinig Powermat
- ! for mounting of thin-kerf saw blades

Design

Advantages

Notes

- ! for clockwise and counter-clockwise rotation
- ! different diameters upon request

Ø D	Ø d	Ø d1	L2	L1	a	NL	Ident-No.
105	Weinig HSK	60	68	148	26	3/8/74	182974 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

Ident-No.

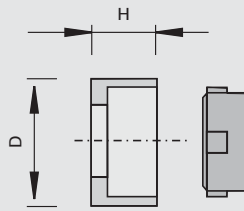
Lock Nuts	105x15xM58x1,5 [mm]	995290	182993 o
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994711

Balluff Chip for mounting in HSK 63F tool adapters

Product

Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with tool recognition system based on Balluff Chip
- | for machines Biesse, Reichenbacher, Homag

Design

Balluff Chip BIS C-122-04/L,
 511 Byte
 for mounting in HSK 63F tool
 adapters

Advantages

Notes

- | without reading / writing
- | reading / writing possible after clearance

	Ø D	H	Ident-No.
Balluff Chip with adapter	11,6 [mm]	6 [mm]	182558 o

Spare parts

Dimension

Class-No.

Ident-No.

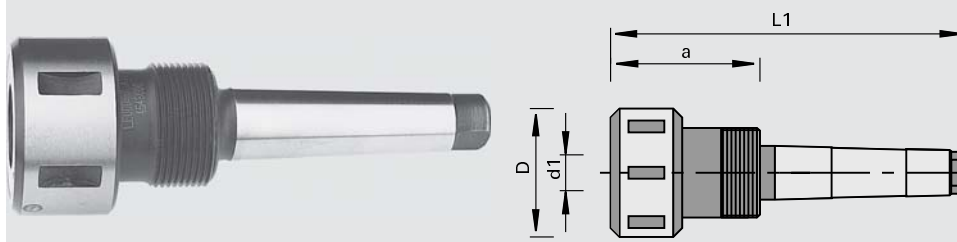
Adapter for Balluff Chip	Ø 11,6x6	956500	182560 o
Balluff Chip	Ø 10x4,5 [mm]	994711	182559 o

933250

Draw-In Collet Chucks with MK shank

Product

Drawing


LEUCO
CNC
Machine / Application

- | CNC machining centers
- | routers
- | for precise clamping of shank-type tools with cylindrical shank

Design

- | lock nut with sleeve bearing

Advantages

- | high concentricity thanks to ball-bearing mounted lock nut

Notes

- | for clockwise and counter-clockwise rotation
- | collet chucks DIN 6388 Type 415E/OZ16
- | included in delivery: collet chuck with lock nut

Ø D	Ø d	Ø d1	L1	a	Type	Ident-No.
43	MK 2	2-16	119	50	415E/OZ16	170784
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts**Dimension****Class-No.****Ident-No.**

Union Nuts	W 1 1/8"/M30x1,5	995290	165561
Ball-bearing lock nuts	M30x1,5R	995290	178763
Hook Wrenches	SW40/42 DIN 1810	985720	169298
	[mm]		



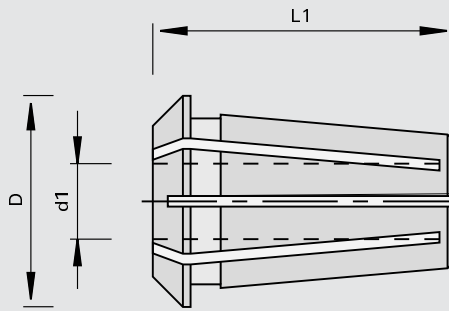
933280

Precision collets - 415E/OZ16

Product



Drawing



LEUCO
GNC

Machine / Application

for use in draw-in collet chuck
Type 415E/OZ16

Design

slotted from top and bottom
clamping tolerance 0.5 mm
according to DIN 6388 Type
415E/OZ16

Advantages

Notes

Ø D	Ø d1	L1	Ident-No.
25.5	2,5	40	820753 o
25.5	3	40	820754 o
25.5	4	40	820494 o
25.5	4,5	40	830236 o
25.5	5	40	820495 o
25.5	6	40	170779 o
25.5	6,35	40	821421 o
25.5	7	40	829692 o
25.5	8	40	170780
25.5	9	40	825190 o
25.5	9,5	40	168739 o
25.5	10	40	170781
25.5	12	40	168740
25.5	12,7	40	830156 o
25.5	13	40	821221 o
25.5	16	40	168741
[mm]	[mm]	[mm]	

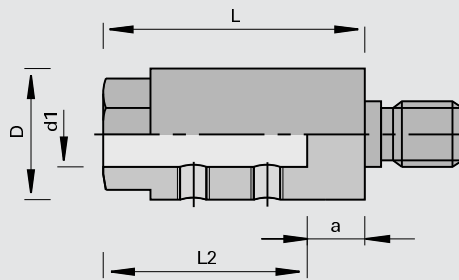
933350

Clamping Chuck Combi Systems

Product



Drawing



Machine / Application

for mounting of drill bits with cylindrical shank and clamping surface

Design

drill bits are clamped with setscrews

Advantages

Notes

clamping chucks with "BSS" mark are compatible with quick-changing system for drill bits
for threaded shank design and appropriate machines see technical information

Ø D	Ø d1	L2	L	a	Type	Ident-No. [L]	Ident-No. [R]
15	8	20	22	2	D	161282 o	161281 o
15	8	20	24.5	4.5	A	010683 o	010677 o
15	8	20	24.5	4.5	B	161285 o	161284 o
15	8	20	24.5	4.5	C	058412 o	058411 o
15	8	20	37	17	C	059300	059299
19	10	20	24.5	4.5	A	003575	003574
19	10	20	24.5	4.5	B	008003	008002
19	10	20	24.5	4.5	C	058414	058413
19	10	20	25	5	D	003571	003570
19	10	20	25	5		183055 o	183055 o
19	10	20	47	27	G	161287	161286
19	10	20	29.3	9.3	F	003573	003572
19	10	20	28.5	8.5	E	161987 o	161283 o
19	10	20	37	17	C	161681	161680
19	10	20	47	27	D	170372 s	170371 s
[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Dimension

For Ø D

Class-No.

Ident-No.

Set Screws	M6x4 DIN EN ISO 4029	15	995161	167068
Set Screws	M6x5 DIN EN ISO 4029	19	995161	165049
Set Screws	M5x4 DIN EN ISO 4029	15	995161	001608
	[mm]	[mm]		

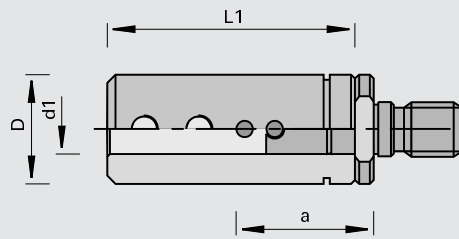
933321

Klack Quick-Changing Chucks with hole pitch 19 mm

Product



Drawing



Machine / Application

- for boring machines
- for mounting of drill bits with cylindrical shank and clamping surface

Design

- for clamping of the drill bit with hex socket setscrews

Advantages

- low downtimes thanks to fast drill bit changes

Notes

- for small hole pitch widths (19 mm)
- top part is drill bit seat
- bottom part to install on the machine spindle
- for threaded shank design and appropriate machines see technical information

Ø D	Ø d1	L1	Ident-No.
15	8	35	162014
[mm]	[mm]	[mm]	

Bottom part	Type	a	Class-No.	Ident-No. [L]	Ident-No. [R]
	A	19	933322	162015	162016
	C	19	933322	162017	162018
		[mm]			

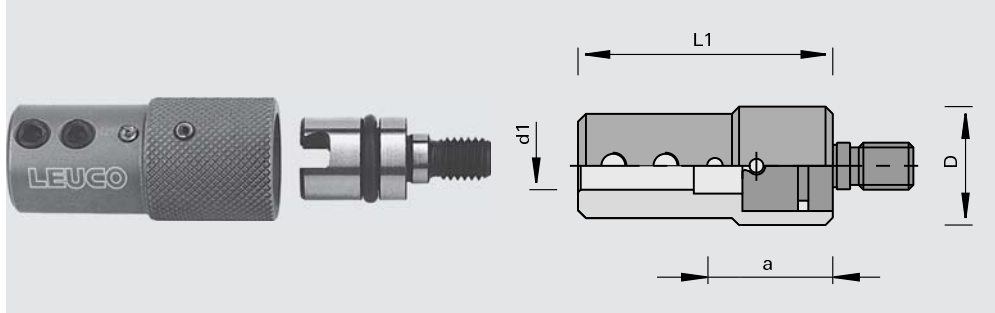
Spare parts	Dimension	Class-No.	Ident-No.
Springs	0,8 DIN 17223	995790	162948
Set Screws	M5x4 DIN EN ISO 4029	995161	001608
Cranked Wrench Keys	SW2,5 DIN ISO 2936	985730	009671
	[mm]		

933321

Klack Quick-Changing Chucks with hole pitch 25 mm

Product

Drawing



Machine / Application

for boring machines Nottmeyer
for mounting of drill bits with cylindrical shank and clamping surface

Design

for clamping of the drill bit with hex socket setscrews

Advantages

low downtimes thanks to fast drill bit changes

Notes

for medium hole pitch widths (25 mm)
top part is drill bit seat
bottom part to install on the machine spindle
for threaded shank design and appropriate machines see technical information

Ø D	Ø d1	L1	Ident-No.
22	10	47	166992
22	8	49	166074
[mm]	[mm]	[mm]	

Bottom part	Type	a	Class-No.	Ident-No. [L]	Ident-No. [R]
	C	19	933322	166075	166076
		[mm]			

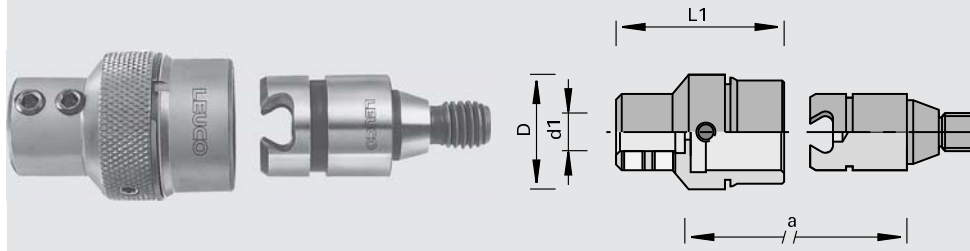
Spare parts	Dimension	Class-No.	Ident-No.
Multi-Purpose Greases		993520	056746
Special Levers		997100	166095
Set Screws	M5x4 DIN EN ISO 4029	995161	001608
Set Screws	M6x5 DIN EN ISO 4029	995161	165049
O-Rings	10,77x2,62	995490	166078
	[mm]		

933321

Klack Quick-Changing Chucks with hole pitch 32 mm

Product

Drawing



Machine / Application

- for boring machines
- for mounting of drill bits with cylindrical shank and clamping surface

Design

- for mounting of drill bits with cylindrical shank and clamping surface

Advantages

- low downtimes thanks to fast drill bit changes

Notes

- for larger hole pitch widths (32 mm)
- top part is drill bit seat
- bottom part to install on the machine spindle
- for threaded shank design and appropriate machines see technical information

Ø D	Ø d1	L1	Ident-No.
30	10	44	003567
[mm]	[mm]	[mm]	

Bottom part	Type	a	Class-No.	Ident-No. [L]	Ident-No. [R]
	D	26.5	933322	003561	003560
	A	19	933322	003565	003564
		[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Multi-Purpose Greases		993520	056746
Special Levers		997100	164309
Reducing Bushings		955530	057513
Set Screws	M6x5 DIN EN ISO 4029	995161	165049
Set Screws	M5x8 DIN EN ISO 4028	995161	180015
Screws	M8x24L	995191	180013
Screws	M8x24R	995191	180012
	[mm]		

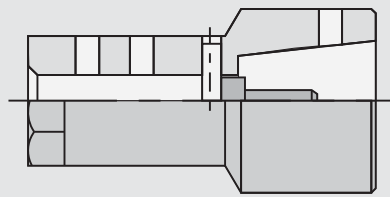
933321

Drill Bit Quick-Changing Systems - top part

Product



Drawing



Machine / Application

l boring machines
l for mounting of drill bits with cylindrical shank with clamping screws

Design

l for clamping of the drill bit with hex socket setscrews

Advantages

l low downtimes thanks to fast drill bit changes

Notes

l for larger hole pitch widths (32 mm)
l top part is drill bit seat
l bottom part to install on the machine spindle
l for threaded shank design and appropriate machines see technical information

	Dimension	Class-No.	Ident-No.
locating bore	Ø10		168669
locating bore	Ø8		168668
	[mm]		
Spare parts	Dimension	Class-No.	Ident-No.
collet chuck	Ø3	933380	168666 o
collet chucks	Ø2,5	933380	168665 o
Engineers Wrenches	9x11 DIN 3118	985720	168672 o
Engineers Wrenches	11x13 DIN 3118	985720	168670 o
Engineers Wrenches	14x17 DIN 3118	985720	168671
	[mm]		
Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M6x5 DIN EN ISO 4029	995161	165049
Set Screws	M5x4 DIN EN ISO 4029	995161	001608
	[mm]		



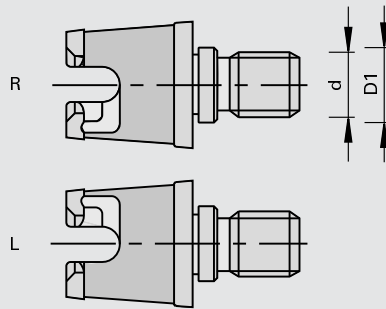
933322

Drill Bit Quick-Changing Systems - bottom part

Product



Drawing



Machine / Application

for boring machines
for installation on the machine spindle

Design

conical design

Advantages

Notes

for threaded shank design and appropriate machines see technical information

Type	Ø d	Ø D1	Ident-No. [L]	Ident-No. [R]
C	M8	9	168662	168663
D	M10	11	170243	170242
	[mm]	[mm]		

Spare parts

	Class-No.	Ident-No.
Dust protection cap	997800	170283
Socket Wrenchs	985730	168673 &

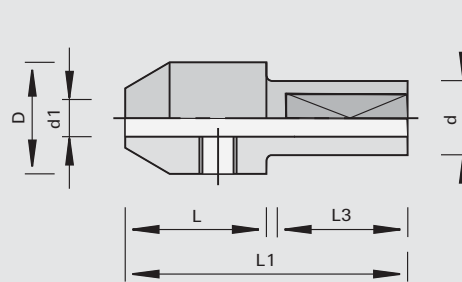
933389

Adapters

Product



Drawing



Machine / Application

for mounting of twist drills in combi chuck and Klack chuck

Design

shank with clamping surface
thread M5, without screw

Advantages

Notes

adjusting and attachment screw Ident-No. 181520 M5x11,5 for Weeke quick clamping chuck must be ordered separately

Ø d1	L	Ø d	L3	Ø D	L1	Ident-No.
2	19	10	21	15	41	183275
2,5	19	10	21	15	41	183276
3	19	10	21	15	41	183277
3,5	19	10	21	15	41	183278
4	19	10	21	15	41	183279
5	19	10	21	15	41	183280
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	

Spare parts	Dimension	Class-No.	Ident-No.
Set Screws	M6x6 DIN EN ISO 4029	995161	180003
Cranked Wrench Keys	SW3 DIN ISO 2936 [mm]	985730	009672

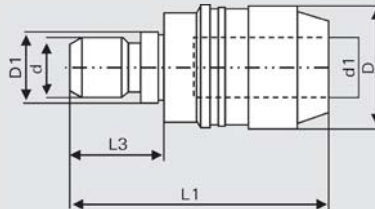
933359

Drill Bit Quick-Changing Systems

Product



Drawing


LEUCO
CNC

Machine / Application

- | boring machines
- | CNC machining centers
- | for mounting of drill bits with cylindrical shank and clamping surface

Design

Advantages

- | low downtimes thanks to fast drill bit changes
- | no special adjusting screw necessary
- | for all common drill bits with shank \varnothing 10 mm and boring \varnothing < 20 mm

Notes

- | for threaded shank design and appropriate machines see Technical Information

\varnothing D	\varnothing D1	\varnothing d	\varnothing d1	L1	L3	Type	Ident-No. [L]	Ident-No. [R]
20	9	M8	10	42	15	C	182396 o	182395 o
20		M8	10	42	15	A	182398 o	182397 o
20		10	10	45	18		182400 o	182399 o
20	11	M10	10	42	15	D	182402 o	182401 o
20		M10	10	42	15	B	182404 o	182403 o
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

Spare parts

Class-No.

Ident-No.

Socket Wrenchs

985730

182405 o

933390

Universal Drill Chucks

Product

Drawing



LEUCO
CNC

Machine / Application

- | CNC machining centers with automatic tool changer
- | for clamping of drill bits with cylindrical shank

Design

- | continuously adjustable clamping area between 1-13 mm
- | n max = 20,000 min-1
- | hardened clamping jaws

Advantages

- | fine balance is easy on spindle and spindle bearing
- | high clamping accuracy over total lifetime of drill chuck thanks to hardened clamping jaws
- | high holding moment
- | no chips and dirt in the clamping zone thanks to special clamping jaws

Notes

- | for clockwise and counter-clockwise rotation
- | included in delivery: clamping key, retaining bolts

Ø D	Ø d	Ø d1	L1		Ident-No.
50	SK 30 (DIN)	1-13	90	Weeke, Maka, Reichenbacher	180375 o
50	SK 30	1-13	90	Biesse from 9/92, Masterwood (HSD motors)	180376 o
50	SK 30	1-13	90	Alberti, Masterwood (Colombo motors)	180377 o
50	SK 30	1-13	90	Morbidelli, SCM (with ring gear)	180378 o
50	SK 40 (DIN)	1-13	90	Maka, Reichenbacher Stegherr	180379 o
57	SK 40 (DIN)	3-16	90	Maka, Reichenbacher Stegherr	180380 o
50	HSK 63F	1-13	112	Homag, EIMA, Weeke, IMA from 9/94	180381
57	HSK 63F	3-16	112	Homag, EIMA, Weeke, IMA from 9/94	180382
[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

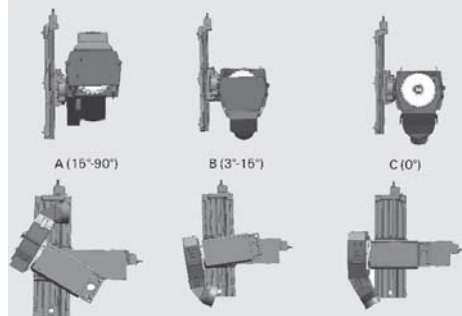
Ident-No.

Cranked Wrench Keys	SW6x100 [mm]	985730	180383 o
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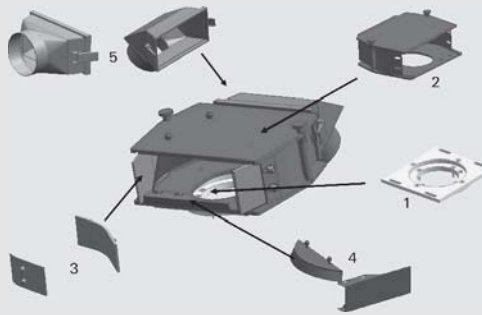
975917

LEUCO Dust Hoods

Product



Drawing



Machine / Application

- | double end tenoners
- | especially for flooring manufacturing

Design

- | LEUCO dust hood system

Advantages

- | optimum chip caption
- | wear parts individually replaceable
- | flow-optimizing design

Notes

complete dust hood - consisting of one part of each of the following 5 groups

Flange	Ø D	B	Motor output	Class-No.	Ident-No.
flange Ø180x13	180	13	Perske up to 11 KW	975117	540301 o
flange Ø180x13	180	13	Perske from 11 KW	975117	540430 o
	[mm]	[mm]			

2 - Basic hood	Tool Ø D	Tilting area	Basic hood form	Class-No.	Ident-No.
basic hood 15° - 90° cpl. tool-Ø 250 mm	250	15 - 90	A	975217	540295 o
basic hood 3° - 15° cpl. tool-Ø 250 mm	250	3 - 15	B	975117	540317 o
basic hood 0° cpl. tool-Ø 250 mm	250	0	C	975117	540389 o
	[mm]	[°]			

3 - Side profile (wear plate and adjusting plate)	Thickness of wear plate	Class-No.	Ident-No.
side profile standard cpl.	8	975417	540302 o
side profile 0° right cpl.	8	975417	540358 o
side profile 0° left cpl.	8	975417	540386 o
	[mm]		

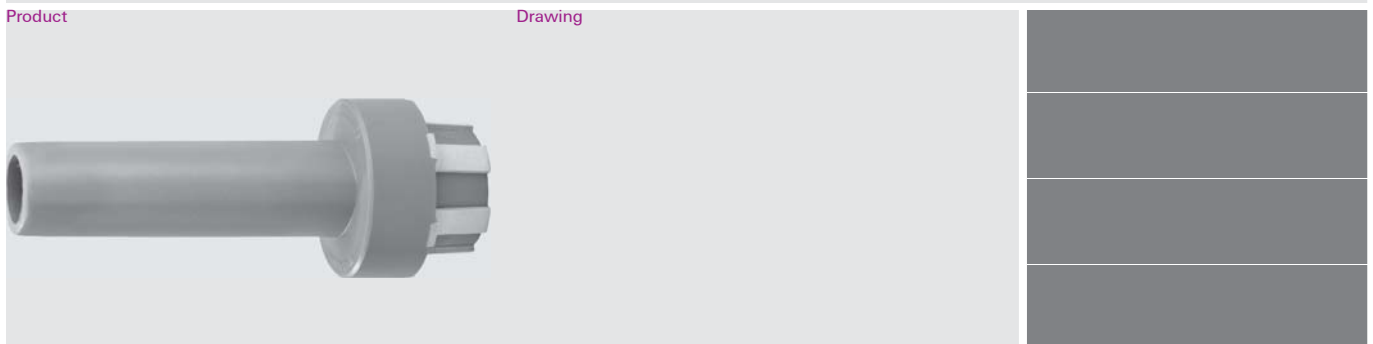
4 - Chip flow set	Height of C plate	Height of chip flow plate	Class-No.	Ident-No.
chip flow set 12/82 cpl.	12	82	975217	540227 o
chip flow set 22/72 cpl.	22	72	975217	540228 o
chip flow set 32/62 cpl.	32	62	975217	540229 o
chip flow set 42/52 cpl.	42	52	975217	540230 o
chip flow set 52/42 cpl.	52	42	975217	540231 o
chip flow set 62/32 cpl.	62	32	975217	540232 o
chip flow set 67/27 cpl.	67	27	975217	540233 o
	[mm]	[mm]		

5 - Extraction connection	Tool Ø D	Ø Connection	Angle	Basic hood form	Class-No.	Ident-No.
connection 0° - Ø 120 mm	250	120	0	A, B	975217	540298 o
connection 0° - Ø 140 mm	250	140	0	A, B	975217	540304 o
connection 30° - Ø 120 mm	250	120	30	A, B	975217	540308 o
connection 30° - Ø 140 mm	250	140	30	A, B	975217	540310 o
connection 0° - Ø 120 mm	250	120	0	C	975217	540362 o
connection 0° - Ø 140 mm	250	140	0	C	975217	540392 o
	[mm]	[mm]	[°]			

Spare parts	Dimension	Basic hood form	Class-No.	Ident-No.
basic plate	D = 250 mm	A, B, C	975217	540291 o
basic hood 15° - 90° cpl. tool- \emptyset 250 mm		A	975217	540292 o
thread bolt		A, B, C	975217	540201 o
wear plate 0° standard cpl.	S = 8 mm	A, B	975517	540210 o
wear plate 0° right cpl.	S = 8 mm	C	975517	540356 o
wear plate 0° left cpl.	S = 8 mm	C	975517	540364 o
C plate 12	H = 12 mm	A, B, C	975217	540213 o
C plate 22	H = 22 mm	A, B, C	975217	540214 o
C plate 32	H = 32 mm	A, B, C	975217	540215 o
C plate 42	H = 42 mm	A, B, C	975217	540216 o
C plate 52	H = 52 mm	A, B, C	975217	540217 o
C plate 62	H = 62 mm	A, B, C	975217	540218 o
C plate 67	H = 67 mm	A, B, C	975217	540219 o
connection 0° - \emptyset 120 mm		A, B	975217	540298 o
connection 0° - \emptyset 140 mm		A, B	975217	540304 o
connection 30° - \emptyset 120 mm		A, B	975217	540308 o
connection 30° - \emptyset 140 mm		A, B	975217	540310 o
connection 0° - \emptyset 120 mm		C	975217	540362 o
connection 0° - \emptyset 140 mm		C	975217	540392 o
	[mm]			

985700

Cone wiper

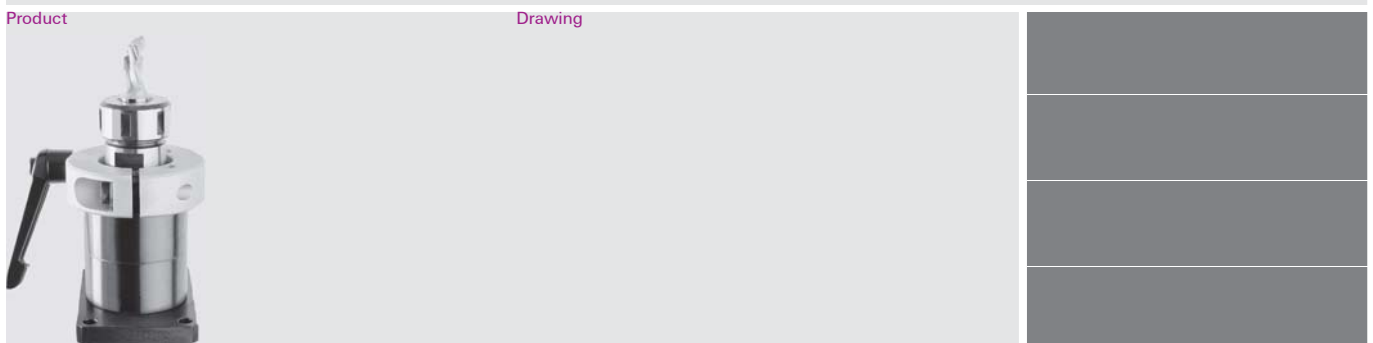


Machine / Application	Design	Advantages	Notes
for cleaning of the inner cones of the cone tool adaptors			the highly precise machine spindle and clamping chuck needs dust and chip-free fit

Ø d	Ident-No.
SK 30	180907 o
SK 40	180908 o
HSK 25	180909
HSK 32	180910
HSK 63	180911 o
[mm]	

985202

Mounting device with clamping lever




Machine / Application	Design	Advantages	Notes
for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders	with two-part clamping jaws made from high-quality light alloy mounted on stable pedestal which can be fixed onto workbench quick-grip lever for clamping of clamping chucks or holding arbors	variably applicable for all interfaces by simple exchanging of the clamping jaw	

Ø d	Ident-No.
SK 30 (DIN) / HSK 50F	50 180362 o
SK 40 (DIN)	63,5 180363 o
SK 30 with ring gear (Morbidelli, SCM)	49 180364 o
SK 30 (ISO) CMS / BT 30	46 180365 o
HSK 63F / 63E	63 180366 o
BT 35	53 180367 o
HSK 85 (Weinig)	85 182284 o
[mm]	

Spare parts	For Ident-No.	Class-No.	Ident-No.
Clamping Jaws (2-parts)	180362	997300	180368 o
Clamping Jaws (2-parts)	180363	997300	180369 o
Clamping Jaws (2-parts)	180364	997300	180370 o
Clamping Jaws (2-parts)	180365	997300	180371 o
Clamping Jaws (2-parts)	180366	997300	180372 o
Clamping Jaws (2-parts)	180367	997300	180373 o
Clamping Jaws (2-parts)	182284	997300	182285 o
Pedestal (without clamping jaw)		997300	180374 o

985202


Mounting device without clamping lever

Product	Drawing		
			
Machine / Application for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders	Design mounted on stable pedestal which can be fixed onto workbench	Advantages simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary	Notes for all adapters HSK 63 F

Ø d1	Ident-No.
HSK 63F [mm]	182467

985202

Mounting device without clamping lever, high-end design

Product	Drawing		
			
Machine / Application for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders	Design high-end version with integrated plastic inserts to protect the tool holder mounted on stable pedestal which can be fixed onto workbench	Advantages simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary	Notes for all adapters HSK 63 F

Ø d1	Ident-No.
HSK 63F [mm]	182166 o

985201

inductive shrinking device ISG2202

Product



Drawing

Machine / Application

for shrinking of HW shanks Ø 3 - 20 mm and HS shanks Ø 6 - 20 mm

Design

device with inductor, centering discs for tool adapters and 3 replacement discs
 color: grey-white RAL 9002
 performance: 8 kW
 version without ventilator

Advantages

inductor can be lowered to the heating position by simple manual operation and can be locked by pushing a button
 choose the shrinking diameter on the control panel and press the start button
 the stored time elapses, at the end the inductor moves automatically upward
 the process can be ended ahead of time by pressing the stop button

Notes

in combination with the cooling station FKS04 shrinking, cooling and cleaning can be done within seconds please order separately

	Dimension	Weight	Ident-No.
inductive shrinking device ISG2202 (without ventilator)	640x310x390 [mm]	25 [kg]	184036 o
Accessories	Weight	Class-No.	Ident-No.
liquid cooling device FKS 04 (manual)	22.5	985201	184037o
tool adapter HSK40/50/63F for FKS04		985201	184039o
tool adapter SK30/40/BT30/40 for FKS04		985201	184038o
	[kg]		



985201

inductive shrinking device ISG3400TLK

Product

Drawing



Machine / Application

- | for shrinking of HW shanks Ø 3 - 32 mm and HS steel shanks Ø 6 - 32 mm
- | with the inductive shrink unit ISG3400 TLK all tools from Ø 3-32 can be shrunk by simple change of discs; the energy coupling is thereby optimally adapted to the respective chuck; with special coils, the system can also shrink larger diameters tools up to 50 mm

Design

- | device with inductor with 4 replacement discs
- | performance: 11 kW
- | design with ventilator

Advantages

- | operation of the ISG3400TLK by menu
- | all parameter are shown at the same time
- | several languages can be chosen
- | data for clamping chucks with special geometries can be saved

Notes

- | in combination with the cooling station FKS04 shrinking, cooling and cleaning can be done within seconds please order separately

	Dimension	Ident-No.	
inductive shrinking device ISG3400TLK (without ventilator)	780x535x950 [mm]	184035 o	
Accessories	Weight	Class-No.	Ident-No.
liquid cooling device FKS 04 (manual)	22.5	985201	184037o
tool adapter HSK40/50/63F for FKS04		985201	184039o
tool adapter SK30/40/BT30/40 for FKS04		985201	184038o
	[kg]		

985300

digital height measuring device

Product

Drawing



LEUCO
CNC

Machine / Application

- | for quick and precise adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders

Design

- | repeating precision 0.01 mm
- | tungsten carbide-tipped scriber
- | digital display

Advantages


- | simple adjustment and fixing of the height dimension

Notes

	Ident-No.
digital height measuring device	183684 o

999300

iBlade StarterKit

<p>Product</p> 	<p>Drawing</p>	
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<p>Machine / Application</p> <p> for simple monitoring and tracking of tool performance</p>	<p>Design</p>	<p>Advantages</p> <p> perfect cost control</p>	<p>Notes</p> <p> the insertion of the chip depends on the tool used</p> <p> in the case of very small/thin tools the memory chip can be attached to a tool card</p>
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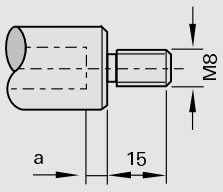
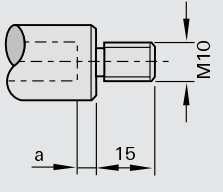
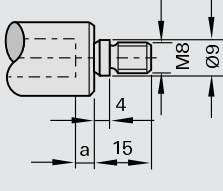
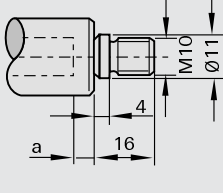
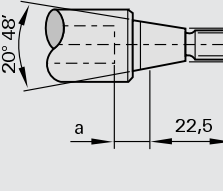
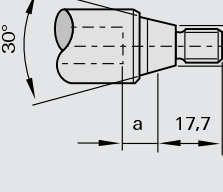
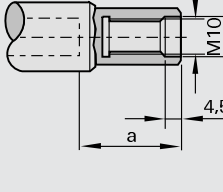
			Ident-No.
iBlade StarterKit	software documentation Basic, memory chip V2 (5 pieces), reader Classic USB, activator spray, glue		184784 s

		Class-No.	Ident-No.
Software documentation Basic	annual licence	999300	184776s
Software documentation user	annual licence	999300	184777s
software documentation dealer/service	annual licence	999300	184778s
reader Classic USB		994721	184779s
reader bluetooth		994721	184780s
memory chip V2	8.5x2.0 mm	994711	184781
glue	20g	993390	184782s
activator spray	200 ml can	993390	184783s



Connection dimensions for Boring Bit Collet Chucks

Threaded shank design for Kombi and Klack systems with appropriate machines

Type	Machine assignment
<p>A</p> 	<p>Nottmeyer Lehbrink Pankoke + Kochsiek Priß + Horstmann</p>
<p>B</p> 	<p>Ayen Holzma Knoevenagel Mayer Brandt Reichenbacher Torwegge Zubiola</p>
<p>C</p> 	<p>Nottmeyer</p>
<p>D</p> 	<p>Böttchner + Gessner Biese Busellato Dingenotto Hüllhorst Holz-Her Homag Koch</p> <p>Morbidelli Reimall Torwegge Weeke Reich</p>
<p>E</p> 	<p>Bilek Type KÜN Knoevenagel</p>
<p>F</p> 	<p>Alberti Balestrini Bilek (05 R) Busellato Dubus Goma Grotefeld Omeg</p> <p>Reimall Schleicher SCM Tanzani Viciani Vitap Weingärtner</p>
<p>G</p> 	<p>Scheer</p>



Spare Parts

Product	Page
Screws / Set Screws	8-1
Nuts	8-10
Spacer Rings	8-12
Reducing Bushings / Reducing Rings	8-16
Ball Bearings	8-20
Accessory Tools	8-22

Torque for Screws

Hexagon Socket Set Screws (DIN 913...916)

Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 45H
M3	1.5	0.82
M4	2.0	1.90
M5	2.5	3.50
M6	3.0	5.50
M8	4.0	9.50
M10	5.0	20.0
M12	6.0	30.0

Hexagon Socket Set Screws (DIN 912)

Thread	Width across flats [mm]	Tightening moment MA (nm) for property class 8.8
M3	2.5	1.1
M4	3.0	2.5
M5	4.0	5.0
M6	5.0	10.0
M8	6.0	15.0
M10	8.0	15.0

Screws with Torx

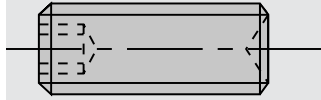
Thread	Torx-Size	Torque MA [Nm] for property class
M2.5	T8	1.31
M3	T9	2.30
M3.5	T15	2.95
M4	T15	5.20
M4x0.5	T9	2.00
M4.5	T15	5.20
M5	T20	8.60
M6	T25	15.00
M5	T15	8.00

995161

Set Screws - with hexagon socket and cup point

Drawing

Notes



I with hexagon socket and cup point

Dimension

Ident-No.

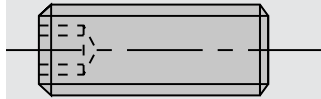
M5x4 DIN EN ISO 4029	001608
M5x5 DIN EN ISO 4029	001609
M6x4 DIN EN ISO 4029	167068
M6x6 DIN EN ISO 4029	180003
M6x5 DIN EN ISO 4029	165049
[mm]	

995161

Set Screws - with hexagon socket and flat point

Drawing

Notes



I with hexagon socket with flat point

Dimension

Ident-No.

M5x10 DIN EN ISO 4026	180028
M6x6 DIN EN ISO 4026	163546
M6x8 DIN EN ISO 4026	180036
M8x10 DIN EN ISO 4026	059549
[mm]	

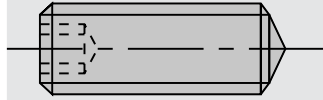


995161

Set Screws - with hexagon socket and cone point

Drawing

Notes



I with hexagon socket with cone point

Dimension

Ident-No.

M5x10 DIN EN ISO 4027
[mm]

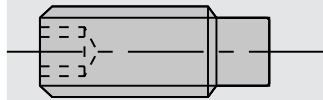
001686

995161

Set Screws - with hexagon socket and dog point

Drawing

Notes



I with hexagon socket with dog point

Dimension

Ident-No.

M5x8 DIN EN ISO 4028	180015
M5x12 DIN EN ISO 4028	050565
M6x6 DIN EN ISO 4028	163841
M6x10 DIN EN ISO 4028	180002
M6x12 DIN EN ISO 4028	180214
M6x16 DIN EN ISO 4028	001617
M6x25 DIN EN ISO 4028	167979
M8x10 DIN EN ISO 4028	001622
M8x12 DIN EN ISO 4028	180001
M8x14 DIN EN ISO 4028	168453
M8x16 DIN EN ISO 4028	164422
M8x20 DIN EN ISO 4028	001625
M8x35 DIN EN ISO 4028	165937
M10x12 DIN EN ISO 4028	001630
M10x16 DIN EN ISO 4028	168192
M10x20 DIN EN ISO 4028	815807
M10x25 DIN EN ISO 4028	168108
M12x25 DIN EN ISO 4028	181466
[mm]	

995161

Set Screws - with hexagon socket and ball pressure screw

Notes

| with hexagon socket and ball pressure screw

Dimension

Ident-No.

M8x20

168874 o

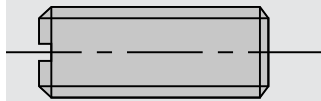
[mm]

995162

Set Screws - with flat point

Drawing

Notes



| slotted with flat point

Dimension

Ident-No.

M5x10 DIN EN 24766

001600

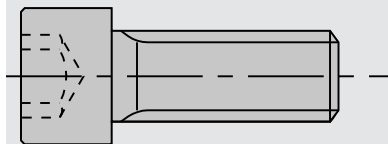
[mm]

995111

Head Cap Screws - with hexagon socket

Drawing

Notes



| with hexagon socket

Dimension

Ident-No.

M5x40 DIN EN ISO 4762

001875

M6x16 DIN EN ISO 4762

001879

M6x40 DIN EN ISO 4762

001884

M8x10 DIN EN ISO 4762

001890 o

M10x50 DIN EN ISO 4762

001909

M12x30 DIN EN ISO 4762

001917

M12x50 DIN EN ISO 4762

001921

M16x40 DIN EN ISO 4762

001933

M16x50 DIN EN ISO 4762

166442

M16x50L DIN EN ISO 4762

166431

M16x70 DIN EN ISO 4762

059169

M16x120 DIN EN ISO 4762

001938

M20x50 DIN EN ISO 4762

166441

M20x50L DIN EN ISO 4762

166440

M20x80 DIN EN ISO 4762

056178

[mm]

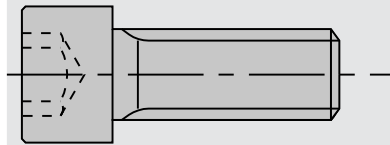
Dimension	Ident-No.
M20x120 DIN EN ISO 4762 [mm]	056153

995111

Head Cap Screws - with hexagon socket with low head

Drawing

Notes



I with hexagon socket with low head

Dimension

Ident-No.

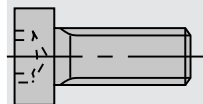
M5x16	165961
M8x16	180004
M8x30	180005
M8x50	180006
[mm]	

995115

Head Cap Screws - with Torx

Drawing

Notes



I with Torx

Dimension

Ø D

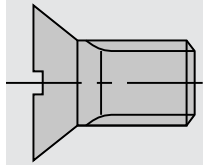
Ident-No.

M2,5x3 T8	3,45	168237
M2,5x4 T8	3,45	168238
M3x5,5 T8	4,35	168239
M3x10 T8	4,4	168782
M3,5x3,8 T15	7,0	162645
M3,5x5,5 T15	6,0	168236
M3,5x6,5 T15	6,2	163223
M3,5x6,5 T15	7,0	162644
M3,5x8 T15	6,25	163222
M5x12 T20	8,5	171237
[mm]	[mm]	

995 122

Countersunk Screws - slotted

Drawing



Notes

| slotted

Dimension

Ident-No.

M5x10 DIN EN ISO 2009

055881

M5x12

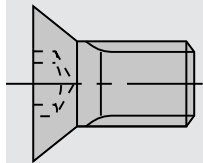
180007

[mm]

995 125

Countersunk Screws - with Torx

Drawing



Notes

| with Torx

Dimension

Ident-No.

M2,5x5,5 T8

167486

M3x7,3 T8

166502

M3,5x5,5 T15

162649

M3,5x6 T15

162648

M4x0,5x3,2 T9

163925

M4x0,5x4,2 T9

165908

M4x0,5x5,3 T9

170202

M5x6 T20

176199

M5x6,8 T15

180839

M5x8 T20

164005

M5x9 T20 D=Ø9,3

827277

M5x10 T20

for attaching the saw blade without flange

171236

M5x10,8 T15

180840

M5x12 T20

166709

M5x13,5 T20

with collar 6,3 mm

171238

M5x16 T20

for attaching the flange

164839

M6x10 T20

181244

[mm]

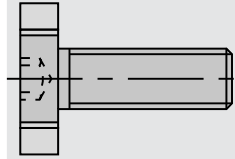


995 190

Cutter Retaining Bolts

Drawing

Notes



I with hexagon socket

Dimension

Ident-No.

M16x26xØ42

173592

M12x22xØ35

173591

Ø20xM8x23

171393

Ø28xM10x26

171392

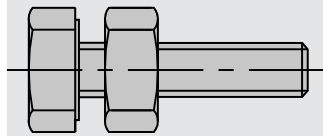
[mm]

995 190

Stop Screws

Drawing

Notes



I for shank-type tools

Dimension

Ident-No.

M8x25

stop screw

172828

M6x16

for shank Ø 16

172797

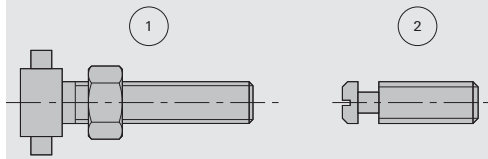
[mm]

995 190

Special Screws

Drawing

Notes



| for ps-System and PS 2000-E

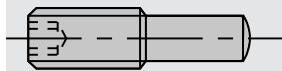
	Dimension		Ident-No.	
1	M6x20	for ps-System 16 mm	Ident-No. 168674	172115
1	M8x25	for ps-System 25 mm	Ident-No. 167738	172113
2	M8x19	for PS-2000 E	Ident-No. 173352	172921
	[mm]			

995 191

Special Set Screws

Drawing

Notes

| for SuperProfiler "MAN"
| with hexagon socket

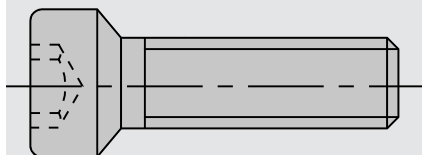
	Dimension	Ident-No.
	M8x24	167269
	[mm]	

995 191

Screws

Drawing

Notes



| for „Klack“ bottom part

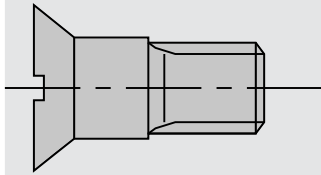
	Dimension	Ident-No.
	M8x24L	180013
	M8x24R	180012
	[mm]	

995 192

Countersunk Screws - with collar

Drawing

Notes



I with collar

Dimension

Ident-No.

M5x12

180009

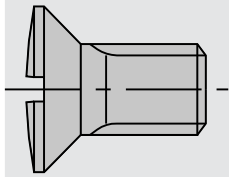
[mm]

995 192

Countersunk Screws - for hogger segments

Hoggers

Notes



I for hogger segments

Dimension

Ident-No.

M8x12,5

180010

M8x17

180011

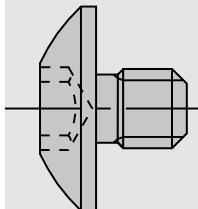
[mm]

995 195

Round Head Screws

Drawing

Notes



I with Torx

Dimension

Ident-No.

M3,5x4 T15

head Ø 9

168893

M3,5x12 T15

head Ø 9

171067

M4x5,9 T15

head Ø 9

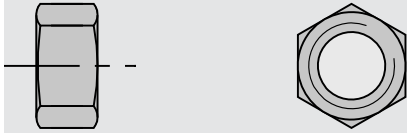
167966

[mm]

995210

Hexagon Nuts

Drawing



Dimension

Ident-No.

M4 DIN EN ISO 4032

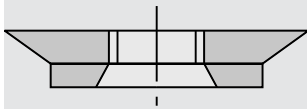
009631

M6 DIN EN ISO 4032

009633

[mm]

995290

Special Nuts

| for grooving cutterhead turnover knives

Dimension

Ident-No.

M4x0,5x1,6

163704

M4x0,5x2,2

163703

M4x0,5x2,75

165907

M4x0,5x4,1

170203

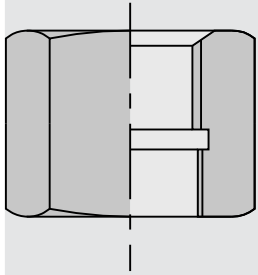
[mm]



995290

Union Nuts

Drawing



Notes

I for MK-shanks

Dimension

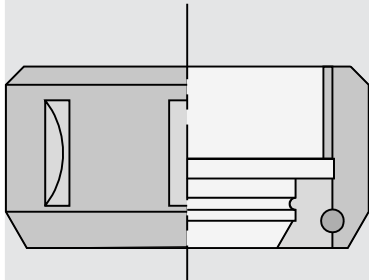
Ident-No.

M33x3/M30x1,5	double-edged	170275 o
W 1 1/8"/W20x14	hexagonal	167911 o
W 1 1/8"/M30x1,5/L	hexagonal	167780
W 1 1/8"/M30x1,5	hexagonal	165561
[mm]		

995290

Lock Nuts

Drawing



Notes

I for draw-in collet chucks

Dimension

Ident-No.

M30x1,5R	with ball-bearing	178763
M40x1,5R	with slide bearing	178761
M48x2R	with slide bearing	178764
M50x1,5R	with slide bearing	178762 o
[mm]		

955520

Spacers

Ø D	B	Ø d	DKN	NL	Ident-No.
14	0,1	6			176422 o
14	0,2	6			176423 o
14	0,5	6			176424 o
14	1,0	6			176425 o
14	2,0	6			176426 o
14	5,0	6			176427 o
40	0,1	20			000218
40	0,2	20			000219
40	0,5	20			000220
40	1,0	20			000221
40	2,0	20			000222
40	3,0	20			000223
40	0,1	25			183756
40	0,2	25			183757
40	0,5	25			183758
40	1,0	25			183759
40	2,0	25			183760
40	4,0	25			183761
40	6,0	25			183762
40	10	25			183763
40	20	25			183764
80	0,05	22		2/4/42	017424
80	0,1	22		2/4/42	017425
80	0,2	22		2/4/42	017426
45	0,1	25			000230
45	0,2	25			000231
45	0,5	25			000232
45	1,0	25			000233
45	2,0	25			000234
45	3,0	25			000235
50	0,1	30			000242
50	0,2	30			000243
50	0,5	30			000244
50	1,0	30			000245
50	2,0	30			000246
50	3,0	30			000247
66	0,1	30			000266
66	0,1	30	8x3,3		176700
66	0,2	30			000267
66	0,2	30	8x3,3		176701
66	0,5	30			000268
66	0,5	30	8x3,3		176702
66	1,0	30			000269
66	1,0	30	8x3,3		176703
66	2,0	30			000270
66	2,0	30	8x3,3		176704
66	3,0	30			000271
66	3,0	30	8x3,3		176705
66	4,0	30			161999
66	4,0	30	8x3,3		176706
66	10	30			162002
66	10	30	8x3,3		176707
90	0,1	30			000308
90	0,2	30			000309
90	0,5	30			000310
90	1,0	30			000311
90	2,0	30			000312
90	3,0	30			000313
100	0,1	30			000320
[mm]	[mm]	[mm]	[mm]		



Ø D	B	Ø d	DKN	NL	Ident-No.
100	0,2	30			000321
100	0,5	30			000322
100	1,0	30			000323
100	2,0	30			000324
100	3,0	30			000325
175	0,1	30			000458
175	0,2	30			000459
175	0,5	30			000460
175	1,0	30			000461
70	0,1	35			000296
70	0,1	35	10x3,3		176436
70	0,2	35			000297
70	0,2	35	10x3,3		176437
70	0,5	35			000298
70	0,5	35	10x3,3		176438
70	1,0	35			000299
70	1,0	35	10x3,3		176439
70	2,0	35			000300
70	2,0	35	10x3,3		176440
70	3,0	35			000301
70	3,0	35	10x3,3		176441
70	4,0	35			162000
70	4,0	35	10x3,3		176442
70	10	35			162003
70	10	35	10x3,3		176443
100	0,1	35			000326
100	0,2	35			000327
100	0,5	35			000328
100	1,0	35			000329
100	2,0	35			000330
100	3,0	35			000331
70	0,1	40			000302
70	0,1	40	12x3,3		176444
70	0,2	40			000303
70	0,2	40	12x3,3		176445
70	0,5	40			000304
70	0,5	40	12x3,3		176446
70	1,0	40			000305
70	1,0	40	12x3,3		176447
70	2,0	40			000306
70	2,0	40	12x3,3		176448
70	3,0	40			000307
70	3,0	40	12x3,3		176449
70	4,0	40			162001
70	4,0	40	12x3,3		176450
70	10	40			162004
70	10	40	12x3,3		176451
120	0,1	40			000344
120	0,2	40			000345
120	0,5	40			000346
120	1,0	40			000347
120	2,0	40			000348
90	0,1	50			000314
90	0,2	50			000315
90	0,5	50			000316
90	1,0	50			000317
90	2,0	50			000318
90	3,0	50			000319
100	0,05	50		4/9/80	177019
100	0,1	50		4/9/80	176835
100	0,2	50		4/9/80	176836
100	0,5	50		4/9/80	176837
100	1,0	50		4/9/80	176838
100	2,0	50		4/9/80	176839
[mm]	[mm]	[mm]	[mm]		

Ø D	B	Ø d	DKN	NL	Ident-No.
100	3,0	50		4/9/80	176840
90	0,05	60		3/9/74	177022
90	0,1	60		3/9/74	177023
90	0,2	60		3/9/74	177024
90	0,5	60		3/9/74	177025
90	1,0	60		3/9/74	177026
90	2,0	60		3/9/74	177027
100	0,1	60			000332
100	0,2	60			000333
100	0,5	60			000334
100	1,0	60			000335
100	2,0	60			000336
100	3,0	60			000337
120	0,1	60		4/9/100	176830
120	0,15	60		4/9/100	177018
120	0,2	60		4/9/100	176831
120	0,5	60		4/9/100	176832
120	1,0	60		4/9/100	176495
120	2,0	60		4/9/100	176833
120	3,0	60		4/9/100	176834
160	0,1	60			000452
160	0,2	60			000453
160	0,5	60			000454
160	1,0	60			000455
160	2,0	60			000456
160	3,0	60			000457
115	1,0	80		4/10/100	009255
120	0,1	80		4/9/100+2/6,5/90	177380
120	0,2	80		4/9/100+2/6,5/90	177381
120	0,5	80		4/9/100+2/6,5/90	177382
120	1,0	80		4/9/100+2/6,5/90	177383
120	2,0	80		4/9/100+2/6,5/90	177384
120	3,0	80		4/9/100+2/6,5/90	177385
130	0,5	80			000450
145	0,1	80		4/12/100+4/9/120	552104
145	0,2	80		4/12/100+4/9/120	552105
145	0,5	80		4/12/100+4/9/120	552106
145	1,0	80		4/12/100+4/9/120	552107
[mm]	[mm]	[mm]	[mm]		

955521

Spacer Sets - 9 parts

Notes

! 9 piece set consists of: 1 piece 0.1 mm, 2 pieces 0.2 mm, 1 piece 0.5 mm, 3 pieces 1.0 mm, 1 piece 4.0 mm, 1 piece 10 mm

Ø D	B	Ø d	Ident-No.
66	18	30	161797
70	18	35	161798
70	18	40	161799
[mm]	[mm]	[mm]	

955521

Spacer Sets - 8 parts for milling spindles

Notes

| for milling spindles

| 8 piece set consists of: 2 pieces 5 mm, 1 piece 8 mm, 1 piece 10 mm, 2 pieces 16 mm, 1 piece 25 mm, 1 piece 40 mm

Ø D	B	Ø d	Ident-No.
50	125	30	160233 o
60	125	40	160234 o
[mm]	[mm]	[mm]	

995520

Spacers for S-System - Homag

Notes

| for S-System - Homag

Ø D	B	Ø d	DKN	Ident-No.
60	11	35	10x3,3	180647
[mm]	[mm]	[mm]	[mm]	

955530

Reducing Ring

Notes

| for reduction of the saw blade bore

| rotation of the clamping flanges must be observed to ensure secure clamping of the tool

Ø D	B	Ø d	Ø d	Ident-No.
20	1,6	12,7	1/2	161946
20	1,6	16		161945
22	2,0	20		161887
22	4,0	20		161830
25	2,2	20		000104
30	1,4	15		000107
30	1,4	16		000111
30	1,4	20		000117
30	1,4	25		000125
30	1,8	15,1	19/32	161949
30	1,9	16		000112
30	1,9	20		000118
30	2,0	20		016848
30	2,0	25		000127
30	2,2	15,88	5/8	000110
30	2,2	16		000113
30	2,2	18		000114
30	2,2	20		000119
30	2,2	22		000120
30	2,2	25		000128
30	2,2	25,4	1	000130
30	2,2	28		000132
30	3,0	25		000129
32	2,0	16		161886
32	2,2	16		000134
32	2,2	20		000135
32	2,2	22		010571
32	2,2	30		000137
35	1,0	30		000145
35	1,4	30		000146
35	1,9	30		000147
35	2,2	20		000138
35	2,2	24		000139
35	2,2	25		000142
35	2,2	28		000144 s
35	2,2	30		000148
35	2,2	32		000150 s
40	2,0	32		161962
40	2,2	20		000151
40	2,2	30		000153
40	2,2	35		000154
45	2,5	30		161831
50	2,2	30		000156
55	2,2	30		000159
60	2,2	30		000161
60	2,2	35		000162
60	2,2	40		000163
60	2,2	50		000164
60	2,8	30		010577
70	2,2	30		000166
80	2,2	30		000171
80	2,2	35		000172
80	2,2	50		000175
80	2,2	60		000177
80	2,2	70		000179
[mm]	[mm]	[mm]	[inch]	



Ø D	B	Ø d	Ø d	Ident-No.
80	2,8	60		000178
[mm]	[mm]	[mm]	[inch]	

956506

Reducing Bushing

Notes

- | cylindrical
- | bore tolerance H7

Ø D	B	Ø d	Ø d	Ident-No.
30	5,1 - 10	20		000411 s
30	5,1 - 10	25		000415 &
30	10,1 - 25	20		000441 o
30	10,1 - 25	25		000445 &
30	15,1 - 20		1	000726 &
30	15,1 - 20	20		000721 o
30	15,1 - 20	25		000725 &
30	20,1 - 25		1	000756 o
30	20,1 - 25	25		000755 &
30	25,1 - 30	20		000781 o
30	25,1 - 30	25		000785 &
30	30,1 - 40		1	000816 &
30	30,1 - 40	20		000811 &
30	30,1 - 40	25		000815 &
30	40,1 - 50		1	000846 &
30	40,1 - 50	25		000845 o
30	50,1 - 60	25		000875 &
30	60,1 - 80		1	000365
30	60,1 - 80	20		000360
30	60,1 - 80	25		000364
35	5,1 - 10	20		000420 &
35	5,1 - 10	30		000424 &
35	10,1 - 25	30		000704 &
35	15,1 - 20		1 1/4	000735 &
35	15,1 - 20	30		000734 &
35	20,1 - 25		1 1/4	000765 &
35	20,1 - 25	30		000764 &
35	25,1 - 30		1 1/4	000795 o
35	25,1 - 30	30		000794 &
35	30,1 - 40		1 1/4	000825 &
35	30,1 - 40	30		000824
35	40,1 - 50	30		000854 &
35	50,1 - 60		1 1/4	000885 &
35	50,1 - 60	30		000884 &
35	60,1 - 80		1 1/4	000374
35	60,1 - 80	20		000369
35	60,1 - 80	30		000373
40	5,1 - 10	20		000428 &
40	5,1 - 10	25		000429 &
40	5,1 - 10	30		000430 &
40	5,1 - 10	35		000891 &
40	10,1 - 25	20		000708 &
40	10,1 - 25	30		000710 &
40	10,1 - 25	35		000912 &
40	15,1 - 20	30		000740 &
40	15,1 - 20	35		000933 &
30	25,1 - 30		1	000786 &
40	20,1 - 25	25		000769 &
40	20,1 - 25	30		000770 &
40	25,1 - 30	30		000800 &
40	25,1 - 30	35		000975 o
[mm]	[mm]	[mm]	[inch]	

Ø D	B	Ø d	Ø d	Ident-No.
40	30,1 - 40	20		000828 &
40	30,1 - 40	25		000829 &
40	30,1 - 40	30		000830 &
40	30,1 - 40	35		000996 &
40	40,1 - 50	30		000860 &
40	40,1 - 50	35		001017 &
40	50,1 - 60	30		000890 &
40	50,1 - 60	35		001038 &
40	60,1 - 80	20		000377
40	60,1 - 80	25		000378
40	60,1 - 80	30		000379
40	60,1 - 80	35		000380
60	5,1 - 10	30		000899 &
60	5,1 - 10	35		000900 &
60	5,1 - 10	40		000901 &
60	10,1 - 25	30		000920 &
60	10,1 - 25	35		000921 &
60	10,1 - 25	40		000922 &
60	15,1 - 20	30		000941 &
60	15,1 - 20	35		000942 &
60	15,1 - 20	40		000943 &
60	20,1 - 25	30		000962 &
60	20,1 - 25	35		000963 &
60	25,1 - 30	30		000983 &
60	25,1 - 30	35		000984 &
60	25,1 - 30	40		000985 &
60	30,1 - 40	30		001004 &
60	30,1 - 40	35		001005 &
60	30,1 - 40	40		001006 &
60	40,1 - 50	30		001025 &
60	40,1 - 50	35		001026 &
60	40,1 - 50	40		001027 &
60	50,1 - 60	35		001047 &
60	50,1 - 60	40		001048 &
60	60,1 - 80	30		000388
60	60,1 - 80	35		000389
60	60,1 - 80	40		000390
80	5,1 - 10	30		000905 &
80	10,1 - 25	40		000928 &
80	15,1 - 20	30		000947 &
80	15,1 - 20	35		000948 &
80	15,1 - 20	40		000949 &
80	20,1 - 25	35		000969 &
80	20,1 - 25	40		000970 &
80	25,1 - 30	30		000989 &
80	25,1 - 30	35		000990 &
80	30,1 - 40	35		001011 &
80	30,1 - 40	40		001012 &
80	40,1 - 50	30		001031 &
80	40,1 - 50	35		001032 &
80	40,1 - 50	40		001033 &
80	50,1 - 60	35		001053 &
80	60,1 - 80	30		000394
80	60,1 - 80	35		000395
80	60,1 - 80	40		000396
80	10,1 - 25	30		000926 &
80	10,1 - 25	35		000927 &
80	5,1 - 10	35		000906 &
80	5,1 - 10	40		000907 &
[mm]	[mm]	[mm]	[inch]	

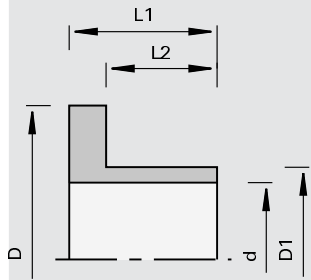


956506

Reducing Bushings with collar

Drawing

Notes



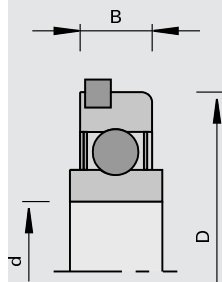
I with collar

$\varnothing D$	$\varnothing D1$	$\varnothing d$	L1	L2	Ident-No.
60 [mm]	40 [mm]	30 [mm]	24 [mm]	18 [mm]	168063 s

997500

Ball Bearing Bushings

Drawing



Notes

- | for use with ball bearing rub collar
- | bearing cage sealed against dust
- | stop collar for ball bearing ring

Ø D	B	Ø d	Ident-No.
62	16	30	003578
72	20	40	160203 o
[mm]	[mm]	[mm]	

997500

Ball Bearings

Notes

Notes

- | for shank-type tools

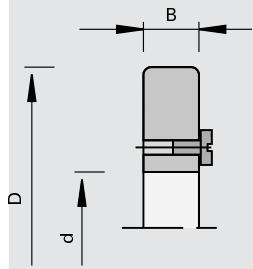
	Dimension	Ident-No.
ball-bearing thrust ring assy.	Ø12	167923
ball-bearing thrust ring assy.	Ø14	169314
Ball Bearings	12,7x5x4,76	164920
Ball Bearings	13x5x6	170265 o
Ball Bearings	15,9x5x6,35	164921
Ball Bearings	19x6x6	164922
Ball Bearings	22x7,5x8	180838
ball-bearings with thrust ring	19x7,5x6,35	164229
ball-bearings with thrust ring	21x7,5x6,35	170774 o
ball-bearings with thrust ring	22x7,5x6,35	164228
	[mm]	



955550

Rub Collars

Drawing



Notes

- | for use on ball bearing bushing
- | intermediate dimensions available upon request
- | screw for axial locking: cap screw M4x10 DIN 84 Ident-No. 001730

Ø D	B	Ø d	Ident-No.
75	10	62	160205
80	10	62	160206
85	10	62	160207
90	10	62	160208
95	10	62	160209 o
100	10	62	160210
105	10	62	160211
110	10	62	160212
115	10	62	160213 o
120	10	62	160214
125	10	62	056840
130	10	62	160215 o
135	10	62	160216 o
140	10	62	160217 o
145	10	62	160218 o
150	10	62	160219
[mm]	[mm]	[mm]	

985720

Engineers Wrenches

Dimension	Ident-No.
9x11 DIN 3118	168672 o
11x13 DIN 3118	168670 o
14x17 DIN 3118	168671
SW10/13 DIN 895	171060 o
[mm]	

985720

Single-Head Engineers Wrenches

Dimension	Ident-No.
SW36 DIN 894	169296 o
SW41 DIN 894	169297
SW46x10 DIN 894	178760
[mm]	

985720

Hook Wrenches**Notes**

I for draw-in collet chucks

Dimension	Ident-No.
SW40/42 DIN 1810	169298
SW45/50 DIN 1810	175851
SW58/62 DIN 1810	169299
[mm]	

985730

Cranked Wrench Keys for hexagon socket screws**Notes**

I for hexagon socket screws

Dimension	Ident-No.
SW2 DIN ISO 2936	009670
SW2,5 DIN ISO 2936	009671
SW3 DIN ISO 2936	009672
SW4 DIN ISO 2936	009673
SW5 DIN ISO 2936	009674
SW6 DIN ISO 2936	009675
SW8 DIN ISO 2936	009677
[mm]	



985730

Screwdrivers with sliding handle for hexagon socket

Notes

- | for hexagon socket screws
- | with sliding handle

Dimension	Ident-No.
SW2,5x100	168010
SW3x100	166090
SW4x100	166091
SW5x150	168703
SW6x200	167817
[mm]	

985730

Screwdrivers with sliding handle for Torx

Notes

- | for screws with Torx
- | with sliding handle

Dimension	Ident-No.
T20x100	166092
T25x100	50933169
T40x130	831404 o
[mm]	

985730

Screwdrivers with flag for Torx

Notes

- | for screws with Torx
- | with flag

Dimension	Ident-No.
T7	167904
T8	166499
T9	164344
T15	163161
[mm]	

985730

Cranked Wrench Keys for Torx

Notes

Notes

- | for screws with Torx

Dimension	Ident-No.
T15	for adjustment unit Altendorf 181147
T30x100	50933102
[mm]	

985730

Screwdrivers with spinner handle for Torx

Notes

- | for screws with Torx
- | with spinner handle

Dimension	Ident-No.
T9x60	173796
T15x80	171188
T15x140	179145
[mm]	

985730

Screwdrivers with spinner handle

Notes

Notes

- | with spinner handle

Dimension	Ident-No.
8	053874
[mm]	

985730

Screwdrivers with wooden handle

Notes

Notes

- | with wooden handle

Dimension	Ident-No.
9,0	011088
[mm]	

985200

Adjusting Gauges

Dimension	Ident-No.
0,3	055883
0,5	50570583
0,7	056096
0,8	50570581
1,0	011103
1,8	50570582
[mm]	

997800

Magnetic Stops

Dimension	Ident-No.
0,0	016613
0,5	166093
1,0	166094
[mm]	

two-piece for glue-joint cutterhead

1 Ordering details

1.1 Catalogue Tools

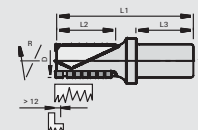
By indicating the Ident-No. the tool is described unequivocally.

The additional indication of Class-No., dimensions, sense of rotation and cutting material increases the information content and avoids wrong deliveries if the Ident-No. is false.

Please see one example each for shank-type tools and tools with bore.

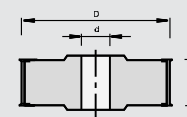
1.1.1 Shank-Type Tools

description: LEUCODIA shank-type cutter
 Class-No.: 229022
 Ident-No.: 181475
 dimensions: 25 x 38/120 x 25 (D X L2/L1 x d)
 sense of rotation: R (right-hand rotation)
 no. of teeth: Z3+3
 cutting material: DP (polycrystalline diamond)



1.1.2 Tools with Bore

description: chamfering cutterhead
 Class-No.: 120255
 Ident-No.: 167048
 dimensions: 125 x 50 x 30 (D x B x d)
 double keyway: DKW 12 x 5
 no. of teeth: Z4+4 (main cutting edge knives+spurs)
 cutting material: HW (tungsten carbide)



1.2 Special Tools

The quick processing of inquiries and orders requires detailed information.

1.2.1 Tool Data

- tool design (one-part tool, compound tool or composed tool)
- diameter x cutting width x bore (tools with bore)
- diameter x effective length x shank dimension (shank-type tools)
- no. of teeth
- profile depth
- sense of rotation
- operating speed (RPM)
- feed rate
- dimensions of keyways
- cutting material type

1.2.2 Type of feed

- manual feed (MAN)
- mechanical feed (MEC)

1.2.3 Sense of rotation

- right-hand rotation[R]
- left-hand rotation[L]



1.2.4 Workpiece

- workpiece material: solid woods, wood-based panels, composite materials, plastics, NF metals etc.
- surface texture of the workpiece material: veneered, plastic-laminated, melamine-faced, lacquered etc.

In the case of lack of clarity with regard to the workpiece material samples of the material to be machined can be sent.

1.2.5 Machine data

- brand and type
- range of RPM
- installed capacity
- max. tool dimensions
- interface
- type of feed etc.

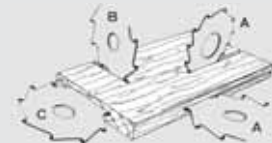
1.2.6 Position of the workpiece with regard to the tool

- reference surface and reference edge of the workpiece (i.e. machine cutting table surface)
- feed direction

1.2.7 Grain direction

Grooving in grain-oriented materials

- A along the grain
- B across the grain
- C end-grain cutting



Application with and across the grain

(1)

- position of workpiece is horizontal relative to the spindle
- direction of feed is across the grain
- position of the spindle is parallel to the grain
- peripheral edge cuts parallel to the grain
- end or side (flank) edge cuts vertical relative to the grain
- no preliminary cleavage

In rebating and grooving work the flank or side edges will make the separating cut



(2)

- position of workpiece is vertical relative to the spindle
- direction of feed is across the grain
- peripheral edge cuts through end grain
- flank or side edge cuts parallel to the grain
- no preliminary cleavage

In jointing, rebating and grooving work the peripheral edges will do the principal cutting.

1.2.8 Mode of application

- against feed
- with feed

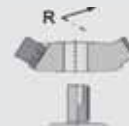
1.2.9 Profile details

Profile drawings must clearly show whether the workpiece or the tool is shown. Please state bearing side, sense of rotation, dimensions and application conditions on workpiece samples or drawings.

1.2.10 Information for chamfering, rabbeting and profiling tools

If no special information is available chamfering, rabbeting and profiling tools are always delivered as follows:

clockwise rotation and large diameter resp. top side spur.



2.1 Tools

One-piece tools (solid tungsten carbide tool / solid steel tool)

Tools without combined or removable parts; the body and the cutting parts are made from one piece.



Composite tools (tipped tools)

Tools with cutting parts (cutting tips) which are tightly connected with the body by means of welding, soft-soldering, hard-soldering, non-detachable bonding, etc.



Complex tools

Tools consisting of a body and one or more cutting parts (exchangeable inserts, knives) which can be changed by means of unlockable clamping elements. The cutting parts can be made in one-piece or compound design.



Tool set

Single tools which are mounted on a tool carrier and meant to work like one tool.



Tool combination

Unit consisting of multiple loose tools which can be combined with each other in diverse order or can be varied axially in different positions.



2.2 Tool bodies

2.3 Types of feed (according to EN 847)

Tool bodies are made from such materials that they can withstand the forces and strains to be expected during use. For this purpose steel- and aluminum materials are used. For shank-type tools supplemental materials are available.

2.3.1 Manual feed (MAN)

Manual feed means manually holding and guiding workpieces or machine elements with tools. Manual feed also includes using a removable feed device that is not interlocked with the tool as well as as a manual push-slide.

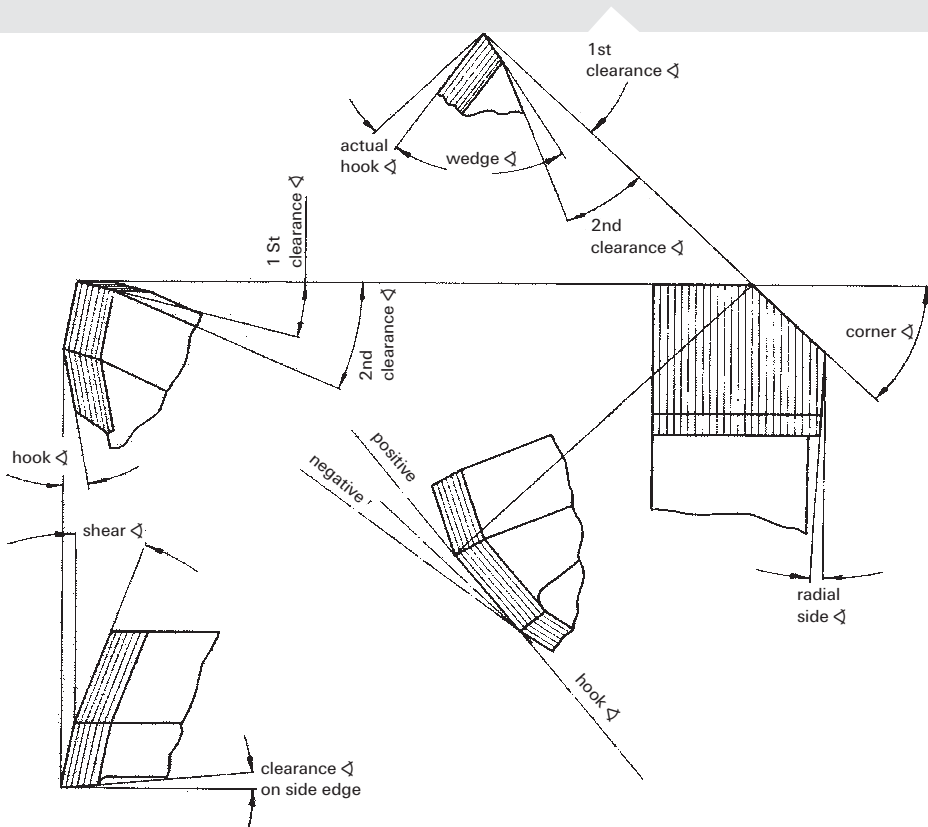
2.3.2 Mechanical feed (MEC)

Feed mechanism for the workpiece or the tool, integrated in the machine and by means of which the workpiece or machine element with tool is mechanically clamped and guided during operation.

2.4 Information with regard to the tables and charts

The working parameters for machining of wood and wood-composites are significantly co-determined by a multitude of individual factors (i.e. structure and composition of the workpiece material, machine parameters). In specific application cases there may be differences from the indications given in the tables and diagrams.

2.5 Angles and cutting edge geometries



Diameter D [mm]

Cutting width B [mm]

Hook angle [°]

Wedge angle [°]

Shear angle [°]

Corner angle [°]

3 Formulas, standard values and further information

cutting diameter D[mm]

RPM n [min⁻¹]

depth of knife marks t [mm]

medium chip thickness h_m [mm]

cutting speed v_c [m/s⁻¹]

depth of cut a_e [mm]

feedrate v_f [m/min⁻¹]

feedrate per tooth f_z [mm]

number of teeth z

$$D = (1000 \times 60 \times v_c) / (n \times \pi)$$

$$n = v_c \times 1000 \times 60 / (\pi \times D)$$

$$t = f_z^2 / (4 \times D)$$

$$h_m = f_z \times \sqrt{(a_e / D)}$$

$$v_c = \pi \times D \times n / (1000 \times 60)$$

$$v_f = f_z \times n \times z / 1000$$

$$f_z = v_f \times 1000 / (n \times z)$$

$$z = (v_f \times 1000) / (f_z \times n)$$

For safety reasons (noise emission, danger of kickback) the range of cutting speeds for tools with manual feed (MAN) lies between 40 - 70 m/s.

4 Cutting materials

4.1 General information

For woodworking the following cutting materials are used:

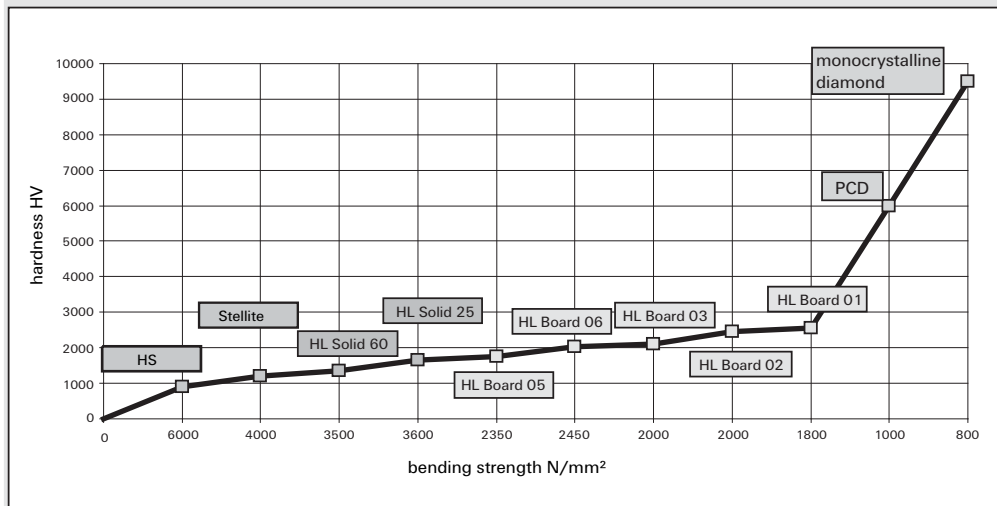
- SP alloyed steel
- HL high-alloyed steel
- HS high-speed steel
- HW uncoated tungsten carbide
- HC coated tungsten carbide
- ST casting alloy on cobalt basis
- DP polycrystalline diamond
- DM monocrystalline diamond

The multitude of materials to be machined and the various kinds of applications make different demands on the cutting edge and thus on the cutting edge material and the cutting edge geometry.

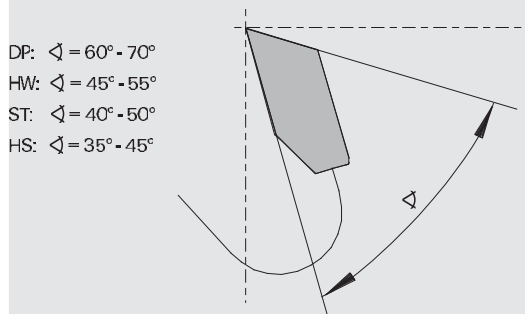
Whereas soft woods require a small hook angle, particle boards require a cutting edge which is extremely wear-resistant.

The optimum cutting material would thus be tough and hard.

The chart shows the hardness and bending strength of the most popular cutting materials.



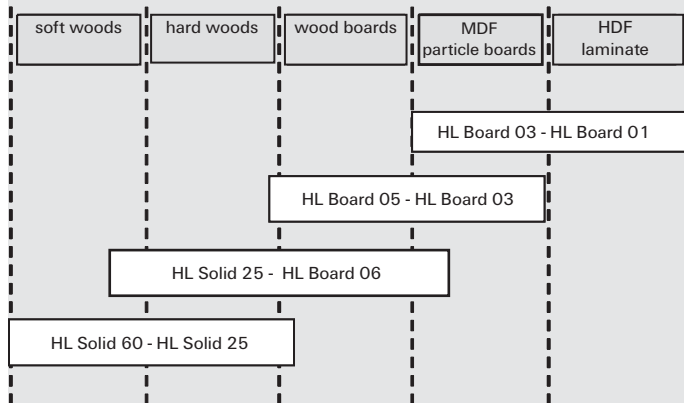
This suggests that an increase of hardness is inevitably linked with a decrease of the bending strength. With other words: „Hard cutting materials need a large wedge angle.“



4.2 Range of application of the different cutting materials

4.2.1 Tungsten carbide cutting materials (HW, HC)

Tungsten carbide grades are destined for the use in soft woods, hard woods and laminated timbers as well as in wood-based panels.



The spectrum of tungsten carbide grades ranges from HL Board 01 to HL Solid 60. HL Board grades are hard and wear-resistant. HL Solid grades are tougher and can have a smaller wedge angle.

4.2.2 Diamond cutting materials (DP)

Diamond cutting materials have a wide range of application (from hard woods to laminate overlays).

The applied diamond grades are exclusively made by well-known manufacturers of cutting materials who guarantee a constant high quality.

Mainly the following grades are applied:

	Fine	Medium	Coarse
Advantages	<ul style="list-style-type: none"> high wear resistance excellent surface quality excellent sharpness of cutting edges, long edge lives 	<ul style="list-style-type: none"> excellent wear resistance high sharpness of cutting edges moderate impact resistance 	<ul style="list-style-type: none"> extremely high wear resistance slightly lesser impact resistance and toughness
Application area	for moderately abrasive materials	universally applicable	for extremely abrasive materials

4.2.3 Monocrystalline diamond (DM)

Because of its high brittleness and hardness monocrystalline diamond is applied in the case of homogeneous and extremely abrasive workpiece materials. Application areas are for example the machining of laminate overlays and transparent plastics.

4.2.4 Casting alloy on cobalt basis (ST, Stellite)

Stellite is the ideal cutting material for the machining of humid woods.

4.2.5 High speed steel (HS)

High speed steel is chosen for the machining of soft and hard woods.

For special applications further cutting materials (e.g. CVD) and coatings (e.g. Topcoat) are available.

5 Workpiece materials

Overview

Solid woods	Soft woods Hard woods Exotic woods Veneers	
Wood-based materials	Laminated woods Particle materials Fiber boards Laminates Wood wool	Plywood etc. Particle boards MDF etc. HPL, CPL, Trespa, Multiplex etc. Heraklith etc.
Plastics	Thermoplastic Thermosets Fiber-reinforced plastics Polymer bound plastics	PA, PE, PMMA etc. Pertinax®, Restitex® etc. CFRP, GRP etc. Corian®, Varicor®, Noblan®, Kerrock® etc.
Composite materials	Solid wood laminated with Panels laminated with Gypsum boards Gypsum plaster boards Cement bonded boards Mineral wool boards Plastics with metals (Alucobond® etc.)	HDF, MDF, veneer HPL, cork etc.
NF-Metals	Pure aluminum Al-Mg-Cu Al-Si alloys	

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 Fax: (007)-3452-470707
 E-Mail: 470707@stanki72.ru / ferrum-iberus@mail.ru
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- HW-Service

Spain

Huleco S.A.
 C/Vicente Roca Cervera, 39
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- HW-Service

USA

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 Phone: (001)-901-346-3044
 E-Mail: sales@leucotool.com
 Internet: www.leucotool.com

- HW-Service

Singapore

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 No. 3 Sungei Kadut Crescent
 Singapore 728686
 Phone: (65)-6362-0788
 Fax: (65)-6362-0733
 E-Mail: leucosg@leucosg.com.sg
 Internet: www.leucosg.com.sg

- HW-Service
- DP-Service

Spain

Huleco S.A.
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 28971 Grinon (Madrid)
 Phone: (34)-0918-140225
 Fax: (34)-0918-140336
 E-Mail: huleco@huleco.es

- DP-Service

USA

LEUCO Tool Corporation
 500 Industrial Court West
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 Phone: (1)-770-459-5784
 Fax: (1)-770-459-1445
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 Internet: www.leucotool.com

- HW-Service
- DP-Service

South Africa

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 Phone: (27)-021-557-5364
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- HW-Service

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- HW-Service
- DP-Service

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 Internet: www.leucotool.com

- HW-Service
- DP-Service



AS GOOD AS NEW: EXCELLENT RESHARPENING SERVICE

As a premium manufacturer we know cutting materials and cutting edge geometries very well and have access to the original data. Among others, LEUCO offers carbide-tipped tools with different carbide grades and thus meets the application like no other. As a manufacturer, LEUCO has the know-how for the best service.

In addition, the excellent LEUCO sharpening service is characterized by:

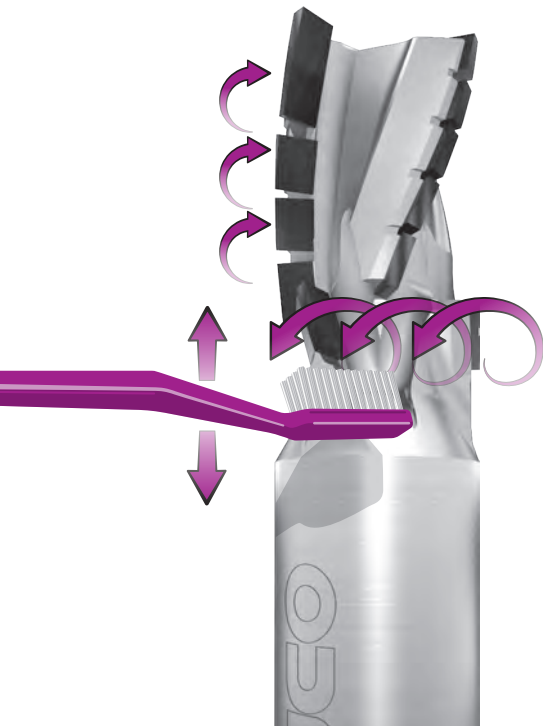
- | sharpening know-how of well-trained LEUCO employees
- | the most modern high-tech systems in the company service centers
- | availability of your tools based on strict sharpening schedules

LEUCO diamond and carbide service: worldwide

The maintenance of quality tools is necessary for optimal results in woodworking. This is satisfied with a worldwide network of specialists and sharpening services that put your tools back in shape. Our global pickup and delivery service has its own service network covering your area as well - worldwide.

As a quality-aware tool manufacturer we repair all of your tools. Whether sharpening of all tooth geometries and tooth replacement up to adjustment, alignment, eroding and setting - the precision and quality required, throughout the entire life-span of the tool, along with ensuring the economy of the work at the same time, are the factors in measuring the work of our LEUCO Service Team.

Please find the contact data of your competent LEUCO service partner at the end of the catalog or give us a call: +49(0) 745 1/93-0 or info@leuco.com



“GOOD SERVICE IS NOT JUST SMILING AT THE CUSTOMER BUT MAKING THE CUSTOMER SMILE.

**THIS IS WHAT WE STRIVE FOR!
TO WIN YOUR SMILE!”**

LEUCO SERVICES

Not only is the correct tool selection important for LEUCO, but also the high quality repair and sharpening service plays an important role. As well as the sharpening expertise among our employees, modern high-tech equipment guarantees the worldwide availability of tools in manufacturer quality.

LEUCO has been offering a diverse range of module based services for a number of years. Different invoicing models, or a gradual, modular tool management are the selections a customer can make depending on the application.

LEUCO's invoicing models

Consignment stock:

This enables the customer to have a stock of tools at their factory. A tool can be taken from stock when it is needed in production, and then the customer receives an invoice for the tool.

Life cycle invoicing:

The customer is invoiced according to the sharpening frequency, i.e. the customer pays a percentage of the new tool cost at the same time as paying for the sharpening service.

LEUCO-Leasing:

LEUCO places the tool at the customer's disposal. The tool remains the property of LEUCO. The customer is invoiced for produced units (pay-on-product).

Gradual, modular tool management

Visualisation by the LEUCO color code scheme for tool, stock position and machine that provides a certain transparency for customer tool management

Each tool has a code consisting of a color, which defines the tool type, and a letter, which defines the position on the machine at which the tool is required. Additionally, each tool has an accompanying card including a color code; this color code is also allocated to a stock position, and a machine position for clear and easy recognition. If required, LEUCO can assist the customer in developing a concept for their stock system, as well as helping to implement it.

Stock balance from the ERP system

In this way orders can be given in time to re-stock, so that the customer has a constant supply of tools. The danger of a production stop is ruled out entirely. Based on these evaluations, useful information about the tool and its use can be obtained such as total amount of processes achieved with the tool or the actual number of re-sharpening compared to the pre-defined sharpening quota.



Tool Checklist

Imperative features for special tools

	Saw Blades / Hoggers	Cutters with Bore	Finger Joint Cutters	Shank-Type Cutters	Drill Bits / Plunge Cutters	Profile Knives
Machine data						
Flange diameter	●					
Spindle diameter	●	●	●			
Spindle position	●	●	●	●		
RPM [n]	●	●	●	●		
Feedrate [Vf]	●	●	●	●	●	
Type of feed [MEC / MAN]	●	●	●	●		
Clamping system [e.g. Tribos, ps-System]	●	●	●	●	●	●
Machining data						
Workpiece material	●	●	●	●	●	●
Required cutting quality	●	●	●	●	●	●
Cutting direction [along, across, ...]	●	●		●		
Application [with feed, against feed]	●	●		●		
Design	●					
Tool data						
Product group [PHG]	●	●	●	●	●	●
Single / set tool	●	●	●	●	●	●
Outside diameter	●	●	●	●	●	●
Cutting width [B]	●	●	●	●		
Bore diameter 1, shank diameter 2 [d]	● ₁	● ₁	● ₁	● ₂	● ₂	
Number of teeth [T], Description of cutterhead	●	●	●	●	●	● ₁
Shear angle	●	●		●		
Raker 1; spur 2	● ₁	● ₂		● ₂	● ₂	
Pin holes [NL]	●	●				
Cutting material	●	●	●	●	●	●
Keyway [KN], double keyway [DKN]	●	●	●			
Plunging insert / face cutting edge				●		
Drawing						
Drawing	●	●	●	●	●	●
Tool dimension	●	●	●	●	●	●
Arrow indicating direction of rotation	●	●	●	●	●	

Tool Checklist

Imperative features for special tools

Date: _____

LEUCO sales person	_____	Offer / Order no.	_____
Customer	_____		
Address	_____		
Contact name	_____	Phone: _____	Fax: _____
Customer no.	_____	E-mail: _____	_____

Machine data

Machine	_____	Type	_____
Flange Ø [mm]	_____	RPM [min-1]:	_____
Spindle Ø [mm]	_____	Spindle position	<input type="checkbox"/> Horizontal <input type="checkbox"/> Vertical <input type="checkbox"/> Tilted
Type of feed	<input type="checkbox"/> MEC <input type="checkbox"/> MAN	Clamping System	_____
		Feed rate [m/min]:	_____
		Degree of tilt [°]	_____

Machining data

Workpiece material	_____	Mode of application:	<input type="checkbox"/> Against feed <input type="checkbox"/> With feed
Cutting quality	<input type="checkbox"/> Trimming cut <input type="checkbox"/> Finish cut	<input type="checkbox"/> Pre-Trimming	<input type="checkbox"/> Finish-Trimming
Cutting direction	<input type="checkbox"/> With grain <input type="checkbox"/> Across grain	<input type="checkbox"/> Crosscut wood	<input type="checkbox"/> Contour <input type="checkbox"/> Drill
Profile as drawing no.	<input type="checkbox"/> Drawing <input type="checkbox"/> Wood sample	<input type="checkbox"/> Tool sample	<input type="checkbox"/> Customer drawing
Version hoggers	<input type="checkbox"/> Folding <input type="checkbox"/> Stepped	<input type="checkbox"/> Circular cut	<input type="checkbox"/> Double hogging <input type="checkbox"/> Scoring / Hogging

Tool data

Type of tool	_____	Prod. group	_____	Class-No.	_____
<input type="checkbox"/> Single tool	<input type="checkbox"/> Set tool	<input type="checkbox"/> Bolted		<input type="checkbox"/> Pinned	
Ø D [mm]	B [mm]	Ø d [mm]	_____	Hub diameter [mm]	_____
Z [qty.] _____	Raker [qty.] _____	Spur [qty.] _____	<input type="checkbox"/> Plunge tip	<input type="checkbox"/> Face cutting edge	
KN [mm]	DKN [mm]	NL [mm]	_____	Minor diameter [mm]	_____
Shear angle <input type="checkbox"/> Yes <input type="checkbox"/> No	Hook angle [°]	TOK runout [°]	_____	Description of cutterhead	_____
Cutting material	<input type="checkbox"/> HS <input type="checkbox"/> ST	<input type="checkbox"/> HW <input type="checkbox"/> DP		Cutting material quality	_____

Drawing

482-01.0613

01

Code designations of the cutting materials

NEW - according to ISO	Signification	Old name
SP	alloyed tool steel (minimum 0.6% C and no more than 5 % alloy constituents)	SP
HS	high-alloyed steel (more than 12 % alloy elements Mo, V, Co in total)	HSS
ST	casting alloy on cobalt basis e.g. Stellite	Stellite
HW	uncoated tungsten carbide	HM
VHW	solid tungsten carbide	VHM
DP	polycrystalline diamond	DIA

02

Tool Attributes

Short form	Significance
NL	pin holes
KN	keyway
DKN	double keyway
n	permitted range of RPM
n max	maximum RPM
U min-1	rotations per minute
Vc	cutting speed
Vf	feedrate
Z	number of teeth

03

Types of feed

Short form	Significance
MEC	mechanical feed
MAN	manual feed

04

Delivery signs

Short form	Significance
⊕	modification and/or mounting of stock parts
o	available on short notice
s	production per drawing
#	new type in process
\$	Superstandard

All Ident-No. are available from stock unless specifically indicated.

LEUCO Ledermann GmbH & Co. KG fulfills all demands of ISO 9001:2008.
The certificate-no. is 01 100 010679.

LEUCO DIALOG

you're part of it. welcome!



LEUCO completely changed their online presence. With the clearly structured and modern new homepage LEUCO presents themselves as a competent partner for premium tools for the woodworking and furniture industry on an international level.

The first page lists the newest information about LEUCO and gives a quick overview of the LEUCO contact data.

The menu item "Products" gives information as to the tools. The new menu item "Solutions" provides a multitude of information around the tools, e.g. about specific applications such as through-feed and stationary machining, door manufacturing, flooring and cutting materials used for the tools. Clicking on "Career", qualified young people as well as professional and managerial staff can get an overview of LEUCO as an employer.

In the Service menu item folders, catalogs, the LEUCO customer magazine "LEUCOLINE" and videos can be downloaded.

THE NEW WWW.LEUCO.COM!

**WHETHER YOU HAVE A PC,
TABLET OR SMARTPHONE -
THE DISPLAY OF THE LEUCO
HOMEPAGE IS OPTIMAL ON
ALL DEVICES.**





CATALOG
GENERAL PROGRAM 03



SOLID WOOD

SAWING

THROUGH-FEED

STATIONARY