



Cutters with Bore

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122110

Edge Jointing Cutters one part version - IMA (BIMA)

Product		Drawing					
					Tungsten Carbide [HW]		
					MEC		
Machine / Application		Design		Advantages		Notes	
<ul style="list-style-type: none"> edge banding machines IMA model BIMA with glueing device and Combiform / flush cutting unit 6120, 6121 for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<ul style="list-style-type: none"> cutting edges parallel to cutter axis one part version countersunk on both sides for application on top and bottom n max = 18,000 min-1 				<ul style="list-style-type: none"> sense of rotation see drawing 	
Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
70	6	3.5	30	6	IMA (BIMA)	658554 s	658554 s
[mm]	[mm]	[mm]	[mm]				

122110

Edge Jointing Cutters two-part version - IMA (BIMA)

Product		Drawing					
					Tungsten Carbide [HW]		
					MEC		
Machine / Application		Design		Advantages		Notes	
<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 		<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 				<ul style="list-style-type: none"> sense of rotation see drawing 	
Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
70	6	6	30	6	IMA (BIMA)	716658 s	716657 s
[mm]	[mm]	[mm]	[mm]				

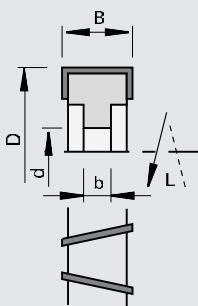
122110

Edge Jointing Cutters

Product



Drawing



Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l with alternating shear angle
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	shear∠		Ident-No.
55	20	10	16	4	5x2,3	5	Raimann	160642 s
70	35	20	20	4	6x2,8	10		160645
[mm]	[mm]	[mm]	[mm]		[mm]	[°]		

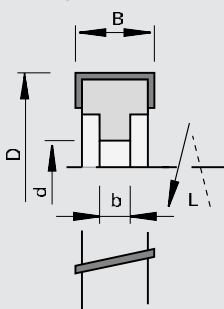
122110

Edge Jointing Cutters

Product



Drawing



Machine / Application

l edge banding machines
l for jointing and flush-cutting of solid wood, veneer and plastic edge bands

Design

l with shear angle
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	shear∠		Ident-No. [L]	Ident-No. [R]
70	25	10.5	16	4	5x2,3	10	Homag	180796	180795
100	25	15	30	4		15		160647	160109
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

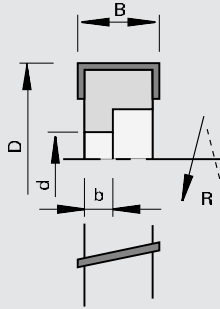
122110

Edge Jointing Cutters

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 with shear angle
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	shear∠		Ident-No. [L]	Ident-No. [R]
70	25	10.5	16	4	5x2,3	10		057387	057388
70	23	12.5	20	4	6x3,5	10	IMA	772982 s	772981 s
70	25	12.5	20	4	6x3,5	10	IMA	006291	006290
[mm]	[mm]	[mm]	[mm]		[mm]	[°]			

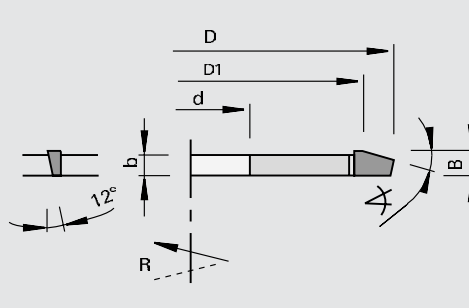
122115

Edge Jointing Cutters - Brandt

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l edge banding machines
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l n = 8,100 - 13,800 min-1

Advantages

Notes

l sense of rotation according to DIN-EN 50144

chamfer∠	Ø D1	Ø D	B	b	Ø d	Z	shear∠		Ident-No. [L]	Ident-No. [R]
15	60	66	4	3	16	6	12	Brandt	819482 s	819481 s
16		96	5,8	5	40	12	12	Brandt	164658 s	164657 s
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]			

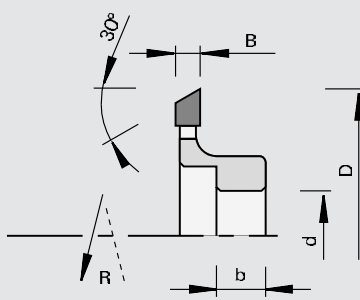
122100

Edge Jointing Cutters - IMA

Product



Drawing



Machine / Application

l edge banding machines
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l cutting edges parallel to cutter axis
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation see drawing

$\varnothing D$	B	b	$\varnothing d$	Z	DKN		Ident-No. [L]	Ident-No. [R]
73	6	12	20	12	6x3,5	IMA	171240	171239
[mm]	[mm]	[mm]	[mm]		[mm]			

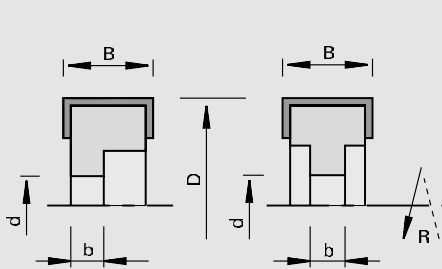
120100

Edge Jointing Cutterheads

Product



Drawing



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

$\varnothing D$	B	b	$\varnothing d$	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
61	20	11	16	3	5x2,3	Homag		167900
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
70	20	11	16	4	5x2,3	Homag, Homburg		164071
70	20	20	16	4	5x2,3	Ott		164069
70	20	12.5	20	6	2/6x3,5	IMA, SCM-IDM	164134	164080
70	20	12.5	20	4	6x3,5	Brandt, Homag	164133	164079
70	20	11	20	4	6x3,5	HOLZ-HER		164070
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		985730	009672
	[mm]			

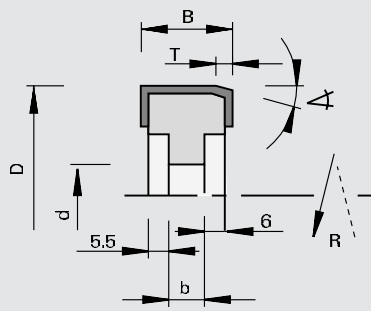
120100

Edge Jointing Cutterheads - HOLZ-HER

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l edge banding machines HOLZ-HER
- 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 06
- l n max = 18,000 min-1

Advantages

Notes

- l 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	29,5	17	20	5	4	HOLZ-HER	164462	164463
[°]	[mm]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives	B	H	S	Class-No.	Ident-No.
for lefthand rotation	29,5	12	1.5	150515	160618
for righthand 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	985730	166090
	[mm]		

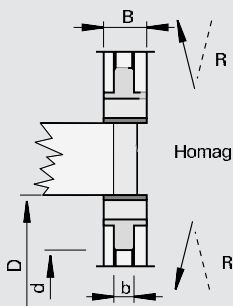
120101

Edge Jointing Cutterheads - Homag

Product



Drawing



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

$\emptyset D$	B	b	$\emptyset d$	Z	DKN		Ident-No.
70	14,3	10	16	4	5x2,3	Homag	170247
70	20	10	16	4	5x2,3	Homag	168510
[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

	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x10,8 T15	995125	180840
Screwdrivers	T15x100 [mm]	985730	180470

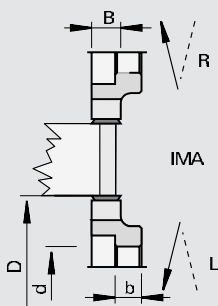
120101

Edge Jointing Cutterheads - IMA

Product



Drawing



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

$\emptyset D$	B	b	$\emptyset d$	Z	DKN		Ident-No. [L]	Ident-No. [R]
70	14,3	13	20	4	6x3,5	IMA	172717	172718 #
[mm]	[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.
Countersunk Flat Headed Screws	M5x10,8 T15			995125	180840
Screwdrivers	T15x100			985730	180470
	[mm]				

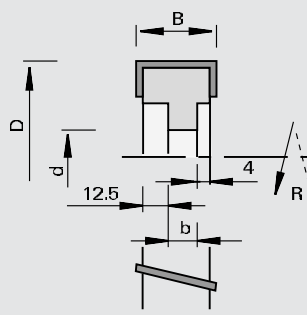
120110

Edge Jointing Cutterheads - Brandt

Product



Drawing



LEUCO DUR
Tungsten Carbide [HW]
MEC


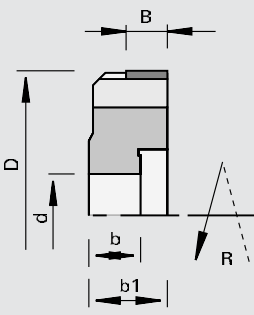
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines for jointing and flush-cutting of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> with shear angle cutting material: HW HL Board 05 n max = 18,000 min-1 		<ul style="list-style-type: none"> sense of rotation see drawing

Ø D	B	b	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
70	29,5	11	16	4	5x2,3	Brandt	170190	170189
[mm]	[mm]	[mm]	[mm]		[mm]			

Turnover Knives	B	H	S	Class-No.	Ident-No.
	30	12	1.5	150515	003083
	[mm]	[mm]	[mm]		
Spare parts	Dimension			Class-No.	Ident-No.
Clamping Bars	B=26,6			925300	167885
Set Screws	M8x10 DIN EN ISO 4028			995161	001622
Screwdrivers	SW4x100			985730	166091
	[mm]				


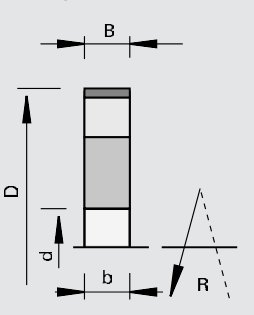
2225 10

Edge Jointing Cutters

Product		Drawing		LEUCO <i>topline</i> K ₁		LEUCO DIAMAX		Polycrystalline Diamond [DP]		MEC	
											
Machine / Application		Design		Advantages		Notes					
<ul style="list-style-type: none"> edge banding machines Brandt, Homag, SCM-IDM, IMA for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<ul style="list-style-type: none"> polished face and high-finish clearance angle reduced resharpenable area straight cutter axis n max = 24,000 min⁻¹ 		<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 		<ul style="list-style-type: none"> sense of rotation according to DIN-EN 50144 					
$\emptyset D$	B	b	b1	$\emptyset d$	Z	DKN		Ident-No. [L]	Ident-No. [R]		
70	10	12.5	19	20	4	6x3,5		175787 #	175786 #		
70	10	12.5	19	20	6	6x3,5		175789	175788		
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]					

2225 10

Edge Jointing Cutters

Product		Drawing		LEUCO <i>topline</i> K ₁		LEUCO DIAMAX		Polycrystalline Diamond [DP]		MEC	
											
Machine / Application		Design		Advantages		Notes					
<ul style="list-style-type: none"> edge banding machines Brandt, Homag for jointing and flush-cutting of solid wood, veneer and plastic edge bands 		<ul style="list-style-type: none"> polished face and high-finish clearance angle reduced resharpenable area straight cutter axis n max = 24,000 min⁻¹ 		<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 		<ul style="list-style-type: none"> sense of rotation according to DIN-EN 50144 					
$\emptyset D$	B	b	$\emptyset d$	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]						

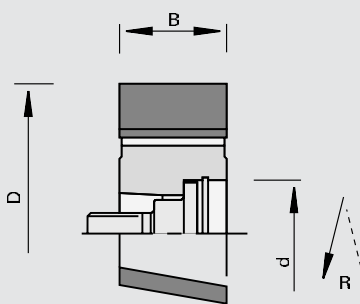
122110

Edge Jointing Cutters HSK 25R - Homag, IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag, IMA
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min⁻¹

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	25	HSK 25R	4	177590	177589
70	35	HSK 25R	4	178035	178034
[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

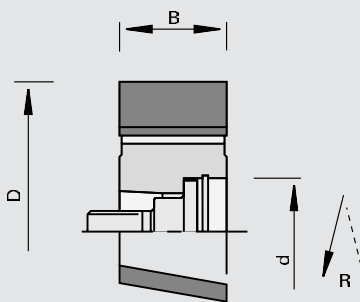
122110

Edge Jointing Cutters HSK 25R - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
Homag
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l n max = 24,000 min⁻¹

Advantages

l optimum cutting quality thanks to high concentric accuracy and precise tool balancing
l optimized chip removal thanks to internal chip evacuation
l less chips remain inside of the machine
l no malfunctions due to chips
l reduction of suction power
l noise reduced

Notes

l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
70	25	HSK 25R	4	180765	180766
[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

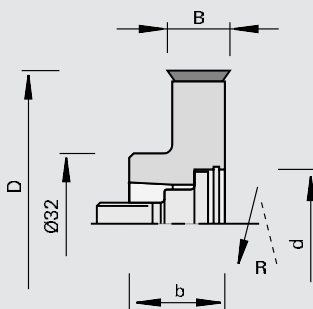
120101

Edge Jointing Cutterheads 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

- 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 [mm]	14,3 [mm]	23 [mm]	HSK 25R [mm]	4	177592	177591

Turnover Knives	B	H	S	Class-No.	Ident-No.
	14,3 [mm]	14,3 [mm]	2,5 [mm]	150518	170248

Spare parts	Dimension	Class-No.	Ident-No.
Countersunk Flat Headed 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 [mm]	995460	177782

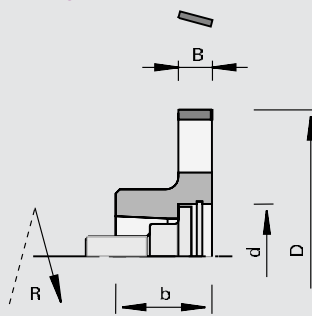
222510

Edge Jointing Cutters HSK 25R - Homag, IMA

Product



Drawing



LEUCO
topline

LEUCO
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 [mm]	995460	177782

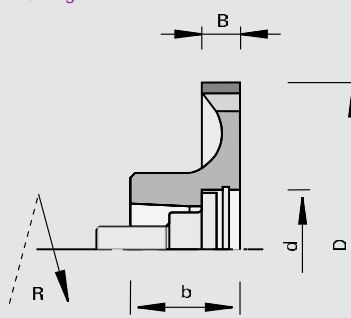
222812

Edge Jointing Cutters HSK 25R - Homag, IMA

Product



Drawing



LEUCO
topline

LEUCO
i@system

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines Homag
- 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 feedrate 20 - 30 m/min
- Z = 6 for feedrate 30 - 45 m/min
- Z = 8 for feedrate 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 #	180651 #
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 one-part version - IMA (BIMA)

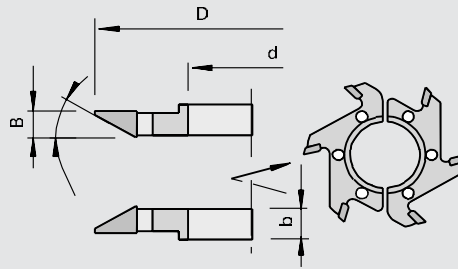
Product	Drawing						
			Tungsten Carbide [HW]				
			MEC				
Machine / Application	Design	Advantages	Notes				
<ul style="list-style-type: none"> edge banding machines IMA model BIMA with glueing device and Combiform / flush cutting unit 6120, 6121 for flush-cutting and chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> with shear angle one part version n max = 18,000 min-1 		<ul style="list-style-type: none"> sense of rotation see drawing 				
chamfer ↙	Ø D	B	b	Ø d	Z	Ident-No. [L]	Ident-No. [R]
30 [°]	70 [mm]	6 [mm]	3.5 [mm]	30 [mm]	6	IMA (BIMA) 658797 s	658796 s

122110

Edge Chamfering Cutters two-part version - IMA (BIMA)

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA model BIMA with glueing device / flush cutting unit 6 135
l for flush-cutting and chamfering of solid wood, veneer and plastic edge bands

Design

l with shear angle
l two part version
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation see drawing

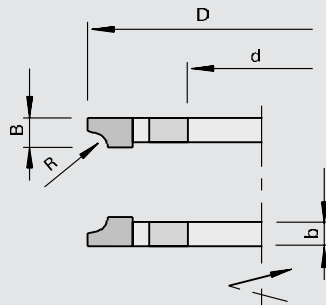
chamfer \sphericalangle	$\varnothing D$	B	b	$\varnothing d$	Z		Ident-No. [L]	Ident-No. [R]
30	70	9	9	30	6	IMA (BIMA)	180164	180163
2	70	9	9	30	6	IMA (BIMA)	180161 s	180162 s
[°]	[mm]	[mm]	[mm]	[mm]				

122110

Edge Rounding Cutters one-part version - IMA (BIMA)

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA model BIMA with glueing device and Combiform / flush cutting unit 6120, 6121
l for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

l one part version
l with shear angle
l n max = 18,000 min-1

Advantages

Notes

l sense of rotation see drawing

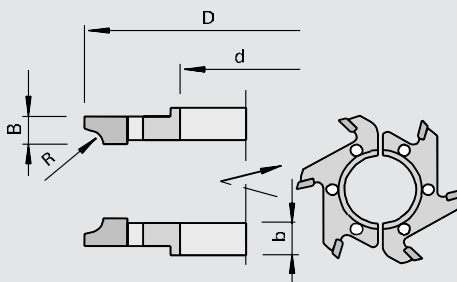
R	$\varnothing D$	B	b	$\varnothing d$	Z		Ident-No. [L]	Ident-No. [R]
1	70	6	3.5	30	6	IMA (BIMA)	833942 s	833941 s
2	70	6	3.5	30	6	IMA (BIMA)	827928 s	827927 s
2,5	70	6	3.5	30	6	IMA (BIMA)	658556 s	658555 s
3	70	6	3.5	30	6	IMA (BIMA)	823139 s	823140 s
4	70	8	3.5	30	6	IMA (BIMA)	827930 s	827929 s
5	70	8	3.5	30	6	IMA (BIMA)	827242 s	827236 s
6	70	10	3.5	30	6	IMA (BIMA)	827249 s	827248 s
10	74	12	3.5	30	6	IMA (BIMA)	720378 s	833943 s
[mm]	[mm]	[mm]	[mm]	[mm]				

122110

Edge Rounding Cutters 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

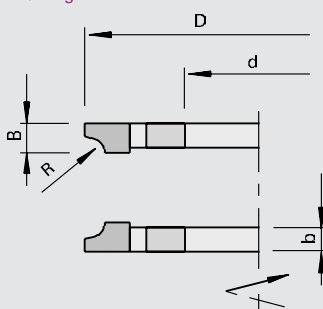
R	Ø D	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
2	70	6	6	30	6	IMA (BIMA)	180155	180156
2	70	9	9	30	6	IMA (BIMA)	180157	180158
2,5	70	6	6	30	6	IMA (BIMA)	708379 s	708378 s
2,5	70	7,6	6	30	6	IMA (BIMA)	710972 s	710971 s
3	70	6	6	30	6	IMA (BIMA)	180165	180166
3	70	9	9	30	6	IMA (BIMA)	180167	180168
4	72	7,5	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 one-part version - Brandt

Product

Drawing

LEUCO
DUR

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

R	Ø D	Ø D1	B	b	Ø d	Z		Ident-No. [L]	Ident-No. [R]
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]				

120102

Edge Chamfering Cutterheads for machining centers - Homag

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

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag machining center 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"> sense of rotation according to DIN-EN 50144


chamfer∟	Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
5	60	12	19	3	179207 s	179206 s
15	60	12	19	3	178634 s	178633 s
30	60	13,5	19	3	178632	178631
45	60	12	19	3	178630	178629
[°]	[mm]	[mm]	[mm]			

Knives	chamfer Ø	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	177823	177822
	[°]	[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 [mm]	985730	166090


120101

Edge Chamfering Cutterheads for machining centers - Homag

Product		Drawing					 Tungsten Carbide [HW] MEC	
Machine / Application edge banding machines Homag machining center for flush-cutting 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 = 18,000 min-1		Advantages		Notes especially for thin edge bands sense of rotation according to DIN-EN 50144		
chamfer \sphericalangle	$\varnothing D$	B	$\varnothing d$	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 for machining centers - Homag

Product		Drawing					 Tungsten Carbide [HW] MEC	
Machine / Application edge banding machines Homag machining center for rounding of solid wood, veneer and plastic edge bands		Design cutting edges parallel to cutter axis cutting material: HW HL Board 05 n max = 18,000 min-1		Advantages		Notes same cutterhead body for R 1.5 - 3 mm; R 4 - 5 mm sense of rotation according to DIN-EN 50144		
R	$\varnothing D$	$\varnothing D1$	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
2	59	50	13	4	19	3	1807498	1807488
3	59	50	13	4	19	3	1807518	1807508
4	63	50	14	4	19	3	178795 s	178794 s
5	63	50	15	4	19	3	178797 s	178796 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	1,5	13	15	2	151546	181954	181953
	2	13	15	2	151546	181956	181955
	3	13	15	2	151546	181957	181958
	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]		

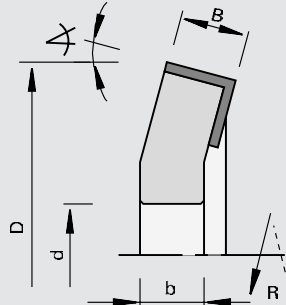
120120

Edge Chamfering Cutterheads - Homag

Product



Drawing



Tungsten Carbide [HW]
MEC

Machine / Application

- edge banding machines Homag
- for flush-cutting 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 = 18,000 min-1

Advantages

Notes

- sense of rotation according to DIN-EN 50144

chamfer [°]	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	Homag	Ident-No. [L]	Ident-No. [R]
15	65	12	11	16	3	5x2,3	Homag	167735	167734

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	164526
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Screwdrivers	SW3x100	985730	166090
	[mm]		

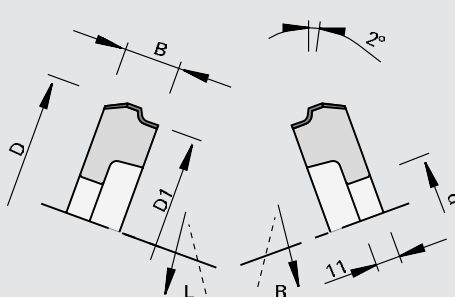
120102

Edge Rounding Cutterheads - Homag Softforming

Product



Drawing



Machine / Application

l edge banding machines
Homag during the softforming process
l for rounding 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

Notes

l same cutterhead body for R 2 - 5 mm; R 5 - 8 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	75	66	20,5	11	16	3	5x2,3	163079	163080
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
7	80	66	30	11	16	3	5x2,3	163089	163090
8	80	66	30	11	16	3	5x2,3	163091	163092
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
	2	20,5	15	2	15 1545	163062
	3	20,8	15	2	15 1545	163063
	5	30	17	2	15 1545	163065
	6	30,5	17	2	15 1545	163066
	7	30	17	2	15 1545	163067
	8	30,5	17	2	15 1545	163068
	[mm]	[mm]	[mm]	[mm]		

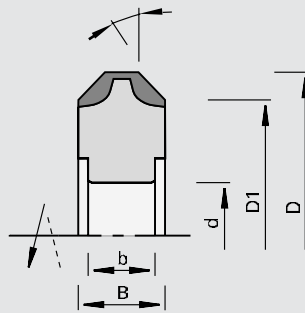
Spare parts	Dimension	for Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=18	163079, 163080, 163081, 163082	925300	163077
Clamping Bars	B=27,6	163085, 163086, 163087, 163088, 163089, 163090, 163091, 163092	925300	163078
Set Screws	M6x12 DIN EN ISO 4028		995161	180214
Screwdrivers	SW3x100		985730	166090
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
Magnetic Stops	0,0		997800	016613
	[mm]			

120102

Edge Chamfering Cutterheads

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 right and left hand rotation
l sense of rotation according to DIN-EN 50144

chamfer	∅ D	∅ D1	B	b	∅ 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 ∅ D = 57	45	12	12	1.5	151545	171190
for ∅ 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]			

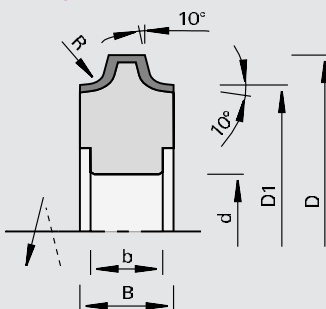
120102

Edge Rounding Cutterheads

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines
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 for right and left hand 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
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	171128
3	73	61	16	11	16	3	5x2,3	Homag	171129
4	73	61	16	11	16	3	5x2,3	Homag	171130&
5	73	61	16	11	16	3	5x2,3	Homag	171131&
6	81	61	24	11	16	3	5x2,3	Homag	170254&
8	81	61	24	11	16	3	5x2,3	Homag	170256&
9	81	61	24	11	16	3	5x2,3	Homag	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
	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
for Ø D = 62/73/82	5	16	17.5	2	15 1545	163492
for Ø D = 81	6	24	22	2	15 1545	170258
for Ø D = 81	8	24	22	2	15 1545	170260
for Ø D = 81	9	24	22	2	15 1545	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]			

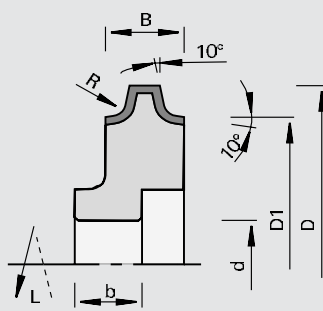
120102

Edge Rounding Cutterheads - IMA

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l edge banding machines IMA
l for rounding of solid wood,
vener and plastic edge bands

Design

l cutting edges parallel to cutter
axis
l cutting material: HW HL Board
05
l n max = 18,000 min⁻¹

Advantages

Notes

l same cutterhead body for R 2
- 5 mm
l sense of rotation see drawing

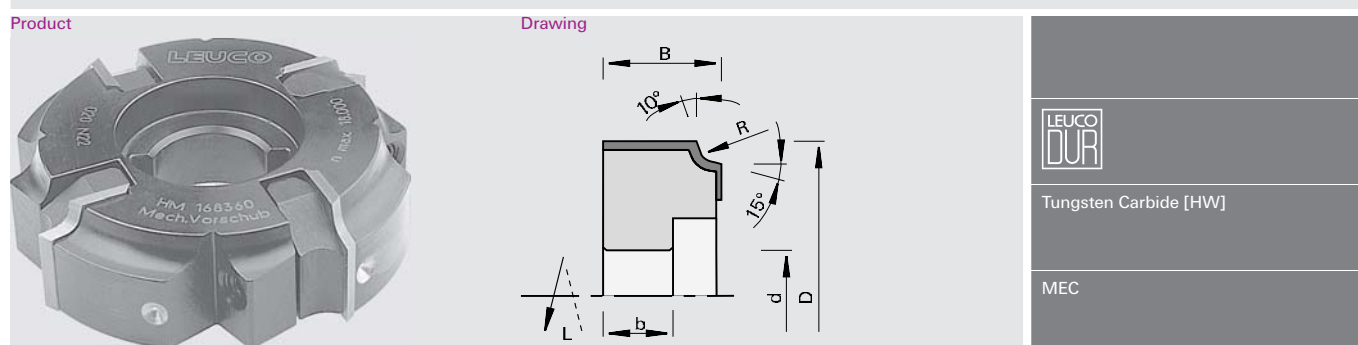
R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2	82	70	16	13	20	4	6x3,5	168373	168374
3	82	70	16	13	20	4	6x3,5	168353	168354
4	82	70	16	13	20	4	6x3,5	168375	168376
5	82	70	16	13	20	4	6x3,5	168377	168378
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
Chamfering Knives	Fase	16	17.5	2	15 1545	169292
Radius Knives	2	16	17.5	2	15 1545	163489
Radius Knives	3	16	17.5	2	15 1545	163490
	[mm]	[mm]	[mm]	[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
Radius Knives	4	16	17.5	2	15 1545	163491
Radius Knives	5	16	17.5	2	15 1545	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 Cutterheads - IMA „Kompakt“



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines IMA „Kompakt“ for rounding 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"> sense of rotation see drawing

R	Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
3	70	20	12.5	20	4	6x3	168359	168360
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives	R	B	H	S	Class-No.	Ident-No.
for righthand rotation	3	20	16	2	15 1555	168356
for lefthand rotation	3	20	16	2	15 1555	168355
	[mm]	[mm]	[mm]	[mm]		

Spare parts	Dimension	for Ident-No.	Class-No.	Ident-No.
Clamping Bars	18x15,5x7	168359	925300	168357
Clamping Bars	18x15,5x7	168360	925300	168358
Set Screws	M6x12 DIN EN ISO 4028		995161	180214
Cranked Wrench Keys	SW3 DIN ISO 2936		985730	009672
	[mm]			

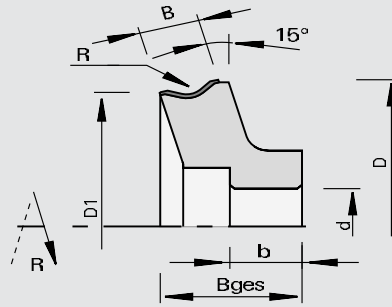
120102

Edge Rounding Cutterheads - 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
- 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]		

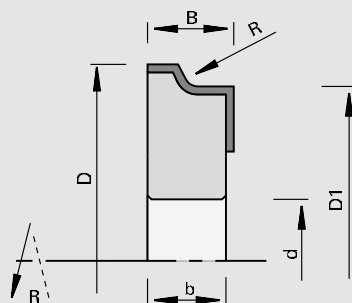
120102

Edge Rounding Cutterheads - 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 Ø 56 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	12	11	16	4	5x2,3	172138	172137
3	56	50	12	11	16	4	5x2,3	172140	172139
2	56	50	16	11	16	4	5x2,3	178215	178214
[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	16,1	14	2	151545	178219	178218
			[mm]	[mm]	[mm]	[mm]			
Spare parts			Dimension	for Ident-No.			Class-No.	Ident-No.	
Clamping Bars			B=10	172137, 172138, 172139, 172140			925300	171221	
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	178214, 178215			995161	180214	
Cranked Wrench Keys			SW2,5 DIN ISO 2936	172137, 172138, 172139, 172140			985730	009671	
Cranked Wrench Keys			SW3 DIN ISO 2936	178214, 178215			985730	009672	
Magnetic Stops			0,0				997800	016613	
			[mm]						

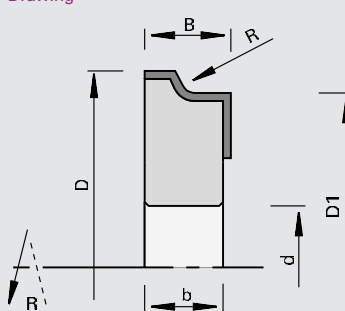
120102

Edge Rounding Cutterheads

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 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	for Ident-No.			Class-No.	Ident-No.	
Clamping Bars			B=17	172137, 172138, 172139, 172140			925300	167971	
Set Screws			M6x10 DIN EN ISO 4028	172137, 172138, 172139, 172140			995161	180002	
Cranked Wrench Keys			SW3 DIN ISO 2936	172137, 172138, 172139, 172140			985730	009672	
Magnetic Stops			0,0				997800	016613	
			[mm]						

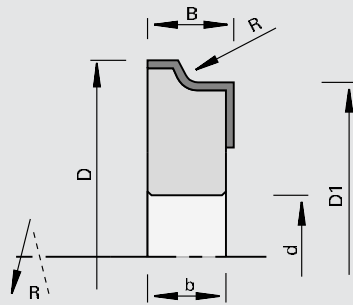
120102

Edge Rounding Cutterheads - Brandt, EBM, Reich

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- edge banding machines Brandt, EBM, Reich
- for rounding and flush-cutting of solid wood, veneer and plastic edge bands

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Board 05
- n max = 18,000 min⁻¹

Advantages

Notes

- same cutterhead body for R 2 - 3 mm
- sense of rotation according to DIN-EN 50144

R	Ø D	Ø D1	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
2,0	56	50	15	11	16	3	5x2,3	179995	179996
2,5	56	50	15	11	16	3	5x2,3	177325	177326
3,0	56	50	15	11	16	3	5x2,3	177327	177328
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

Knives

R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
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
[mm]	[mm]	[mm]	[mm]			

Spare parts

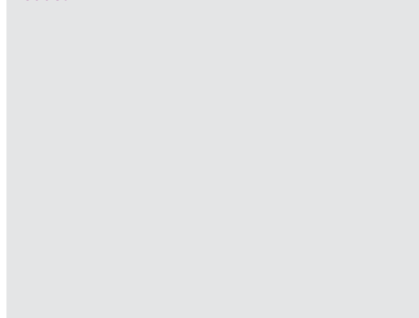
Dimension

	Dimension	Class-No.	Ident-No.
Clamping Bars	B=13	925300	177332
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	009672
Magnetic Stops	0,0 [mm]	997800	016613

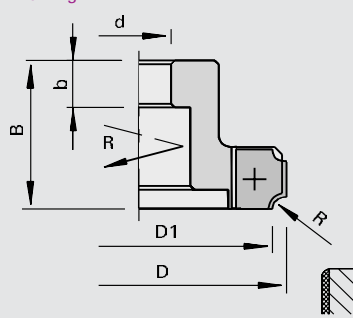
120115

Edge Rounding Cutterheads - 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

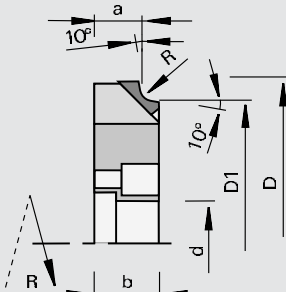
Notes

- 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				997800	016613
			[mm]					


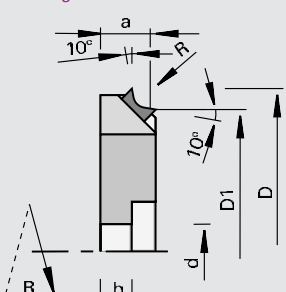
222512

Edge Rounding Cutters - Homag

Product	Drawing		LEUCO topline _{AS}		LEUCO DIAMAX		Polycrystalline Diamond [DP]		MEC	
										
Machine / Application	Design		Advantages		Notes					
<ul style="list-style-type: none"> edge banding machines Homag machining center for rounding of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle with shear angle n max = 24,000 min-1 		<ul style="list-style-type: none"> optimum cutting quality 		<ul style="list-style-type: none"> constant basic dimensions a and D1 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]					

222512

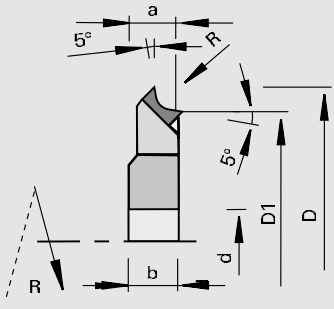

Edge Rounding Cutters - Homag, Brandt

Product	Drawing		LEUCO topline _{AS}		LEUCO DIAMAX		Polycrystalline Diamond [DP]		MEC	
										
Machine / Application	Design		Advantages		Notes					
<ul style="list-style-type: none"> edge banding machines Homag, Brandt for rounding of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle with shear angle n max = 24,000 min-1 		<ul style="list-style-type: none"> optimum cutting quality 		<ul style="list-style-type: none"> 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	12	16	4	5x2,3	177312	177311
3,0	69	61	9.1	12	16	4	5x2,3	177314	177313
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222512

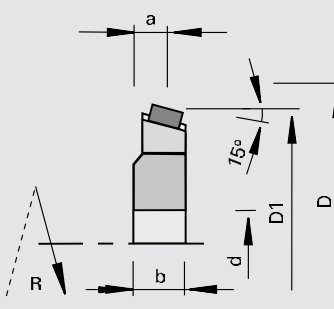

Edge Rounding Cutters - HOLZ-HER

Product	Drawing		
			
			
		Polycrystalline Diamond [DP]	
		MEC	
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines HOLZ-HER for rounding of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> with shear angle n max = 24,000 min-1 		<ul style="list-style-type: none"> 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	182144
3,0	57	50	8.5	12.5	16	2	5x2,3	182145	182146
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222512

Edge Chamfering Cutters - HOLZ-HER

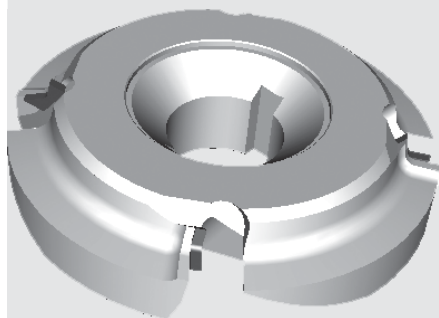
Product	Drawing		
			
			
		Polycrystalline Diamond [DP]	
		MEC	
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines HOLZ-HER for chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> with shear angle n max = 24,000 min-1 		<ul style="list-style-type: none"> 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]		

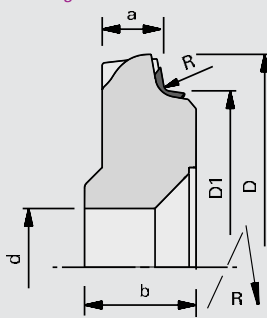
222312

Edge Rounding Cutters CM - HOLZ-HER

Product



Drawing

LEUCO
toplineLEUCO
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	182500
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]		

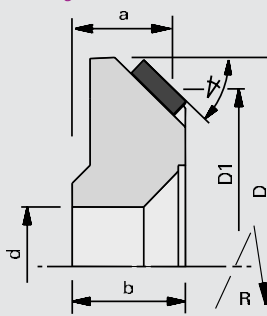
222312

Edge Chamfering Cutters CM - HOLZ-HER

Product



Drawing

LEUCO
toplineLEUCO
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]		

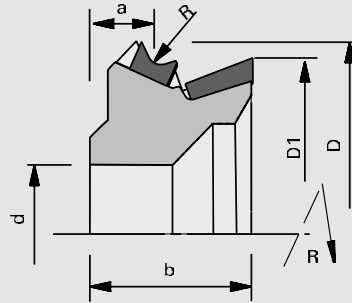
222312

Edge Rounding Flush-Cutting Cutters CM - HOLZ-HER

Product



Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

l edge banding machines
HOLZ-HER aggregate 1833
l for rounding and flush-cutting
of solid wood, veneer and
plastic edge bands

Design

l with shear angle
l polished face and high-finish
clearance angle
l resharpenable area 3.5 mm
l n max = 24.000 min-1

Advantages

l optimized chip removal thanks
to ChipMeister version
l less chips remain inside of the
machine
l no malfunctions due to chips
l reduced suction performance
l low noise level

Notes

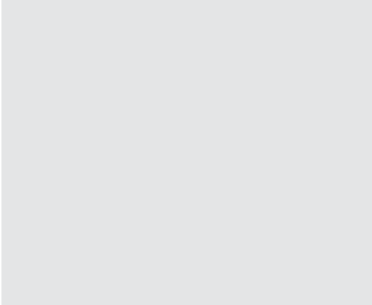
l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	57.3	50	10.76	23	20	2	5x2,2	182481	182480
2	57.3	50	11.02	23	20	2	5x2,2	182483	182482
2,5	57.3	50	11.15	23	20	2	5x2,2	182485	182484
3	57.3	50	11.28	23	20	2	5x2,2	182487	182486
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
2	57.3	50	11.02	23	20	3	5x2,2	182493 s	182492 s
2,5	57.3	50	11.15	23	20	3	5x2,2	182495 s	182494 s
3	57.3	50	11.28	23	20	3	5x2,2	182497 s	182496 s
5	57.3	50	11.80	23	20	3	5x2,2	182499 s	182498 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

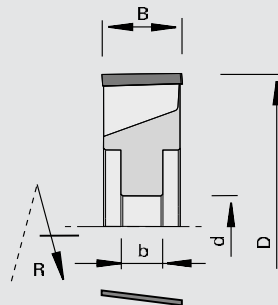
222210

Edge Jointing Cutters - SCM-Stefani

Product



Drawing



LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

l edge banding machines
SCM-Stefani with ED-System
l for jointing and flush-cutting of
solid wood, veneer and plastic
edge bands

Design

l with shear angle
l reduced resharpenable area
l n max = 23,800 min -1

Advantages

Notes

l sense of rotation according to
DIN-EN 50144

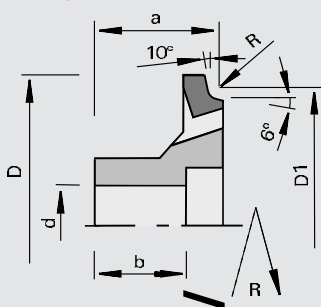
Ø D	B	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
80	20	11	16	4	5x2,3	182410	182409
[mm]	[mm]	[mm]	[mm]		[mm]		

122110

Edge Rounding Cutters - SCM-Stefani

Product

Drawing

LEUCO
DUR

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

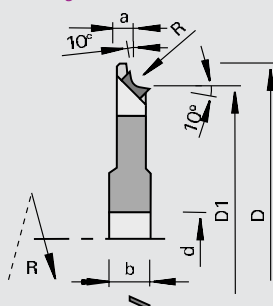
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	55,7	49,9	25,7	20	16	3	5x2,3	182446 s	182447 s
1,5	55,7	50,9	25,7	20	16	3	5x2,3	182448 s	182449 s
2,0	55,7	51,9	25,7	20	16	3	5x2,3	182450	182451
2,5	55,7	52,9	25,7	20	16	3	5x2,3	182452 s	182453 s
3,0	55,7	53,9	25,7	20	16	3	5x2,3	182454	182455
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222512

Edge Rounding Cutters - 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

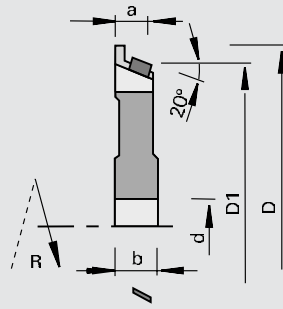
R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1,0	73	61,7	8,1	12	12	4	4x2,15	182288 s	182289 s
1,5	73	61,7	7,6	12	12	4	4x2,15	182290 s	182291 s
2,0	73	61,7	7,1	12	12	4	4x2,15	182292	182293
2,5	73	61,7	6,6	12	12	4	4x2,15	182294 s	182295 s
3,0	73	61,7	6,1	12	12	4	4x2,15	182296	182297
4,0	73	61,7	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

Edge Chamfering Cutters - SCM-Stefani

Product

Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

l edge banding machines
SCM-Stefani with ED-System
l for chamfering of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l n max = 20,000 min-1
l polished face and high-finish
clearance angle

Advantages

l optimized chip removal
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 sense of rotation according to
DIN-EN 50144

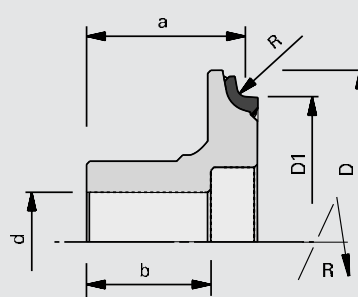
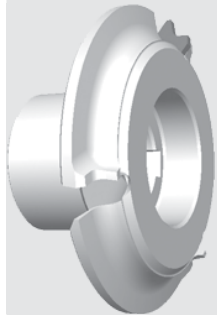
chamfer[°]	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
20	73	61,7	8.7	12	12	4	4x2,15	182302	182303
[°]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

222310

Edge Rounding Cutters - SCM-IDM

Product

Drawing



LEUCO
topline

LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

l edge banding machines
SCM-IDM with ED system and
aggregate Round/K
l for rounding of solid wood,
veneer and plastic edge bands

Design

l with shear angle
l n max = 20,000 min-1
l polished face and high-finish
clearance angle

Advantages

l optimized chip removal
l less chips remain inside of the
machine
l no malfunctions due to chips
l reduced suction performance
l low noise level

Notes

l constant basic dimensions a
and D1
l sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
1	54	49,93	25.7	20	16	3	5x2,3	182418 s	182417 s
1,5	54.5	50,93	25.7	20	16	3	5x2,3	182416 s	182415 s
2	55.3	51,93	25.7	20	16	3	5x2,3	182414 s	182413 s
2,5	55.7	52,93	25.7	20	16	3	5x2,3	182424 s	182423 s
3	55.7	52,93	25.7	20	16	3	5x2,3	182412 s	182411 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		

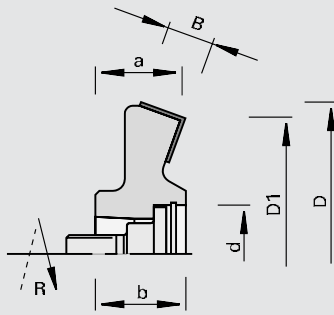
120120

Edge Chamfering Cutterheads 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 \sphericalangle	$\varnothing D$	$\varnothing D1$	a	B	b	$\varnothing d$	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

985730

166090

[mm]

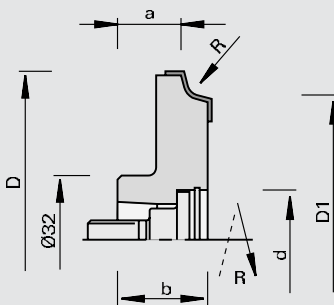
120102

Edge Rounding Cutterheads 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	151521	177606	177605
	2	12	17	2	151521	177608	177607
	2,5	12	17	2	151521	177610	177609
	3	12	17	2	151521	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 DIN EN ISO 4028	995161	001617
Cranked Wrench Keys	SW3 DIN ISO 2936	985730	009672
	[mm]		

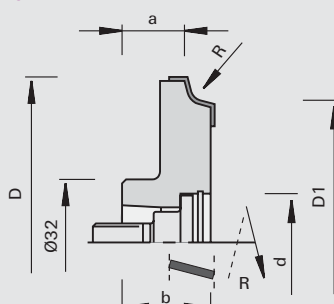
120112

Edge Rounding Cutterheads 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]		


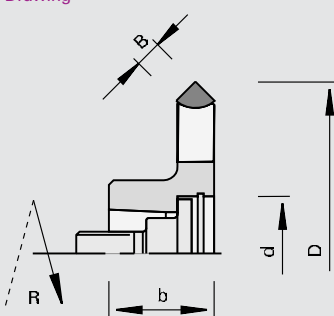
Knives	R	B	H	S	Class-No.	Ident-No. [L]	Ident-No. [R]
	2	12	18	2	151586	180174	180173
	3	12	18	2	151586	180176	180175
	[mm]	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	12x11x7	925300	180255
Clamping Bars	12x11x7	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 DIN EN ISO 4028	995161	001617
	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Cranked Wrench Keys	SW3 DIN ISO 2936 [mm]	985730	009672

222530

Edge Chamfering Cutters HSK 25R - Homag, IMA

Product	Drawing	LEUCO topline
		LEUCO DIA
		Polycrystalline Diamond [DP]
		MEC


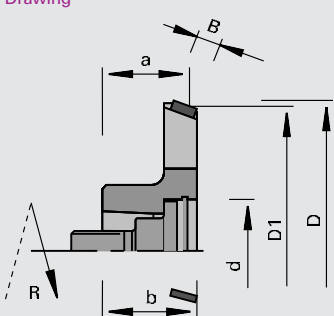
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag, IMA for chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle resharpenable n max = 24,000 min-1 	<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 	<ul style="list-style-type: none"> sense of rotation according to DIN-EN 50144

chamfer	Ø D	B	b	Ø 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

Edge Chamfering Cutters HSK 25R - Homag, IMA

Product	Drawing	LEUCO topline
		LEUCO DIAMAX
		Polycrystalline Diamond [DP]
		MEC

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag, IMA for flush-cutting and chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle with shear angle n max = 24,000 min-1 	<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 	<ul style="list-style-type: none"> constant basic dimensions a and D1 sense of rotation according to DIN-EN 50144

chamfer	Ø D1	Ø D	a	B	b	Ø 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	177650

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]		

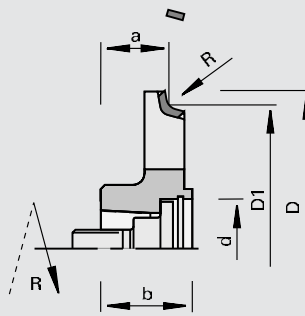
222512

Edge Rounding Cutters HSK 25R - Homag, IMA

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag, 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

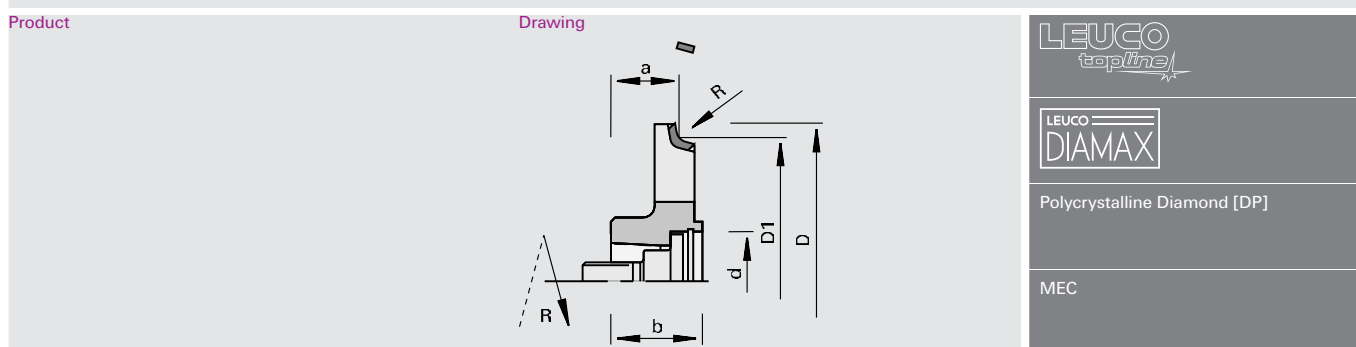
- constant basic dimensions a
and D1
- Z = 4 for feed rate 20 - 30
m/min
- sense of rotation according to
DIN-EN 50144

R	Ø D	Ø D1	a	b	Ø d	Z	nmax	Ident-No. [L]	Ident-No. [R]
1,0	75.1	70	16.5	23	HSK 25R	4	24000	177655 s	177656 s
1,5	76.1	70	16.5	23	HSK 25R	4	24000	177657 s	177658 s
2,0	77.5	70	16.5	23	HSK 25R	4	24000	177659	177660
2,5	78.1	70	16.5	23	HSK 25R	4	24000	177661 s	177662 s
3,0	78.8	70	16.5	23	HSK 25R	4	24000	177663	177664
3,5	80.0	70	16.5	23	HSK 25R	4	24000	177665 s	177666 s
4,0	81.2	70	16.5	23	HSK 25R	4	24000	177667 s	177668 s
4,5	82.3	70	16.5	23	HSK 25R	4	24000	177669 s	177670 s
5,0	83.3	70	16.5	23	HSK 25R	4	24000	177671 s	177672 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]		

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]		

2225 12

Edge Rounding Cutters HSK 25R - Homag, IMA



LEUCO topLine
LEUCO DIAMAX
Polycrystalline Diamond [DP]
MEC

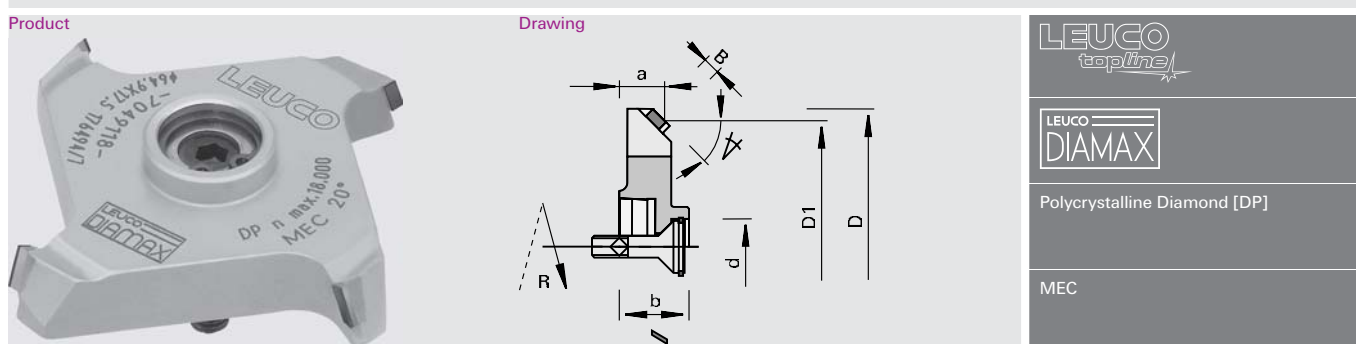
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag, IMA for rounding of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle with shear angle n max = 24,000 min-1 	<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 	<ul style="list-style-type: none"> constant basic dimensions a and D1 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	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]		

2225 12

Edge Chamfering Cutters HSK 32 - Homag



Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banding machines Homag / aggregate FK 01, FK 02, FK 03 for chamfering of solid wood, veneer and plastic edge bands 	<ul style="list-style-type: none"> polished face high-finish clearance angle with shear angle n max = 18,000 min-1 	<ul style="list-style-type: none"> optimum cutting quality thanks to high concentric accuracy and precise tool balancing 	<ul style="list-style-type: none"> constant basic dimensions a and D1 sense of rotation according to DIN-EN 50144

chamfer \sphericalangle	$\varnothing D$	$\varnothing D1$	a	B	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
5	62.8	62	11.5	6	17.5	HSK 32	4	177405 s	177404 s
30	66.3	62	11.5	6	17.5	HSK 32	4	177407 s	177406 s
45	73.6	62	11.5	6	17.5	HSK 32	4	177409 s	177408 s
20	64	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 [mm]	995121	173407

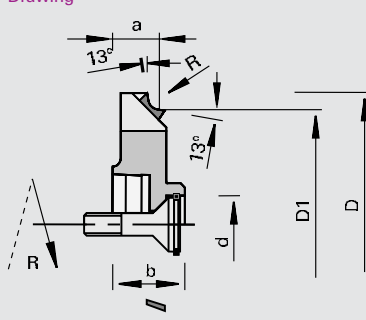
222512

Edge Rounding Cutters HSK 32 - Homag

Product



Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag / aggregate FK 01, FK 02, FK 03
- for 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	$\varnothing D$	$\varnothing D1$	a	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
0,8	70	62	11.5	17.5	HSK 32	4	179376 s	179377 s
1,0	69	62	11.5	17.5	HSK 32	4	179378 s	179379 s
1,5	69	62	11.5	17.5	HSK 32	4	179380 s	179381 s
2,0	69	62	11.5	17.5	HSK 32	4	179382	179383
2,5	69	62	11.5	17.5	HSK 32	4	179384 s	179385 s
3,0	69	62	11.5	17.5	HSK 32	4	179386	179387
3,5	72	62	11.5	17.5	HSK 32	4	179388 s	179389 s
4,0	72	62	11.5	17.5	HSK 32	4	179390 s	179391 s
4,5	72	62	11.5	17.5	HSK 32	4	179392 s	179393 s
5,0	72	62	11.5	17.5	HSK 32	4	179394 s	179395 s
0,8	70	62	11.5	17.5	HSK 32	6	178464 s	178465 s
1,0	69	62	11.5	17.5	HSK 32	6	178466 s	178467 s
1,5	69	62	11.5	17.5	HSK 32	6	178468 s	178469 s
2,0	69	62	11.5	17.5	HSK 32	6	178470 s	178471 s
2,5	69	62	11.5	17.5	HSK 32	6	178472 s	178473 s
3,0	69	62	11.5	17.5	HSK 32	6	178474 s	178475 s
3,5	72	62	11.5	17.5	HSK 32	6	178476 s	178477 s
4,0	72	62	11.5	17.5	HSK 32	6	178478 s	178479 s
4,5	72	62	11.5	17.5	HSK 32	6	178480 s	178481 s
5,0	72	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 [mm]	995121	173407

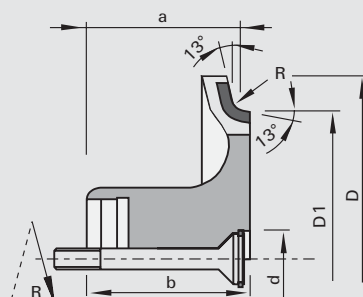
222812

Edge Rounding Cutters HSK 32 - Homag

Product



Drawing

LEUCO
toplineLEUCO
i-system

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines
Homag / FK-aggregates
- 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 s	180300 s
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
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	180287
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.

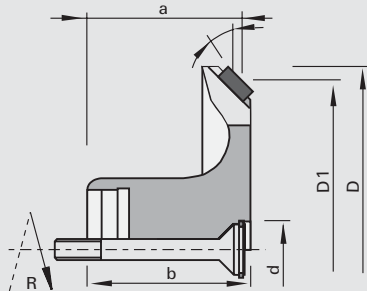
Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991 [mm]	995121	173407

222812

Edge Chamfering Cutters 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 [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	Ident-No. [L]	Ident-No. [R]
20	64.8	62	31.5	34	HSK 32	4	180288	180289
45	64.8	62	31.5	34	HSK 32	4	180319	180318
20	64.8	62	31.5	34	HSK 32	6	180290	180291
45	64.8	62	31.5	34	HSK 32	6	180321 s	180320 s

Spare parts

Dimension

Class-No.

Ident-No.

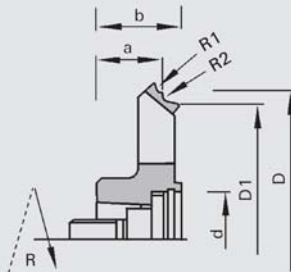
Locking Rings	14x1 DIN 472	995460	057258
Shim Rings	8x14x1 DIN 988	995440	173406
Countersunk Flat Headed Screws	M6x30 DIN 7991 [mm]	995121	173407

222512

Edge Rounding / Chamfering Cutters HSK 25R - Homag

Product

Drawing



LEUCO
topline

LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

- | edge banding machines Homag
- | 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 \sphericalangle	$\varnothing D$	$\varnothing D1$	a	b	$\varnothing d$	Z	Ident-No. [L]	Ident-No. [R]
3	2	20	85	69	22.75	28	HSK 25R	4	179076	179077
[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			995460	177782
						[mm]				

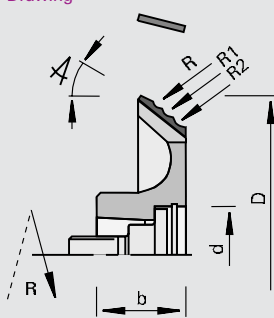
222812

Edge Rounding / Chamfering Cutters Multi HSK 25R - Homag

Product



Drawing

LEUCO
toplineLEUCO
i-system

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines Homag
- 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 feedrate 20 - 30 m/min
- Z = 6 for feedrate 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			995460	177782
						[mm]				

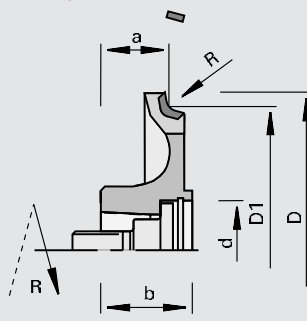
222812

Edge Rounding Cutters HSK 25R - Homag

Product



Drawing



LEUCO
topline

LEUCO
i-system

Polycrystalline Diamond [DP]

MEC

Machine / Application

- | edge banding machines Homag
- | 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 feedrate 20 - 30 m/min
- | Z = 6 for feedrate 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	84	70	17.5	23	HSK 25R	4	180542 s	180543 s
1,5	84	70	18.0	23	HSK 25R	4	180544	180545
2,0	84	70	18.5	23	HSK 25R	4	180546	180547
2,5	84	70	19.0	23	HSK 25R	4	180548 s	180549 s
3,0	84	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
1,0	84	70	17.5	23	HSK 25R	6	180560 s	180561 s
1,5	84	70	18.0	23	HSK 25R	6	180562	180563
2,0	84	70	18.5	23	HSK 25R	6	180564	180565
2,5	84	70	19.0	23	HSK 25R	6	180566 s	180567 s
3,0	84	70	19.5	23	HSK 25R	6	180568	180569
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.

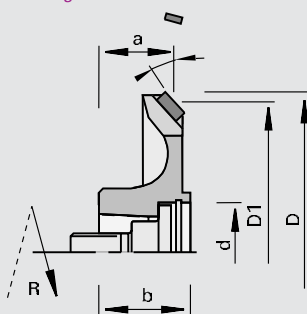
Screws	M10x1,25x32 SW8	995190	177780
Shim Rings	18x25x1,0 DIN 988	995440	177781
Locking Rings	25x1,2 DIN 472	995460	177782
	[mm]		

2228 12

Edge Chamfering Cutters HSK 25R - Homag

Product

Drawing

LEUCO
toplineLEUCO
i-system

Polycrystalline Diamond [DP]

MEC

Machine / Application

- | edge banding machines
- | Homag
- | 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 feedrate 20 - 30 m/min
- | Z = 6 for feedrate 30 - 45 m/min
- | machines must be equipped with i-system
- | sense of rotation according to DIN-EN 50144

chamfer \sphericalangle	$\varnothing D$	$\varnothing D1$	a	b	$\varnothing d$	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 #	180583 #
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]		

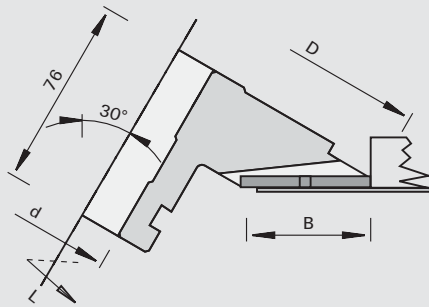
222022

Panel Raising Cutters 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]		

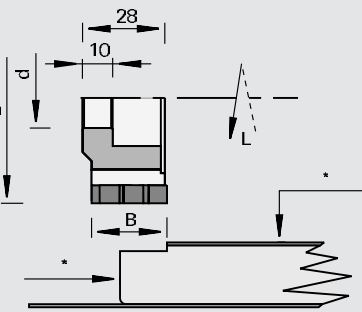
222020

Panel Raising Cutters 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]		

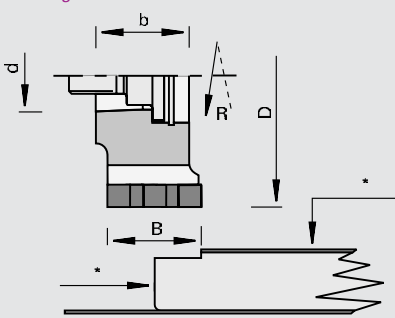
222020

Panel Raising Cutters HSK 25R Postforming - Homag

Product



Drawing



Polycrystalline Diamond [DP]
MEC

Machine / Application

postforming machines Homag for panel raising of melamine-, paper-, HPL-laminated and veneered panels during the direct postforming process

Design

resharpenable area 3.5 mm
inside edge Z = 9 resp. Z = 12
shear angle and extreme division of cutting pressure
n max = 24,000 min-1

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing
no need for extra scoring station

Notes

with inlay profiles
application with feed
* tracing with copy wheel
sense of rotation see drawing

Ø D	B	b	Ø d	Z	recommended feed	Ident-No. [L]	Ident-No. [R]
70	25	28	HSK 25R	9+3+3	25	179020	179019
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]		

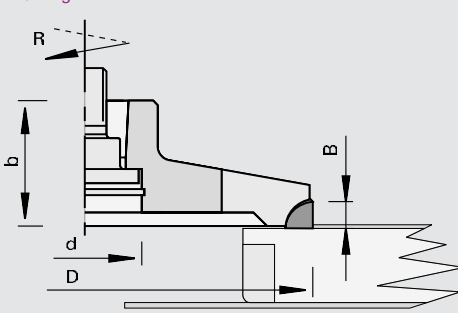
222020

Panel Raising Cutters HSK 25R Postforming - Homag

Product



Drawing



Polycrystalline Diamond [DP]
MEC

Machine / Application

postforming machines Homag for panel raising during the direct postforming process

Design

with shear angle
resharpenable area 3.5 mm
n max = 24,000 min-1

Advantages

optimum cutting quality thanks to high concentric accuracy and precise tool balancing

Notes

for panel raising of the U profile and flush-cutting of the L profile
application against feed
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
	[mm]		

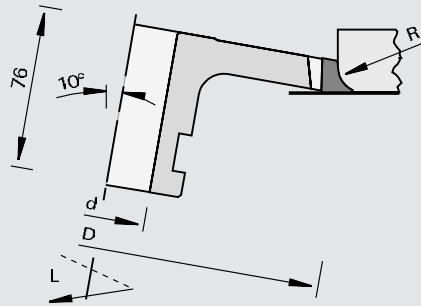
Spare parts	Dimension	Class-No.	Ident-No.
Locking Rings	25x1,2 DIN 472 [mm]	995460	177782

222060

Radius Panel Raising Cutters Postforming - Homag, IMA

Product

Drawing



Polycrystalline Diamond [DP]

MEC

Machine / Application

Design

Advantages

Notes

l postforming machines Homag, IMA
l for profiling and simultaneous panel raising during the direct postforming process

l n max = 10,000 min-1

l for use without inlay strip
l application against feed
l sense of rotation according to DIN-EN 50144

R	Ø D	b	Ø d	Z	DKN	Ident-No. [L]	Ident-No. [R]
3	180	76	35	4	10x4	172996 s	172997 s
4	180	76	35	4	10x4	172998 s	172999 s
5	180	76	35	4	10x4	173000 s	173001 s
6	180	76	35	4	10x4	173002 s	173003 s
6,5	180	76	35	4	10x4	173004 s	173005 s
7	180	76	35	4	10x4	173006 s	173007 s
7,5	180	76	35	4	10x4	173008 s	173009 s
8	180	76	35	4	10x4	173010 s	173011 s
9	180	76	35	4	10x4	173012 s	173013 s
9,5	180	76	35	4	10x4	173014 s	173015 s
10	180	76	35	4	10x4	173016 s	173017 s
11	180	76	35	4	10x4	173018 s	173019 s
12	180	76	35	4	10x4	173020 s	173021 s
12,5	180	76	35	4	10x4	173022 s	173023 s
14	180	76	35	4	10x4	173024 s	173025 s
[mm]	[mm]	[mm]	[mm]		[mm]		

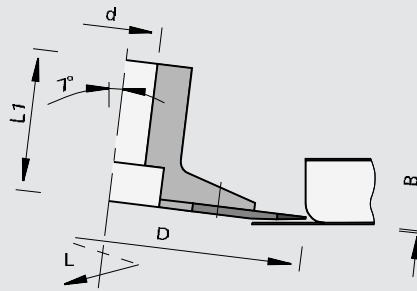
209080

Scribing Cutters 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
LEUCODIA inserts „B“ 1.2 mm with countersunk screws	232921	180834	180835 #
Countersunk Flat Headed Screws	995125		178722
Screwdrivers	985730		171188

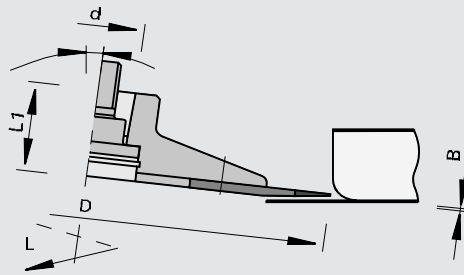
209080

Scribing Cutters HSK 25R Postforming - Homag

Product



Drawing



Polycrystalline Diamond [DP]

MEC

Machine / Application

l postforming machines Homag
l for scribing of the radii during the postforming process

Design

l cutting edges parallel to cutter axis
l tooth configuration: symmetrical design for all radii
l n max = 9,000 min-1

Advantages

l optimum cutting quality thanks to high concentric and runout accuracy and precise tool balancing

Notes

l for use without inlay strip
l application against feed
l LEUCODIA cutter inserts to be installed only in sets (packing unit 4 pieces)
l B=0.5 mm not recommended for butted-up workpieces; in this case B=1.2 mm should be used instead
l sense of rotation see drawing

Ø D	B	Ø d	L1	Z	DKN	Ident-No. [L]	Ident-No. [R]
125	0,5	HSK 25R	26	4		180075&	180076&
125	0,8	HSK 25R	26	4	6x3	180957&	180958&
125	1,2	HSK 25R	26	4		180832&	180833&
[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
LEUCODIA inserts „B“ 1.2 mm with countersunk screws	232921	180834	180835 #
Screws	995190		177780
Shim Rings	995440		177781
Locking Rings	995460		177782
Countersunk Flat Headed Screws	995125		178722
Screwdrivers	985730		171188

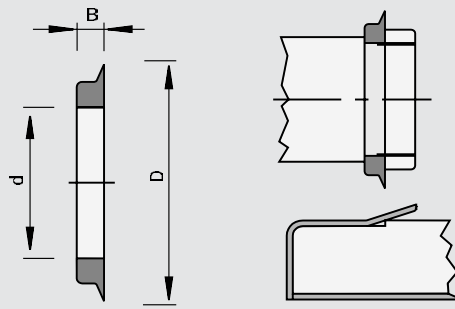
164507

Circular Knives for edge trimming Softforming - Homag

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

l machines Homag
l for cutting of softforming inlay profiles

Design

l LEUCODUR solid carbide
circular knife

Advantages

Notes

$\varnothing D$	B	$\varnothing d$	Ident-No.
40	3	25	172757
[mm]	[mm]	[mm]	

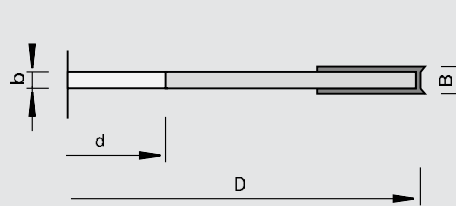
120455

Grooving Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free grooving in solid woods and in wood-based panels

Design

l Ø 125 mm: n = 6,100 - 10,500 min-1
l Ø 150 mm: n = 5,200 - 8,800 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	8	8	30	50	4+8	171159
125	10	10	30	50	4+8	171160
150	8	8	30	50	4+8	171161
150	10	10	30	50	4+8	171162
[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives

	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	7,6	12	1.5	150515	052543
Turnover Knives	9,6	12	1.5	150515	171163
	[mm]	[mm]	[mm]		

Spare parts

	Dimension	for Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=7,2	171159, 171161	925300	168074
Clamping Bars	B=8	171160, 171162	925300	167255
Countersunk Flat Headed Screws	M5x6 T20		995125	176199
Screwdrivers	SW2,5x100		985730	168010
Screwdrivers	T20x100		985730	166092
Adjusting Gauges	0,3		985200	055883
	[mm]			

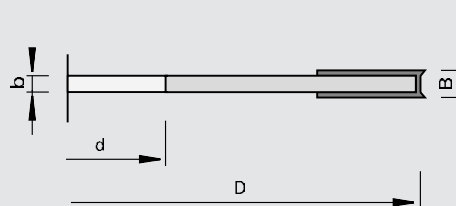
120455

Grooving Cutterheads

Product



Drawing



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]						

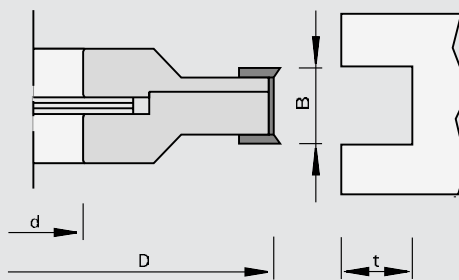
121455

Grooving Cutterheads

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
160	4 - 7,5	30	37	8+4		198425 s
160	4 - 7,5	30		2		198426 s
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
180	4 - 7,5	50	30	8+4		168087
180	4 - 15	30	35	8+2+4		168080
180	4 - 15	35	35	8+2+4	10x4	168082
180	4 - 15	40	35	8+2+4	12x5	168084
[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, 198426		925300	168074
Set Screws	M5x12 DIN EN ISO 4028	168080, 168082, 168084, 198425, 198426		995161	050565
Counter Wedges	B=6,8	166509, 168081, 168083, 168085, 168087, 198425, 198426		925200	010751 #
Countersunk Flat Headed Screws	M4x0,5x3,2 T9	166509, 168081, 168083, 168085, 168087, 198425		995125	163925
Special Nuts	M4x0,5x1,6	166509, 168081, 168083, 168085, 168087, 198425		995290	163704
Special Nuts	M4x0,5x2,2	166509, 168081, 168083, 168085, 168087, 198425, 198426		995290	163703
Spacer Sets	50x3,5x30	166509		955521	166367
Spacer Sets	66x3,5x30	168080, 168081, 198425, 198426		955521	168075
Spacer Sets	70x3,5x35	168082, 168083		955521	168076
Spacer Sets	70x3,5x40	168084, 168085		955521	168077
Spacer Sets	90x3,5x50	168087		955521	168078
Screwdrivers	SW2,5x100			985730	168010
Screwdrivers	T9			985730	164344
Screwdrivers		198425		985730	013951
	[mm]				

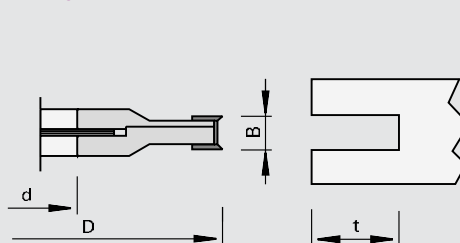
121455

Grooving Cutterheads

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


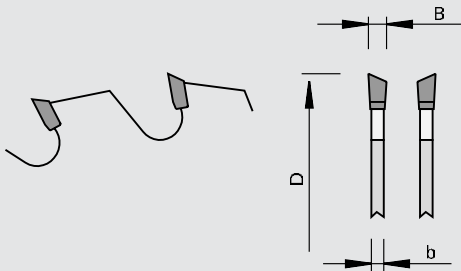

Ø D	B	Ø d	Tmax	Z	DKN	Ident-No.
180	8,0 - 15	30	35	4+4		178725
180	8,0 - 15	35	35	4+4	10x4	178726 #
180	8,0 - 15	40	35	4+4	12x5	178727
180	12,6 - 24	30	40	4+4		178729
180	12,6 - 24	35	40	4+4	10x4	178730 #
180	12,6 - 24	40	40	4+4	12x5	178731
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
Spurs	14	14	2	150559	003079
Turnover Knives	7,6	12	1.5	150515	052543
Turnover Knives	12	12	1.5	150515	003080
	[mm]	[mm]	[mm]		

Spare parts	Dimension	for Ident-No.	Class-No.	Ident-No.
Clamping Bars	B=7,2	178725, 178726, 178727	925300	168074
Clamping Bars	B=10	178729, 178730, 178731	925300	164526
Countersunk Flat Headed Screws	M6x0,5x4,9 T20		995125	178222
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	66x7x30	178725	955521	167282
Spacer Sets	70x7x35	178726	955521	167283
Spacer Sets	70x7x40	178727	955521	167284
Spacer Sets	66x11,5x30	178729	955521	167278
Spacer Sets	70x11,5x35	178730	955521	167279
Spacer Sets	70x11,5x40	178731	955521	167280
Screwdrivers	SW2,5x100	178725, 178726, 178727	985730	168010
Screwdrivers	SW3x100	178729, 178730, 178731	985730	166090
Screwdrivers	T20x100		985730	166092
Adjusting Gauges	0,3		985200	055883
	[mm]			

109085

Lamello Grooving Cutters

Product	Drawing							
								
								
		Tungsten Carbide [HW]						
		MAN						
Machine / Application	Design	Advantages	Notes					
<ul style="list-style-type: none"> l machines Lamello, ELU l for chip-free grooving of Lamello wood joints in solid woods and in wood-based panels 			<ul style="list-style-type: none"> l application against feed with and across the grain 					
Ø D	B	b	Ø d	Z	NL	nmin-nmax		Ident-No.
100	3,95	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]		

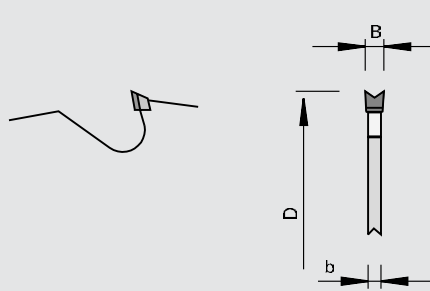
209285

Lamello Grooving Cutters

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

l reduced resharpenable area
l tooth configuration: concave
l $n = 7,000 - 13,300 \text{ min}^{-1}$

Advantages

Notes

l application against feed with and across the grain
l can be used on CNC machines as a grooving cutter

$\emptyset D$	B	b	$\emptyset d$	Z	Ident-No.
100 [mm]	3,95 [mm]	4 [mm]	22 [mm]	4	178496

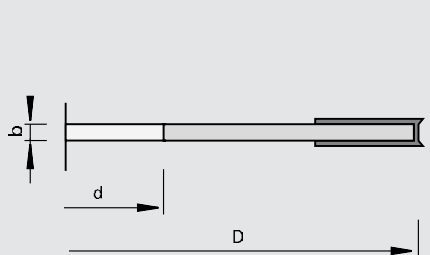
120455

Lamello Grooving Cutterheads

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 $n = 6,500 - 11,000 \text{ min}^{-1}$

Advantages

Notes

l application against feed with and across the grain

$\emptyset D$	B	b	$\emptyset d$	Z	NL	Ident-No.
100 [mm]	4 [mm]	4 [mm]	22 [mm]	4+4	4/4,5/36	164838

Turnover Knives

B	H	S
14	14	1.2
18	18	1.95
[mm]	[mm]	[mm]

Class-No. Ident-No.

Spurs	150559	163701
Turnover Knives	150508	163699

Spare parts

Dimension

Class-No. Ident-No.

Countersunk Flat Headed Screws	M4x0,5x3,2 T9	995125	163925
Special Nuts	M4x0,5x2,2	995290	163703
Screwdrivers	T9	985730	164344
	[mm]		

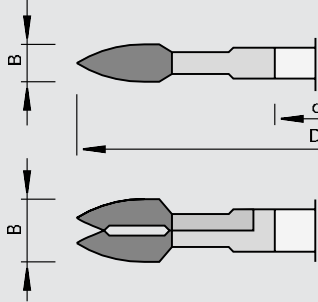
122415

Cutters for removing resin pockets

Product



Drawing



Machine / Application

| Mini-Spot machines
 | edge banding machines IMA
 model BIMA with glueing
 device / flush cutting unit
 6135
 | for cutting out defects in solid
 woods

Design

| with alternating shear angle
 | n max = 12,000 min-1

Advantages

Notes

| for patch sizes 1-4

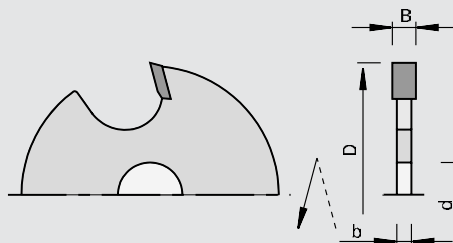
Ø D	B	Ø d	Z	NL	Ident-No.
100	8	22	4	4/4,3/36	180469
100	14	22	4		70176331 o
100	15	22	4		70176420 o
[mm]	[mm]	[mm]			

109015

Grooving Cutters, HW-tipped

Product

Drawing



Machine / Application

| portable routers
 | for grooving in solid woods and
 wood-based panels

Design

| two brazed flat-tooth cutting
 edges
 | n max = 18,000 min-1

Advantages

Notes

| 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

Arbors

8x8
[mm]

Class-No.

997200

Ident-No.

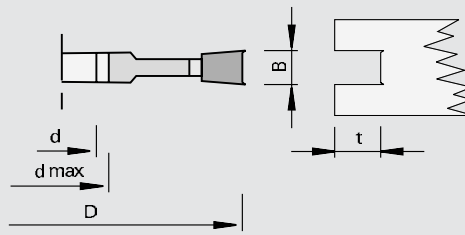
160363

322455

Grooving Cutters with spur

Product

Drawing



High Speed Steel [HS]

MAN

Machine / Application

- stationary milling centers
- table shapers against feed
- for chip-free grooving in solid woods and in wood-based panels

Design

- $n = 5,400 - 9,000 \text{ min}^{-1}$

Advantages

Notes

- application with and across the grain
- cutting width = hub width

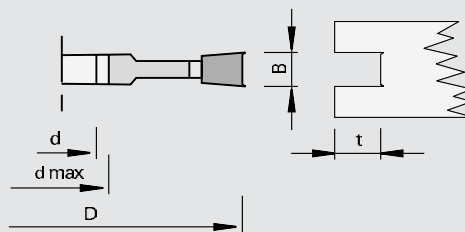
$\emptyset D$	B	$\emptyset d$	$\emptyset d_{\text{max}}$	Tmax	Z	Ident-No.
140	8	30	50	33	4+4	198038 s
140	10	30	50	33	4+4	198039 s
[mm]	[mm]	[mm]	[mm]	[mm]		

122455

Grooving Cutters with spur

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

- stationary milling centers
- table shapers against feed
- for chip-free grooving in solid woods and in wood-based panels

Design

- $n = 5,400 - 9,000 \text{ min}^{-1}$

Advantages

Notes

- application with and across the grain
- cutting width = hub width

$\emptyset D$	B	$\emptyset d$	$\emptyset d_{\text{max}}$	Tmax	Z	Ident-No.
140	4	30	50	33	4+4	198032 s
140	5	30	50	33	4+4	198033 s
140	6	30	50	33	4+4	198034 s
140	8	30	50	33	4+4	198035 s
140	10	30	50	33	4+4	198036 s
[mm]	[mm]	[mm]	[mm]	[mm]		

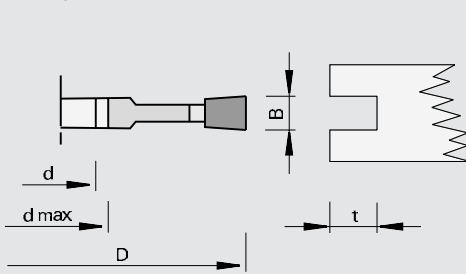
122405

Grooving Cutters

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

l molders
l double end tenoners
l for chip-free grooving in solid woods and in wood-based panels

Design

l n max = 10,000 min-1

Advantages

Notes

l cutting width = hub width

Ø D	B	Ø d	Ø dmax	Tmax	Z	Ident-No.
140	8	30	50	33	6	198051 s
140	10	30	50	33	6	198052 s
[mm]	[mm]	[mm]	[mm]	[mm]		

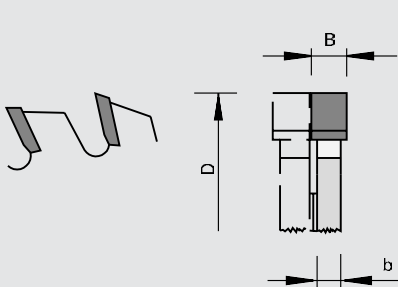
109015

Grooving Cutters

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

l application against feed with the grain (solid wood)
l application with feed only with MEC (wood-based panels)
l for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
l groove width calculation for tool sets: sum of all „b“ + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	1,5	0.8	30	12	6100-10500	188359
125	1,8	1.0	30	12	6100-10500	188360
125	2,0	1.2	30	12	6100-10500	188361
125	2,2	1.2	30	12	6100-10500	188362
125	2,5	1.4	30	12	6100-10500	188363
125	3,0	2.0	30	12	6100-10500	188364
[mm]	[mm]	[mm]	[mm]		[min-1]	

Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No.
125	3,5	2.5	30	12	6100-10500	188365
125	4,0	2.5	30	12	6100-10500	188366
125	4,5	3.0	30	12	6100-10500	188367
125	5,0	4.0	30	12	6100-10500	188368
125	6,0	4.0	30	12	6100-10500	188369
125	7,0	5.0	30	12	6100-10500	188370
125	8,0	5.0	30	12	6100-10500	188371
125	10	6.0	30	12	6100-10500	188372
150	1,5	0.8	30	12	5200-8800	188373
150	2,0	1.2	30	12	5200-8800	188375
150	2,2	1.2	30	12	5200-8800	188376
150	2,5	1.5	30	12	5200-8800	188377
150	3,0	2.0	30	12	5200-8800	188378
150	3,5	2.5	30	12	5200-8800	188379
150	4,0	3.0	30	12	5200-8800	188380
150	4,5	3.5	30	12	5200-8800	188381
150	5,0	4.0	30	12	5200-8800	188382
150	6,0	4.0	30	12	5200-8800	188383
150	7,0	5.0	30	12	5200-8800	188384
150	8,0	5.0	30	12	5200-8800	188385
150	9,0	6.0	30	12	5200-8800	188386
150	10	6.0	30	12	5200-8800	188387
[mm]	[mm]	[mm]	[mm]		[min-1]	

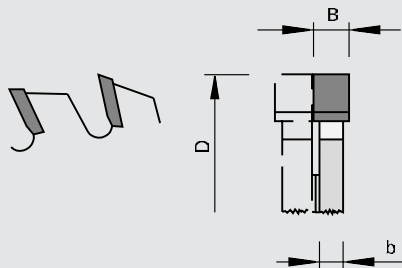
109010

Grooving Cutters

Product



Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- l molders
- l double end tenoners
- l for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

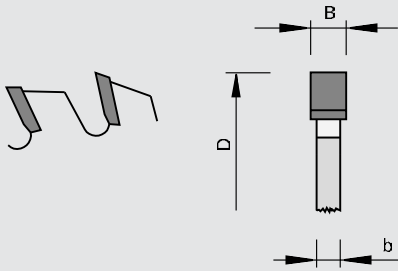

- l for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
- l groove width calculation for tool sets: sum of all „b“ + HW overlap left and right + shim thickness

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
150	4,0	3.0	30	12		12700	160802
150	5,0	4.0	30	12		12700	001434
150	5,0	4.0	35	12	10x4	12700	001435
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	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
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
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		10300	169685
180	5,0	4.0	30	18		10300	169684
180	8,0	5.0	30	18		10300	169683
180	10	6.0	30	18		10300	169682
196	6,0	5.0	30	12 WS		9600	163836
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

109010

Grooving Cutters

Product	Drawing		
			
		Tungsten Carbide [HW]	
		MEC	

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> CNC machining centers for chip-free grooving in solid woods and in wood-based panels 	<ul style="list-style-type: none"> positive hook angle without shear angle pin holes with countersink tooth configuration: flat „F“ cutting material: HW HL Board 06 		

Ø D	B	b	Ø d	Z	NL		Ident-No.
100	5	3.0	30	20		Weeke	189260
120	4	3.0	35	30	4/6/50	Biesse	189262
125	3,2	2.2	30	36	4/6,1/48 + 4/6,1/48	Weeke	189306
[mm]	[mm]	[mm]	[mm]				

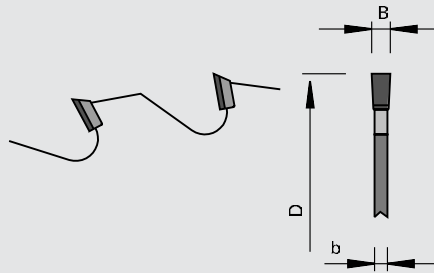
209010

Grooving Cutters

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

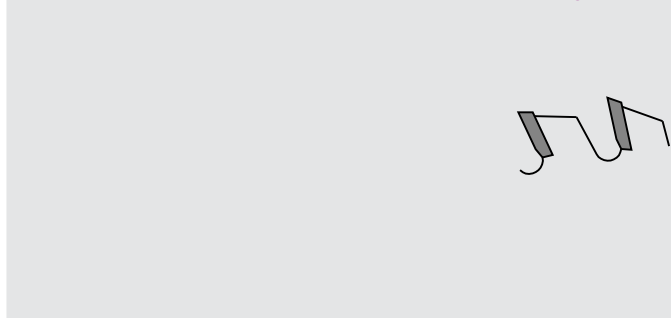
- application with feed
- number of teeth depends on the feed rate, the material to be cut and the desired cutting quality

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]	

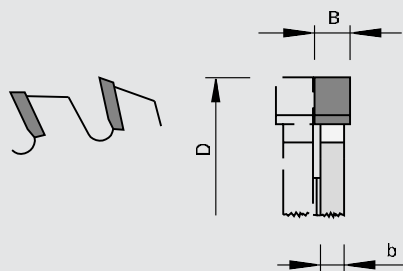
109010

Grooving Cutters

Product



Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- double end tenoners
- for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

- cutting width 4 - 6.5 mm possible with body thickness of 3.0 mm
- cutting width 7 - 10 mm possible with body thickness of 5.0 mm
- rework possible: enlarge bore, produce pin holes and keyways, chose cutting width and tooth geometry

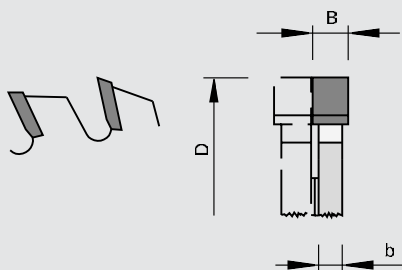
$\varnothing D$	B	b	$\varnothing d$	Z	Ident-No.
220	4,0	3.0	30	30	1521934 o
220	4,5	3.0	30	30	1521935 o
220	5,0	3.0	30	30	1521936 o
220	5,5	3.0	30	30	1521937 o
220	6,0	3.0	30	30	1521938 o
220	6,5	3.0	30	30	1521939 o
220	7,0	5.0	30	30	1521941 o
220	7,5	5.0	30	30	1521942 o
220	8,0	5.0	30	30	1521943 o
220	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]		

109010

Grooving Cutters

Product

Drawing

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

| double end tenoners
 | for chip-free grooving in solid woods and in wood-based panels

Design

Advantages

Notes

| cutting width 4 - 6.5 mm possible with body thickness of 2.8 mm
 | cutting width 7 - 10 mm possible with body thickness of 5.0 mm
 | rework possible: enlarge bore, produce pin holes and keyways, chose cutting width and tooth geometry

$\varnothing D$	B	b	$\varnothing d$	Z	Ident-No.
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
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
[mm]	[mm]	[mm]	[mm]		

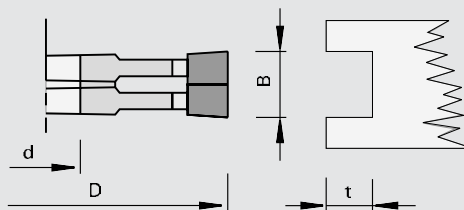
123455

Grooving Cutters

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
150	4,0 - 7,5	30	37	4+4		5200-9000	006190
150	7,5 - 14,5	30	37	4+4		5200-9000	006191
250	5,2 - 10	30	40	8+8		3000-5500	006192 #
150	4,0 - 7,5	35	30	4+4	10X4	5200-9000	006195
200	5,2 - 10	30	40	8+8		3800-7200	160018 #
140	2,2 - 4,0	30	20	4+4		5400-9000	171136
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

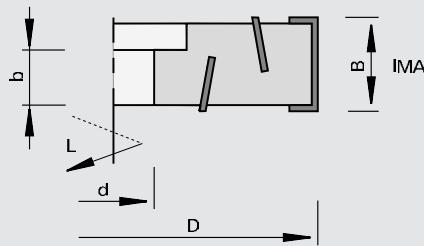
1202 10

Joining Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | double end tenoners
- | edge banding machines
- | for chip-free joining of plastic-laminated panels

Design

- | opposing shear angle
- | cutting material: HW HL Board 05

Advantages

Notes

- | sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No.
100	34	35	30	2x3	8x3	15000	R 171971
100	56	40.5	30	2x3	8x3	15000 IMA	L 173594
100	56	40.5	30	2x3	8x3	15000 IMA	R 173593
100	56	56	30	2x3	8x3	15000 Brandt	R 173636
150	35	35	30	2x3	8x3	10000	R 171191
180	56	25	35	2x3	10x4	8000	R 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	171191, 171971	925300	167971
Clamping Bars	B=30	173593, 173594, 173636	925300	164185
Pressure Jaws	28x11x6	177002	925300	180344
Clamping Parts	12x8,5/M6L	177002	925100	180356
Set Screws	M8x12 DIN EN ISO 4028	171191, 171971	995161	180001
Set Screws	M6x12 DIN EN ISO 4028	173593, 173594, 173636	995161	180214
Clamping Setscrews	M6/M6Lx18	177002	995161	180338
Screwdrivers	SW3x100	173593, 173594, 173636	985730	166090
Screwdrivers	SW4x100	171191, 171971	985730	166091
Screwdrivers	T15x80	177002	985730	171188
Magnetic Stops	1,0	173593, 173594, 173636	997800	166094
	[mm]			

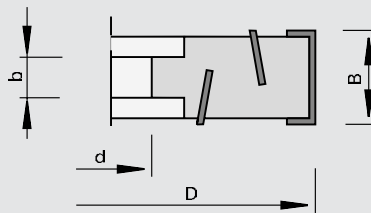
120215

Jointing Cutterheads

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


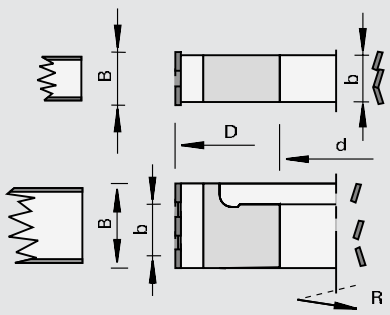

Ø D	B	b	Ø d	Z	DKN	nmin-nmax	Ident-No.
100	34	35	30	2x3	8x3	7700-13400	171972
125	56	56	30	2x3	8x3	6500-10000	177004
150	56	56	30	2x3	8x3	5200-8900	177006
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

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	177004, 177006	925300	180344
Clamping Parts	12x8,5/M6L	177004, 177006	925100	180356
Set Screws	M8x12 DIN EN ISO 4028	171972	995161	180001
Clamping Setscrews	M6/M6Lx18	177004, 177006	995161	180338
Screwdrivers	SW4x100	171972	985730	166091
Screwdrivers	T15x80	177004, 177006	985730	171188
	[mm]			

222220

Joining Cutters


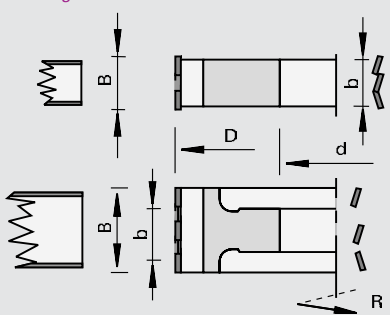

Product 	Drawing 	 Polycrystalline Diamond [DP] MEC
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Machine / Application through feed machines for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels	Design spiral cutting layout resharpenable area 1.5 mm	Advantages optimum glueing of edges	Notes sense of rotation according to DIN-EN 50144
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Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
100	34	37.6	30	3+3	8x3	18000	IMA, Brandt	18 1153	18 1152
100	48	40.6	30	3+3	8x3	18000	IMA, Brandt, SCM-IDM	18 1154	18 1155
85	45	45	30	3+3	8x3	22200	Ott	18 1166	18 1165
100	48	25	30	2+2	8x3	18000	HOLZ-HER, SCM	18 1516	18 1517
100	63	25	30	2+2	8x3	18000	HOLZ-HER, SCM	18 1518	18 1519
100	63	40.6	30	3+3	8x3	18000	Brandt	18 2175	18 2176
100	63	40.6	30	3+3	8x3	18000	SCM	18 2393	18 2392
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

222220

Joining Cutters - Homag

Product 	Drawing 	 Polycrystalline Diamond [DP] MEC
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Machine / Application through feed machines for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels	Design crowned design symmetrical design applicable left and right opposing shear angle spiral cutting layout resharpenable area 1.5 mm	Advantages optimum glueing of edges	Notes sense of rotation according to DIN-EN 50144
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Ø D	B	b	Ø d	Z	DKN	nmax		Ident-No. [L]	Ident-No. [R]
125	34	37.6	30	3+3	8x3	15000	Homag	18 0714	18 0714
125	43	40	30	3+3	8x3	15000	Homag	18 1175	18 1175
125	63	40	30	3+3	8x3	15000	Homag	18 1241	18 1241
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]			

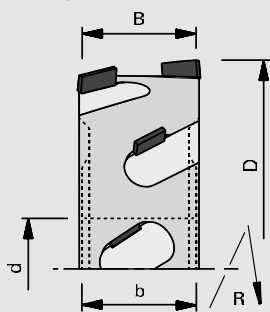
222020

Jointing Cutters CM

Product



Drawing



LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

- edge banding machines Homag, IMA, ...
- for chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- non-mirror image and non-convex design
- narrow division of cut
- offset asymmetrically
- shear angle 35°
- polished face
- resharpenable area 4 mm

Advantages

- excellent results also in sensitive materials
- 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	nmax	Ident-No. [L]	Ident-No. [R]
100	28	31.6	30	3+3	8x3	18000	182585 s	182586 s
100	34	37.6	30	3+3	8x3	18000	182587 s	182588 s
100	46	40	30	3+3	8x3	18000	182589 s	182590 s
100	63	40.6	30	3+3	8x3	18000	182591 s	182592 s
125	28	31.6	30	3+3	8x3	15000	182575 s	182576 s
125	34	34	30	3+3	8x3	15000	182577 s	182578 s
125	46	40	30	3+3	8x3	15000	182579 s	182580 s
125	63	40	30	3+3	8x3	15000	182581 s	182582 s
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

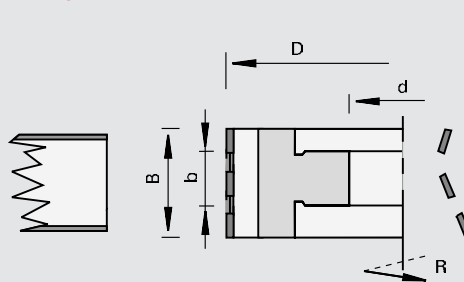
222220

Jointing Cutters CM - HOLZ-HER

Product



Drawing



LEUCO
DIAMAX

Polycrystalline Diamond [DP]

MEC

Machine / Application

- through feed machines HOLZ-HER
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated 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

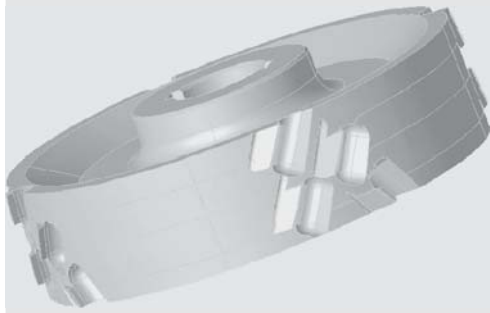
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	DKN	nmax	Ident-No. [L]	Ident-No. [R]
100	53	25	30	2+2	8x2,3	18000	HOLZ-HER	182173
70	54	31	30	1	8x3,3	18000	HOLZ-HER aggregate 1801	182513
70	54	31	30	2	8x3,3	18000	HOLZ-HER aggregate 1801	182515
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]		

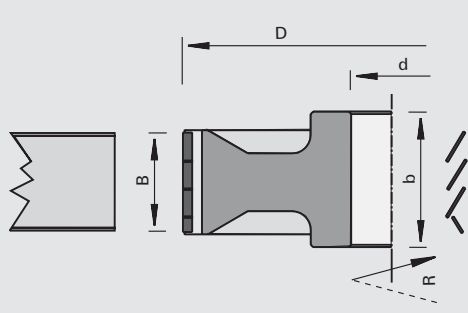
222220

Joining Cutters CM - Homag

Product



Drawing



LEUCO
DIAMAX

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]		

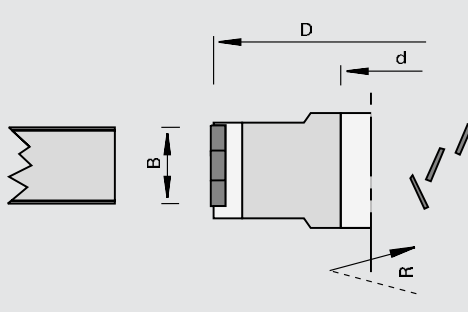
222020

Joining Cutters one-part version

Product



Drawing



LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

l double end tenoners
l edge banding machines
l for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels

Design

l resharpenable area 3.5 mm
l opposing shear angle
l n max = 10,000 min-1

Advantages

Notes

l the specified feed rates are based on n = 6.000 min-1
l sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	DKN	recommended feed	Ident-No. [L]	Ident-No. [R]
180	25	35	4+4	10x4	20	179013 s	179014 s
180	25	35	6+6	10x4	30	179015 s	179016 s
180	35	35	4+4	10x4	20	179017 s	179018 s
[mm]	[mm]	[mm]		[mm]	[m/min]		

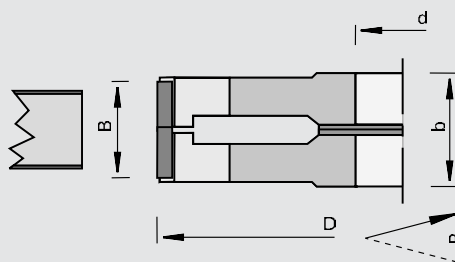
223020

Jointing Cutters

Product



Drawing



LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

- double end tenoners
- edge banding machines
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated 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

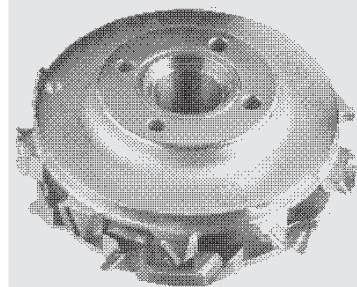
- the specified feed rates are based on Ø = 150 mm: n = 9,000 min-1 / Ø = 200 mm: n = 6,000 min-1
- sense of rotation according to DIN-EN 50144

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]	

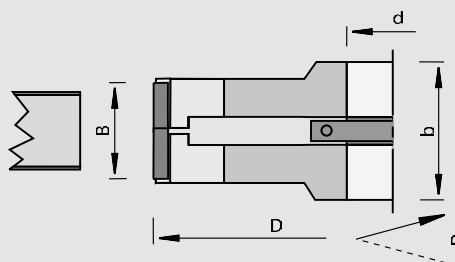
223020

Jointing Cutters progressively adjustable

Product



Drawing



LEUCO
DIA

Polycrystalline Diamond [DP]

MEC

Machine / Application

- double end tenoners with precision spindle (hexagon adapter)
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated 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.
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]	

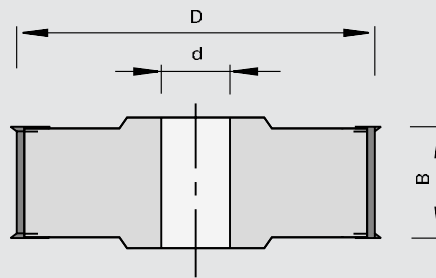
120265

Joining / Rabbeting Cutterheads

Product



Drawing



Tungsten Carbide [HW]
MAN

Machine / Application

l table shapers
l for rabbeting and joining in solid woods and wood-based panels

Design

l with opposing shear angle
l cutting material: HW HL Board 05
l aluminum body

Advantages

l high-quality cutting edges

Notes

l application against feed
l maximum rabbet depth 30 mm

Ø D	B	Ø d	Tmax	Z	nmin-nmax	Ident-No.
125	44	30	30	2+2	6 100-10500	179181
[mm]	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	Ident-No.
Knives	49,6	11.8	1.5	15 1567	179330
Spurs	14	14	2	150559	003079
	[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	6x11x48	925300	180632
Clamping Parts	12x8,5/M8L	925100	180357
Clamping Setscrews	M8x26 SW4	995161	180340
Countersunk Flat Headed Screws for spur	M5x10,8 T15	995125	180840
Screwdrivers	SW4x100	985730	166091
Screwdrivers	T15x80	985730	171188
	[mm]		

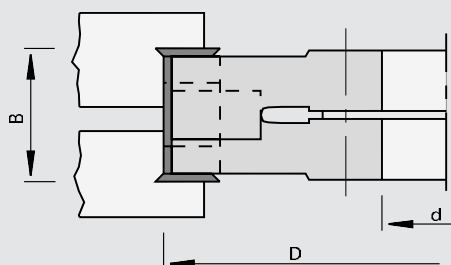
121255

Rabbeting / Grooving Cutterheads

Product



Drawing



Tungsten Carbide [HW]
MAN

Machine / Application

l table shapers
l for rabbeting and grooving in solid woods and wood-based panels

Design

l cutting edges parallel to cutter axis
l cutting material: HW HL Board 05

Advantages

Notes

l application against feed
l rabbeting depth to 43 mm possible
l cutting width adjustable with shims in 0.1 mm increments

Ø D	B	Ø d	Tmax	Z	nmin-nmax	Ident-No.		
160	26,4 - 40	30	43	4+4	4800-8200	168005		
160	36,4 - 60	30	43	4+4	4800-8200	168007		
[mm]	[mm]	[mm]	[mm]		[min-1]			
Turnover Knives				B	H	S	Class-No.	Ident-No.
Spurs				14	14	2	150559	003079
Turnover Knives				20	12	1.5	150515	003082
Turnover Knives				30	12	1.5	150515	003083
				[mm]	[mm]	[mm]		
Spare parts		Dimension		for Ident-No.		Class-No.	Ident-No.	
Clamping Bars		B=17		168005		925300	167971	
Clamping Bars		B=26,6		168007		925300	167885	
Adjusting Gauges		1,0				985200	011103 o	
Countersunk Flat Headed Screws		M5x10,8 T15				995125	180840	
Set Screws		M8x20 DIN EN ISO 4028				995161	001625	
Screwdrivers		T15x100				985730	180470	
Screwdrivers		SW4x100				985730	166091	
		[mm]						

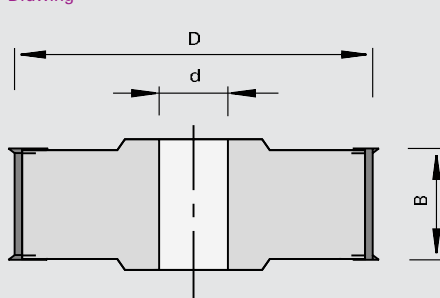
120265

Jointing and Rabbeting Cutterheads

Product



Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for chip-free jointing and rabbeting in solid woods and wood-based panels

Design

l with face shear angles from above and below
l cutting material: HW HL Board 05
l body made from high-quality light-metal alloy

Advantages

l optimum cutting quality

Notes

l application against feed

Ø D	B	Ø d	Z	nmin-nmax	Ident-No.			
140	60	30	4+4	5400-9400	179180			
[mm]	[mm]	[mm]		[min-1]				
Turnover Knives				B	H	S	Class-No.	Ident-No.
Spurs				14	14	2	150559	003079
Turnover Knives				50	12	1.5	150515	003085
				[mm]	[mm]	[mm]		
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			
Countersunk Flat Headed Screws for spur		M5x10,8 T15		995125	180840			
Screwdrivers		SW4x100		985730	166091			
Screwdrivers		T15x80		985730	171188			
		[mm]						

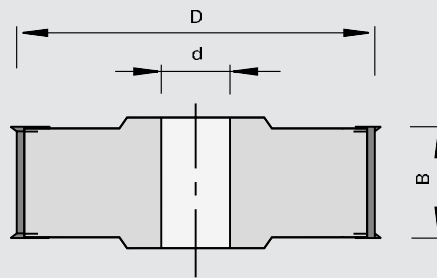
120255

Jointing and Rabbeting Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

| table shapers
 | for jointing 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		9000-15000	167038
100	30	30	2+4		8000-15000	167039
100	50	30	2+4		8000-15000	167040
125	30	30	2+4		6500-12000	167041
125	50	30	2+4		6500-12000	167043
125	50	35	2+4	10x4	6500-12000	167044&
125	50	30	4+4		6500-12000	167046
125	50	35	4+4	10x4	6500-12000	167047&
125	50	40	4+4	12x5	6500-12000	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 DIN EN ISO 4028	167039, 167041, 167043, 167044, 167046, 167047, 167048	995161	001617
Countersunk Flat Headed Screws	M5x10,8 T15		995125	180840
Screwdrivers	SW3x100		985730	166090
Screwdrivers	T15x100		985730	180470
Adjusting Gauges	1,0		985200	011103 o
	[mm]			

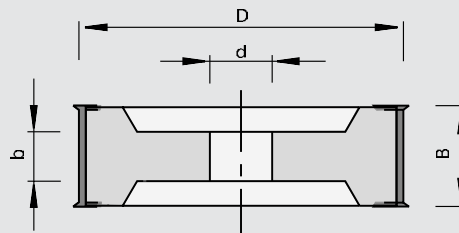
120250

Jointing and Rabbeting Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | molders
- | double end tenoners
- | for jointing and rabbeting in solid woods and wood-based panels

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 05
- | n max = 8,000 min-1

Advantages

Notes

Ø D	B	b	Ø d	Z	DKN	Ident-No.
180	50	20	35	4+4	10x4	167060
180	50	20	40	4+4	12x5	167061
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives

B	H	S
14	14	2
50	12	1.5
[mm]	[mm]	[mm]

Class-No.

Ident-No.

Spurs	150559	003079
Turnover Knives	150515	003085

Spare parts

Dimension

Class-No.

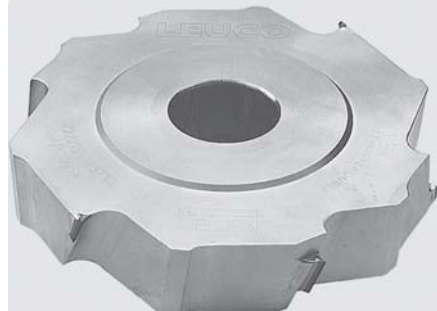
Ident-No.

Clamping Bars	B=48	925300	166984
Set Screws	M6x12 DIN EN ISO 4028	995161	180214
Countersunk Flat Headed Screws	M5x10,8 T15	995125	180840
Screwdrivers	SW3x100	985730	166090
Screwdrivers	T15x100	985730	180470
Adjusting Gauges	1,0 [mm]	985200	011103o

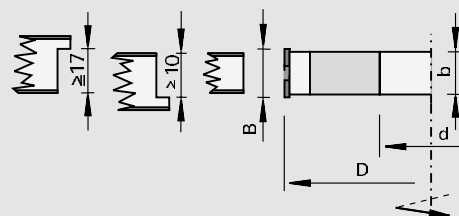
222225

Jointing / Rabbeting Cutters

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

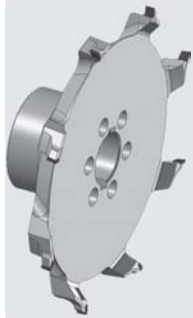
- | application against feed
- | sense of rotation according to DIN-EN 50144

Ø D	B	Ø d	Z	DKN	nmin-nmax	Ident-No.
125	25	30	2+2	8x3	6 100-10500	173710
125	25	50	2+2		6 100-10500	173786
125	43	30	2+2	8x3	6 100-10500	182704
[mm]	[mm]	[mm]		[mm]	[min-1]	

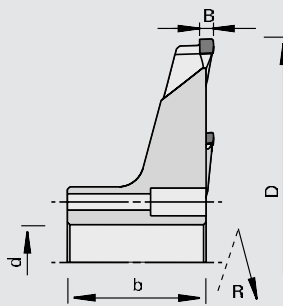
120200

Planing and Rabbeting Cutter

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

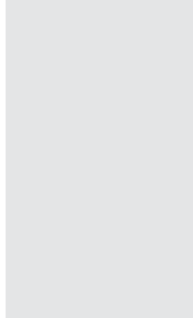
- sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	nmax	Ident-No.
150	5,6	55	30	8	12700	182662 s
180	5,6	58	30	8	10300	182426 s
[mm]	[mm]	[mm]	[mm]		[min-1]	

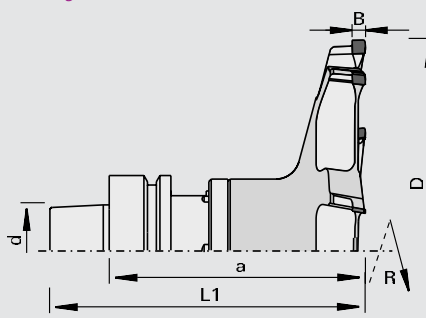
128200

Planing and Rabbeting Cutter

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	133	108	8	12700	182661 s
180	5,6	HSK 63F	133	108	8	10300	182425 s
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

122200

Corner Notching Cutter - Homag

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

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> l CNC machining centers Homag / aggregate 7547 l for sharp-edged cutting out of inside corners 	<ul style="list-style-type: none"> l n max 24.000 min-1 		<ul style="list-style-type: none"> l sense of rotation according to DIN-EN 50144

Ø D	B	b	Ø d	Z	Ident-No.
75 [mm]	15 [mm]	13 [mm]	16 [mm]	4	182457

120325

Chamfering Cutterheads

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

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> l table shapers l for chamfering of solid woods and wood-based panels 	<ul style="list-style-type: none"> l cutting edges parallel to cutter axis l cutting material: HW HL Board 05 		<ul style="list-style-type: none"> l application against feed l sense of rotation according to DIN-EN 50144

chamfer∠	Ø D	B	b	Ø d	Z	nmin-nmax	Ident-No. [L]	Ident-No. [R]
45 [°]	140 [mm]	12 [mm]	12 [mm]	30 [mm]	2	5500-10000 [min-1]	164970	164969

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.
Clamping Bars	B=10	925300	162106
Set Screws	M8x20 DIN EN ISO 4028	995161	001625
Screwdrivers	SW4x100 [mm]	985730	166091

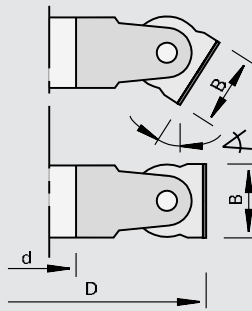
120305

Pivoting Cutterheads

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
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
	[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	76930125o
Clamping Bars	B=50	925300	76930124o
Special Screws	M5x7	995115	76930310o
Set Screws	M6x16 DIN EN ISO 4028	995161	001617
	[mm]		

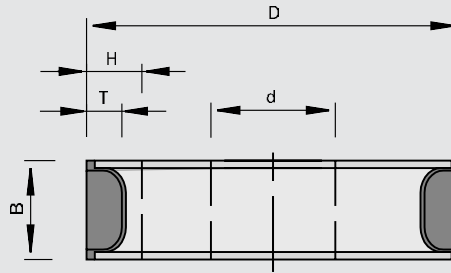
120607

SuperProfiler

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- table shapers
- for planing and profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- n = 6.200 - 10,700 min-1
- cutting material: HW HL Board 06 for hard woods and wood-based panels
- cutting material: HW HL Solid 60 for soft woods

Advantages

- cutterhead for mounting of several profile knives

Notes

- application against feed
- BG-Test 038-062
- 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.
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]			

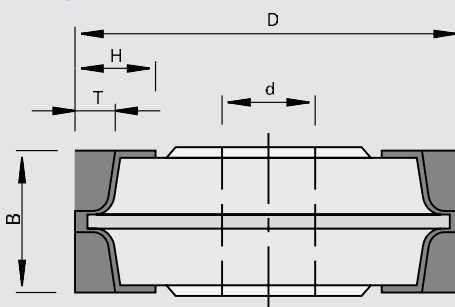
120607

SuperProfiler

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 BG-Test 038-066
- | 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.
125	40	30	35	13	2	SP 3	167897
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

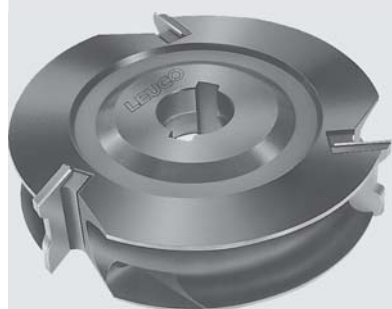
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 3	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 3	152529	177367
support plates	40	28		SP 3	925402	178011
deflector plates	40	28		SP 3	925407	167898
	[mm]	[mm]				

Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	36x12x8	925300	166737
Special Set Screws	M8x24	995191	167269
Screwdrivers	SW4x100	985730	166091
	[mm]		

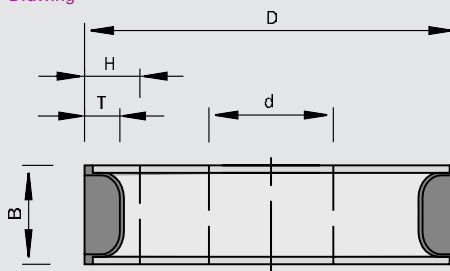
120602

SuperProfiler

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.
125	40	30	35	13	2	8x3	12000	SP 7	167439
125	40	31,75	35	13	2		12000	SP 7	167440
125	60	30	35	15	2	8x3	12000	SP 5	167441
125	60	31,75	35	15	2		12000	SP 5	167442
150	40	30	50	13	3	8x3	10000	SP 7	166971
150	40	31,75	50	13	3		10000	SP 7	176184
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	50	50	15	3		10000	SP 5	166978
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	40	50	50	13	3		8000	SP 7	166722
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
	[mm]	[mm]				

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No.
support plates	80 [mm]	45 [mm]		SP 6	925402	178013
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 [mm]			985730	166091	

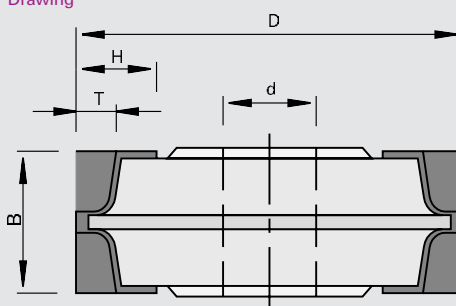
120602

SuperProfiler

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

Ø D	B	Ø d	Ø dmax	Tmax	Z	DKN	nmax	drawing	Ident-No.
150	40	30	50	13	3	8x3	10000	SP 9	167858 #
150	40	40	50	13	3	12x5	10000	SP 9	167860 #
[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 9	152526	179112
SP blanks	40,6	28.2	HL Solid 60	SP 9	152529	177367
support plates	40	28		SP 9	925402	178011
	[mm]	[mm]				

Spare parts	Dimension	for drawing/foil		Class-No.	Ident-No.
Clamping Bars	36x12x8	SP 9		925300	166737
Set Screws	M8x20 DIN EN ISO 4028			995161	001625
Screwdrivers	SW4x100 [mm]			985730	166091

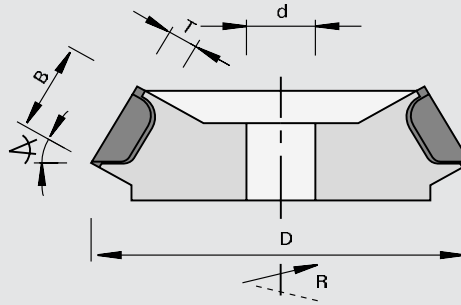
120622

SuperProfiler

Product



Drawing



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]	Ident-No. [R]
125	40	30		13	3	8x3	15	12000	SP 12		168246 #
165	40	30	40	13	3	8x3	30	9000	SP 13	167967	167968
180	40	35	50	13	3	10x4	30	8000	SP 13		166727
180	40	40	50	13	3	12x5	30	8000	SP 13	166728	166729 #
[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]				

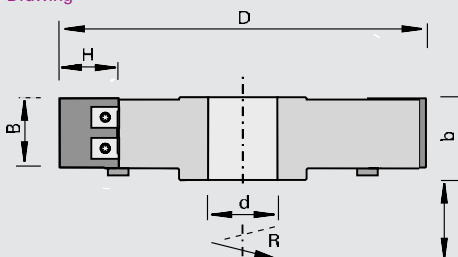
Spare parts	Dimension	Class-No.	Ident-No.
Clamping Bars	36x12x8		
		left	925300
		right	166736
Clamping Bars	36x12x8		925300
Set Screws	M8x20 DIN EN ISO 4028		166737
Screwdrivers	SW4x100		995161
	[mm]		001625
			985730
			166091

120603

EcoPro Cutterheads

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	drawing	Ident-No.
125	30	30	36	30	30	3	7700-10480	EP 382	179050 s
125	40	30	46	30	30	3	7700-9480	EP 384	179051 s
125	50	33	56	30	30	3	7700-8420	EP 386	179052 s
150	30	30	36	30	50	3	6200-9620	EP 382	179053 s
150	40	30	46	30	50	3	6200-8420	EP 384	179054 s
150	50	33	56	30	50	3	6200-7300	EP 386	179055 s
180	30	30	36	30	50	4	4800-8600	EP 382	179056 s
180	40	30	46	30	50	4	4800-7520	EP 384	179057 s
180	50	33	56	30	50	4	5200-6500	EP 386	179058 s
125	30	30	36	30	30	2	7700-10480	EP 382	179087 s
125	40	30	46	30	30	2	7700-9480	EP 384	179088 s
125	50	33	56	30	30	2	7700-8420	EP 386	179089 s
150	30	30	36	30	50	2	6200-9620	EP 382	179090 s
150	40	30	46	30	50	2	6200-8420	EP 384	179091 s
150	50	33	56	30	50	2	6200-7300	EP 386	179092 s
180	30	30	36	30	50	2	4800-8600	EP 382	179093 s
180	30	30	36	30	50	3	4800-8600	EP 382	179094 s
180	40	30	46	30	50	2	4800-7520	EP 384	179095 s
180	40	30	46	30	50	3	4800-7520	EP 384	179096 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]	

Ø D	B	H	b	Ø d	Ø dmax	Z	nmin-nmax	drawing	Ident-No.	
180	50	33	56	30	50	2	5200-6500	EP 386	179097 s	
180	50	33	56	30	50	3	5200-6500	EP 386	179098 s	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		
Blanks for 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&
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]				

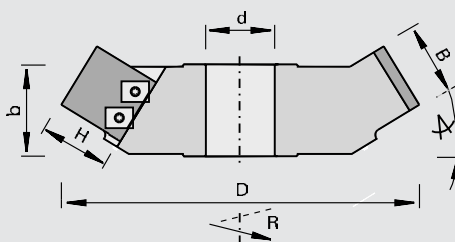
120613

EcoPro Cutterheads

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	drawing	Ident-No. [L]	Ident-No. [R]
150	40	30	49	30	30	3	30	6300-7460	EP 390	179350 s	179059 s
160	50	33	56	30	30	3	30	5800-6450	EP 392	179352 s	179060 s
180	40	30	50	30	50	4	30	5000-6580	EP 390	179355 s	179061 s
180	50	33	57	30	50	4	30	5000-5700	EP 392	179358 s	179062 s
165	40	30	46	30	30	3	45	5300-6920	EP 396	179360 s	179063 s
165	50	33	53	30	30	3	45	4600-6040	EP 398	179362 s	179064 s
195	40	30	46	30	50	4	45	5300-6160	EP 396	179365 s	179065 s
195	50	33	53	30	50	4	45	4600-5320	EP 398	179368 s	179066 s
150	40	30	49	30	30	2	30	6300-7460	EP 390	179349 s	179099 s
160	50	33	56	30	30	2	30	5800-6450	EP 392	179351 s	179100 s
180	40	30	50	30	50	2	30	5000-6580	EP 390	179353 s	179101 s
180	40	30	50	30	50	3	30	5000-6580	EP 390	179354 s	179102 s
180	50	33	57	30	50	2	30	5000-5700	EP 392	179356 s	179103 s
180	50	33	57	30	50	3	30	5000-5700	EP 392	179357 s	179104 s
165	40	30	46	30	30	2	45	5300-6920	EP 396	179359 s	179105 s
165	50	33	53	30	30	2	45	4600-6040	EP 398	179361 s	179106 s
195	40	30	46	30	50	2	45	5300-6160	EP 396	179363 s	179107 s
195	40	30	46	30	50	3	45	5300-6160	EP 396	179364 s	179108 s
195	50	33	53	30	50	2	45	4600-5320	EP 398	179366 s	179109 s
195	50	33	53	30	50	3	45	4600-5320	EP 398	179367 s	179110 s
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[°]	[min-1]	[Foil]		

Blanks for 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]					

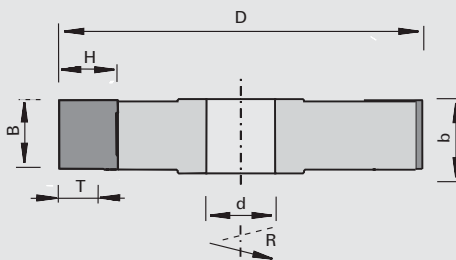
Blanks for for Ident-No.	B	H	LEUCODUR	Drawing/Foil	Class-No.	Ident-No. [L]	Ident-No. [R]
179059, 179061, 179063, 179065, 179099, 179101, 179102, 179105, 179107, 179108, 179349, 179350, 179353, 179354, 179355, 179359, 179360, 179363, 179364, 179365	40,1	30,4	HL Solid 60	EP 390, EP 396	152589		179534
179060, 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

UltraProfiler Cutterheads

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

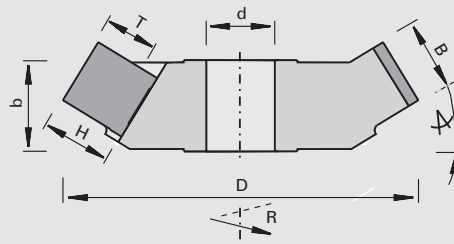
Ø D	B	H	Ø d	Ø dmax	T	Z	nmax
125	32	35	30	30	16	2	12000
125	32	35	30	30	16	3	12000
125	40	35	30	30	16	2	10500
125	40	35	30	30	16	3	10500
125	50	35	30	30	16	2	9500
125	50	35	30	30	16	3	9500
125	60	35	30	30	16	2	7200
125	60	35	30	30	16	3	7200
150	32	40	30	50	21	2	9000
150	32	40	30	50	21	3	9000
150	40	40	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

UltraProfiler Cutterheads

Product

Drawing



LEUCO
ultra profiler

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.
	32	40.4	2	HL Board 06	152586	182419
	40	40.4	2	HL Board 06	152586	182420
	50	40.4	2	HL Board 06	152586	182421
	60	40.4	2	HL Board 06	152586	182422
	[mm]	[mm]	[mm]			

Blanks	B	H	S	LEUCODUR	Class-No.	Ident-No. [L]	Ident-No. [R]
	32	40.4	2	HL Board 06 Topline	152786	182563	182562
	40	40.4	2	HL Board 06 Topline	152786	182565	182564
	50	40.4	2	HL Board 06 Topline	152786	182567	182566
	60	40.4	2	HL Board 06 Topline	152786	182569	182568
	[mm]	[mm]	[mm]				

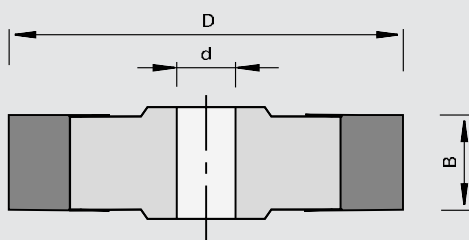
320605

Safety Cutterheads

Product



Drawing



High Speed Steel [HS]

MAN

Machine / Application

- table shapers
- for profiling of solid woods

Design

- cutting edges parallel to cutter axis
- n = 6,500 - 10,000 min-1

Advantages

Notes

- tool set consists of 2 profile knives and 2 deflectors
- knives can be profiled according to customer specifications
- use of 40 and 50 mm wide knives allowed

Ø D	B	Ø d	Z	Ident-No.
128	40	30	2	167245 o
[mm]	[mm]	[mm]		

HS blanks for profiling	B	H	S	T	Class-No.	Ident-No.
	40	45	4	15	332521	163535
	50	45	4	15	332521	163513 o
	[mm]	[mm]	[mm]	[mm]		

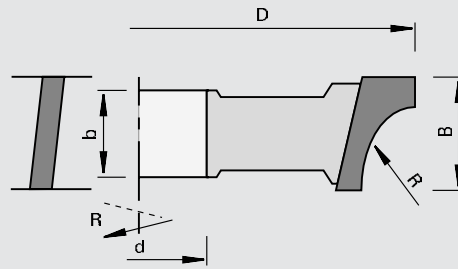
deflectors for profiling	B	H	S	T	Class-No.	Ident-No.
	40	45	4	15	925400	163536
	50	45	4	15	925400	163514 o
	[mm]	[mm]	[mm]	[mm]		

322315

Rounding Cutters

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

l table shapers
l for cutting of quarter round profiles in solid woods

Design

l with shear angle

Advantages

l optimum cutting quality and precise tool balancing

Notes

l profile runout 5 degrees
l sense of rotation according to DIN-EN 50144

R	Ø D	Ø d	Z	nmin-nmax	Ident-No. [L]	Ident-No. [R]
4	120	30	3	6000-11000	198284 s	198283 s
5	120	30	3	6400-11000	198286 s	198285 s
6	120	30	3	6400-11000	198288 s	198287 s
8	120	30	3	6400-11000	198290 s	198289 s
10	120	30	3	6400-11000	198292 s	198291 s
12	120	30	3	6400-11000	198294 s	198293 s
15	140	30	3	5400-9400	198296 s	198295 s
20	140	30	3	5400-9400	198298 s	198297 s
[mm]	[mm]	[mm]		[min-1]		

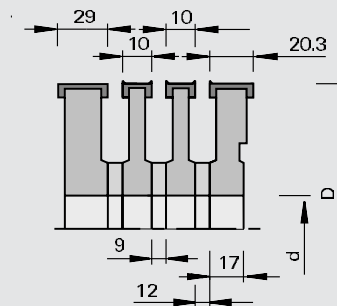
120460

Groove Bed Cutterheads

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
Countersunk Flat Headed Screws	M5x10,8 T15	176067, 176070	995125	180840
Adjusting Gauges	1,0	176067, 176070, 180536	985200	011103 o
Clamping Bars	B=30	180536	925300	164185
Screwdrivers	SW2,5x100	176066, 176069	985730	168010
	[mm]			

Spare parts	Dimension	for Ident-No.	Class-No.	Ident-No.
Screwdrivers	SW4x100	176067, 176070, 180536	985730	166091
Screwdrivers	T15x100	176067, 176070	985730	180470
Screwdrivers	T20x100		985730	166092
	[mm]			

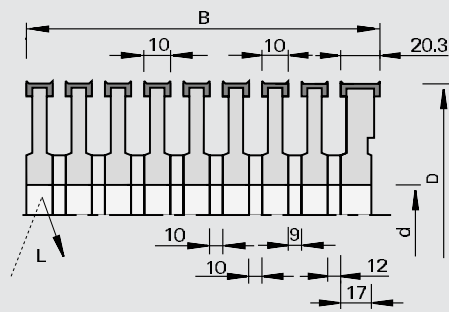
121450

Groove Bed Cutterheads

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]		

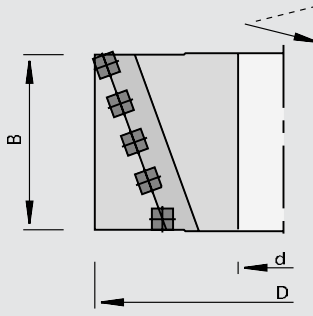
120700

Spiral Cutterheads - 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

Ø D	B	Ø 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
15	15	2.5
[mm]	[mm]	[mm]

Class-No.	Ident-No.
150518	180454

Spare parts

Dimension	Class-No.	Ident-No.
Countersunk Flat Headed Screws	M5x15,5 T20	995125
Screwdrivers	T20x100	985730
	[mm]	

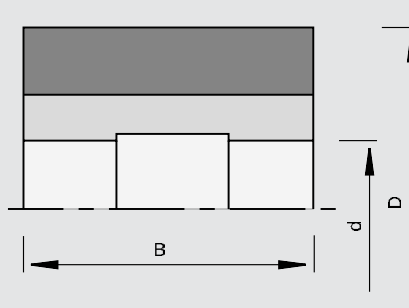
320200

Planing Cutterheads

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.
Clamping Bars	B=80	925300	179205o
Clamping Bars	B=100	925300	181191o
Clamping Bars	B=130	925300	179198o
Clamping Bars	B=150	925300	179199o
Clamping Bars	B=180	925300	179200o
Clamping Bars	B=230	925300	181192o
Adjustment Rings	125x40	985200	179201o
Set Screws	M10x25 DIN EN ISO 4028	995161	168108
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	009674
	[mm]		

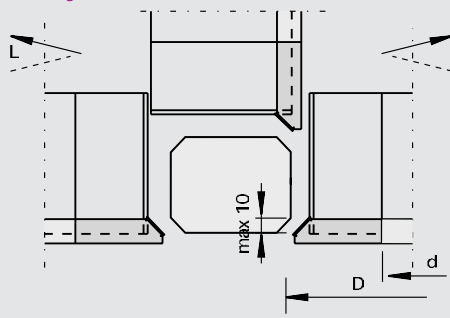
120301

Chamfering Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- l molders
- l for chamfering of solid woods

Design

- l n max = 9,000 min-1

Advantages

- l possibility of simultaneous planing and chamfering of different wood cross-sections without changing tools thanks to the combination with planing cutterheads on vertical and horizontal spindles

Notes

- l recommendation: run 4th chamfer on universal spindle
- l sense of rotation according to DIN-EN 50144

chamfer∠	Ø D	B	Ø d	Ø dmax	Z		Ident-No. [L]	Ident-No. [R]
10x45	145.6	15	40	50	4	for Ø 125	181207 #	181206 #
10x45	160.6	15	40	50	4	for Ø 140	181209	181208 #
[°]	[mm]	[mm]	[mm]	[mm]				

Turnover Knives

B

H

S

Class-No.

Ident-No.

15

15

2.5

150518

181243

[mm]

[mm]

[mm]

Spare parts

Dimension

Class-No.

Ident-No.

Countersunk Flat Headed Screws

M6x10 T20

995125

181244

Screwdrivers

T20x100

985730

166092

[mm]

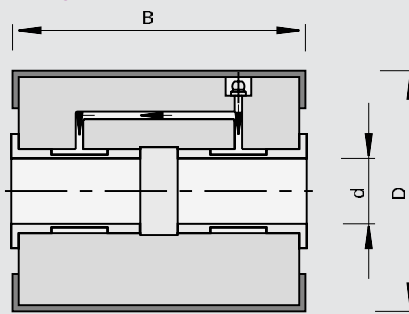
320200

Hydro Planing Cutterheads

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↙	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]

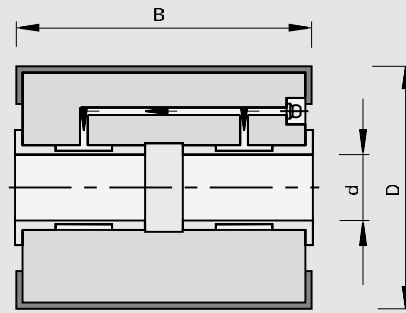
320200

Hydro-Rotaplane Cutterheads

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

$\emptyset D$	B	$\emptyset d$	Z	hook \sphericalangle	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]		

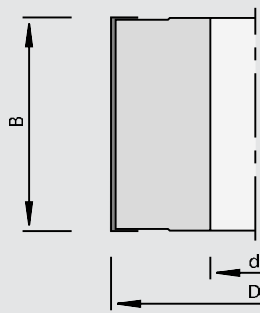
320200 / 332121 / 132121

Planing Cutterheads 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	70469707o
	80	HS - TRI	332121	70469708o
	100	HS - TRI	332121	70469710o
	120	HS - TRI	332121	70469712o
	130	HS - TRI	332121	70469713o
	136	HS - TRI	332121	70469736o
	140	HS - TRI	332121	70469714o
	150	HS - TRI	332121	70469715o
	160	HS - TRI	332121	70469716o
	180	HS - TRI	332121	70469718o
	186	HS - TRI	332121	70469786o
	[mm]			

Turnover Knives	B	cutting material	Class-No.	Ident-No.
	190	HS - TRI	332121	70469719o
	200	HS - TRI	332121	70469720o
	210	HS - TRI	332121	70469721o
	220	HS - TRI	332121	70469722o
	230	HS - TRI	332121	70469723o
	240	HS - TRI	332121	70469724o
	260	HS - TRI	332121	70469726o
	300	HS - TRI	332121	70469730o
	310	HS - TRI	332121	70469731o
	400	HS - TRI	332121	70469740o
	410	HS - TRI	332121	70469741o
	430	HS - TRI	332121	70469743o
	500	HS - TRI	332121	70469750o
	510	HS - TRI	332121	70469751o
	610	HS - TRI	332121	70469761o
	630	HS - TRI	332121	70469763o
	640	HS - TRI	332121	70469764o
	710	HS - TRI	332121	70469771o
	1350	HS - TRI	332121	70469798o
	[mm]			
Turnover Knives	B	cutting material	Class-No.	Ident-No.
	80	HW	132121	70469908o
	100	HW	132121	70469910o
	120	HW	132121	70469912o
	130	HW	132121	70469913o
	140	HW	132121	70469914o
	150	HW	132121	70469915o
	160	HW	132121	70469916o
	180	HW	132121	70469918o
	200	HW	132121	70469920o
	210	HW	132121	70469921o
	220	HW	132121	70469922o
	230	HW	132121	70469923o
	240	HW	132121	70469924o
	250	HW	132121	70469925o
	260	HW	132121	70469926o
	300	HW	132121	70469930o
	610	HW	132121	70469999o
	[mm]			
Spare parts			Class-No.	Ident-No.
Knife Changers			985720	70469100 o

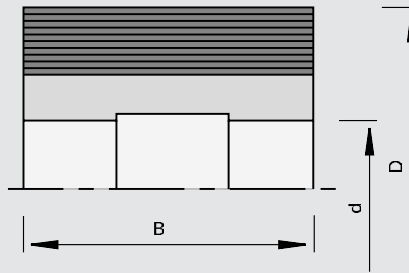
320600

Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- l molders
- l for profiling of solid woods

Design

- l hook angle 25 degrees
- l \varnothing 122 mm: n max = 9,000 min-1
- l \varnothing 137 mm: n max = 8,000 min-1

Advantages

- l high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

- l precise serration (60 degrees, 1.6 mm pitch) ensures tight knife clamping
- l adjustable knives
- l profile depth and cutting circle \varnothing see table
- l for back-serrated blanks S = 5, 8, 10 mm
- l included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

\varnothing D	B	\varnothing 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
122	180	40	4	179214
122	230	40	4	179215 o
137	60	50	4	179216
137	80	50	4	179217 o
137	100	50	4	179218
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	179221o
Clamping Bars	B=60	925300	179222o
Clamping Bars	B=80	925300	179223o
Clamping Bars	B=100	925300	179224o
Clamping Bars	B=130	925300	179225o
Clamping Bars	B=150	925300	179226o
Clamping Bars	B=180	925300	179227o
Clamping Bars	B=230	925300	179228o
Dummy Pieces	B=40	925900	179229o
Dummy Pieces	B=60	925900	179230o
Dummy Pieces	B=80	925900	179231o
Dummy Pieces	B=100	925900	179232o
Dummy Pieces	B=130	925900	179233o
Dummy Pieces	B=150	925900	179234o
Dummy Pieces	B=180	925900	179235o
Dummy Pieces	B=230	925900	179236o
Set Screws	M10x20 DIN EN ISO 4028	995161	815807
	[mm]		

Spare parts	Dimension	Class-No.	Ident-No.
Screwdrivers	SW5x150 [mm]	985730	168703

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	161	161	171	181	181	201	201
Dmax at D=122	176	176	186	196	196	216	216

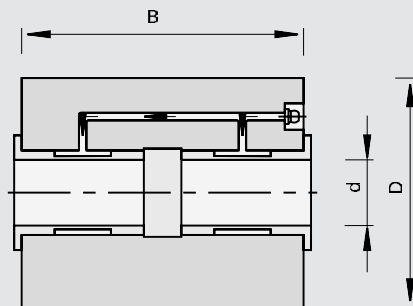
320600

Hydro Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- Ø 137 mm: n max = 9,000 min-1
- Ø 150 mm: n max = 8,000 min-1
- Ø 163-215 mm: n max = 6,000 min-1

Advantages

- best cutting quality without knife marks at high feedrates
- precise concentricity tolerance (system Weing) thanks to dual-chamber Hydro clamping
- high concentric accuracy and low operating vibration
- high feed rates and optimum cutting quality
- tight clamping thanks to precise serration (60 degrees, 1.6 mm pitch)

Notes

- 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.
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
150	230	50	4	176358 o
150	230	50	6	176359 o
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
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

320208

Planing Cutterheads with Weinig HSK

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

| molders „Weinig Powermat“
| for planing of solid woods

Design

| n max = 12,000 min-1

Advantages

| quick knife change thanks to Centrolock clamping bar

Notes

- | clamping by means of front screw
- | HS-tipped turnover knives
- | alternative cutting material: HW for hard woods, glued timber and MDF
- | picture shows sense of rotation left (acc. to DIN left)
- | Turnover Knives see chapter Turnover Knives, Knives, Inserts

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
100	60	Weinig-HSK	2	181728 o	181737 o
100	80	Weinig-HSK	2	181729 o	181738 o
100	100	Weinig-HSK	2	181730 o	181739 o
100	130	Weinig-HSK	2	181731 o	181740 o
100	150	Weinig-HSK	2	181732 o	181741 o
100	170	Weinig-HSK	2	181733 o	181742 o
100	190	Weinig-HSK	2	181734 o	181743 o
100	210	Weinig-HSK	2	181735 o	181744 o
100	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

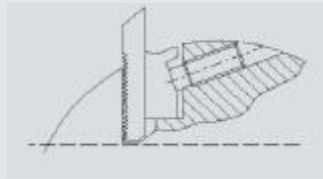
320608

Planing Cutterheads with Weinig HSK

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]			

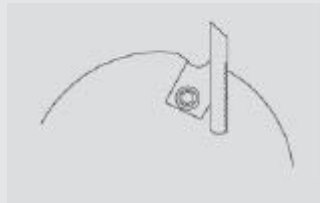
320608

Planing Cutterheads with Weinig HSK

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

| molders „Weinig Powermat“
| for profiling of solid woods

Design

| hook angle 20 degrees (special 12 degrees)
| n max = 12,000 min-1

Advantages

| quick knife change thanks to Centrolock clamping bar
| fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
| high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

| clamping by means of front screw
| adjustable knives
| picture shows sense of rotation left (acc. to DIN left)
| for back-serrated blanks S = 8 mm
| 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	60	Weinig-HSK	2	181748 o	181757 o
90	80	Weinig-HSK	2	181749 o	181758 o
90	100	Weinig-HSK	2	181750 o	181759 o
90	130	Weinig-HSK	2	181751 o	181760 o
90	150	Weinig-HSK	2	181752 o	181761 o
90	170	Weinig-HSK	2	181753 o	181762 o
90	190	Weinig-HSK	2	181754 o	181763 o
90	210	Weinig-HSK	2	181755 o	181764 o
90	240	Weinig-HSK	2	181756 o	181765 o
[mm]	[mm]	[mm]			

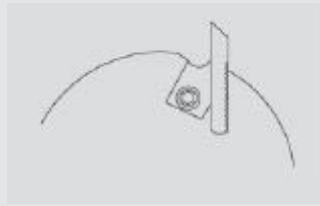
320608

Planing Cutterheads with Weinig HSK

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | molders
- | for profiling of solid woods

Design

- | hook angle 20 degrees (special 12 degrees)
- | n max = 12,000 min-1

Advantages

- | quick knife change thanks to Centrolock clamping bar
- | fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- | high profile accuracy and surface quality thanks to knives sharpened in the cutterhead

Notes

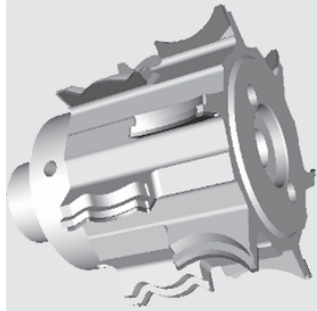
- | clamping by means of front screw
- | adjustable knives
- | picture shows sense of rotation left (acc. to DIN left)
- | for back-serrated blanks resp. back-serrated SetProfiler blanks S = 10 mm
- | included in delivery: cutterhead and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No. [L]	Ident-No. [R]
90	60	Weinig-HSK	2	181899 o	181908 o
90	80	Weinig-HSK	2	181900 o	181909 o
90	100	Weinig-HSK	2	181901 o	181910 o
90	130	Weinig-HSK	2	181902 o	181911 o
90	150	Weinig-HSK	2	181903 o	181912 o
90	170	Weinig-HSK	2	181904 o	181913 o
90	190	Weinig-HSK	2	181905 o	181914 o
90	210	Weinig-HSK	2	181906 o	181915 o
90	240	Weinig-HSK	2	181907 o	181916 o
[mm]	[mm]	[mm]			

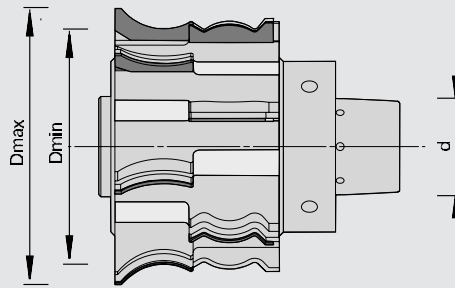
222068

PowerDiaProfiler

Product



Drawing



LEUCO
power
DIAProfiler

Polycrystalline Diamond [DP]

MEC

Machine / Application

- | molding automats with HSK-interface
- | for profiling of MDF, hard and exotic woods

Design

- | Topline (polished knife face and precise cutting edge)

Advantages

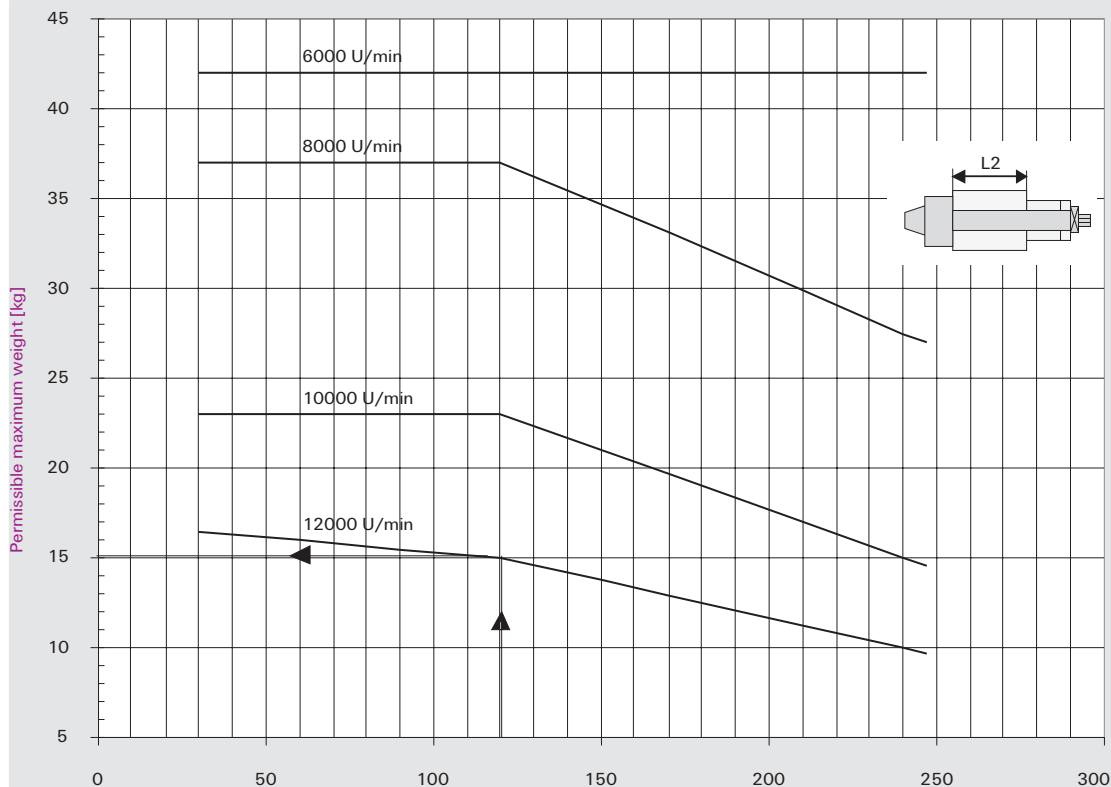
- | highest concentricity
- | feed speed and workpiece surface like in the case of jointed HW-tools

Notes

- | optimal cutting speed 80 - 100m/s
- | profiles according to customer specifications
- | price upon request
- | n max = depending on L2 and weight (see chart)

Ø Dmax	Ø Dmin	Ø d	Z	recommended feed
180	100	Weinig HSK	2	33
180	100	Weinig HSK	3	50
180	100	Weinig HSK	4	66
180	100	Weinig HSK	5	83
180	100	Weinig HSK	6	100
180	100	Weinig HSK	7	117
180	100	Weinig HSK	8	133
[mm]	[mm]	[mm]		[m/min]

Diagram for PowerLock-Adapter



Tool length L2 [mm]

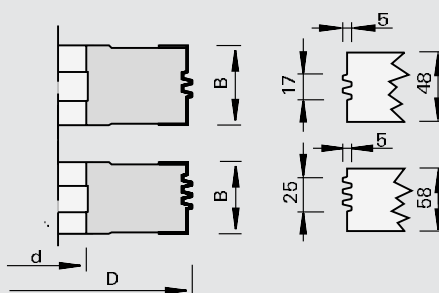
120505

Glue Joint Profile Cutterheads

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

Turnover Knives	B	H	S	Class-No.	Ident-No.
	50	23	2	15 1555	180431
	60	23	2	15 1555	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		925 100	180357
Clamping Setscrews	M8x26 SW4		995 161	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]		

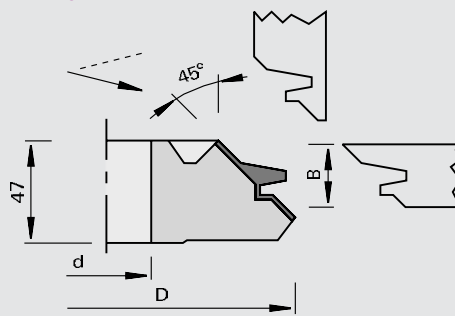
120525

Miter Lock Joint Profile Cutterheads

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- | molders
- | table shapers
- | for cutting of miter lock joints in solid woods and wood-based panels

Design

- | body made from high-strength aluminium alloy
- | cutting edges parallel to cutter axis
- | n = 4,600 - 7,800 min-1

Advantages

- | continuous high profile accuracy thanks to profile knives

Notes

- | application against feed
- | wood thickness approx. 15 mm to max. 26 mm

Ø D	B	Ø d	Z	Ident-No.
170	26	30	2+2	176097
[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Class-No.	Ident-No.
Grooving / Chamfering Knife	4,6 / 2,8		4.6	150509	180500
Miter Glue Joint Profile Knives	39,5	12	1.5	15 1547	165916
	[mm]	[mm]	[mm]		

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
Countersunk Flat Headed Screws	M5x10,8 T15	995125	180840
Screwdrivers	SW4x100	985730	166091
Screwdrivers	T15x100	985730	180470
	[mm]		

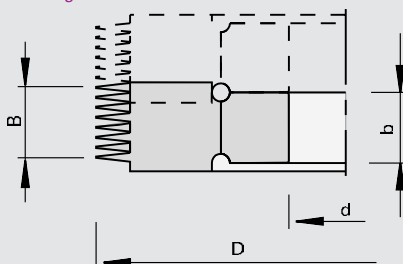
327110

Finger Joint Cutters

Product



Drawing



High Speed Steel [HS]
MEC

Machine / Application

- l finger joint machines
- l machines with cross-cutting device
- l for longitudinal joints in soft woods

Design

Advantages

Notes

- l for machines with cross-cutting device, finger length 4/4,5, 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	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 s
260	28,6	26,6	50	3+3	3,8	15/16,5	7	6000	175749
260	33	31	50	3+3	6,2	20/22	5	6000	175751
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc]	[min-1]	

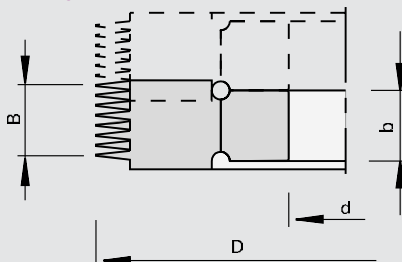
527120

Finger Joint Cutters

Product



Drawing



LEUCO
topline

High Speed Steel [HS]

MEC

Machine / Application

- l finger joint machines
- l machines with cross-cutting device
- l for longitudinal joints in soft woods
- l for production of gluelam construction timber and quality laminated timber

Design

- l cutting material: special HS

Advantages

- l compared to traditional HS finger joint cutters the edge live is 2 - 3 times as long

Notes

- l

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	15/16,5	7	8000	181185 s
180	33	31	50	2+2	6.2	20/22	5	8000	181187 s
260	28,6	26,6	50	3+3	3.8	15/16,5	7	6000	181188 s
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc]	[min-1]	

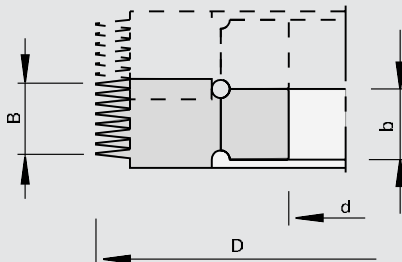
127110

Finger Joint Cutters

Product



Drawing



LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- l finger joint machines
- l machines with cross-cutting device
- l for longitudinal joints in hard and exotic woods

Design

Advantages

Notes

- l for machines with cross-cutting device, finger length 10/11, 15/16,5
- l for machines without cross-cutting device, finger length 10/10, 15/15

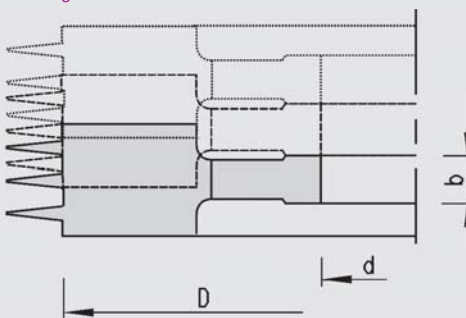
Ø D	B	b	Ø d	Z	division	finger joint length	number of finger joints	nmax	Ident-No.
160	28,6	26,6	50	2+2	3.8	10/10	7	8000	175732 s
160	28,6	26,6	50	2+2	3.8	10/11	7	8000	175733
170	28,6	26,6	50	2+2	3.8	15/15	7	8000	175734 s
170	28,6	26,6	50	2+2	3.8	15/16,5	7	8000	175735 s
250	28,6	26,6	50	3+3	3.8	10/10	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]	

527120

Finger Joint Cutters

Product

Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | finger joint machines
- | machines with cross-cutting device
- | for longitudinal joints in soft woods

Design

- | cutting material: special HS

Advantages

- | compared to traditional HS finger joint cutters the edge live is 2 - 3 times as long

Notes

- | no. of finger joint cutters with regard to wood height: no. of cutters = wood height: hub width (11.4) = round up + 1 cutter
- | tool support of the machine spindle = 5.7 mm below workpiece support

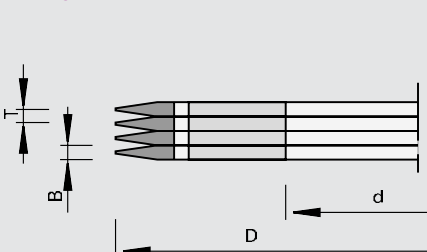
Ø D	b	Ø d	Z	division	finger joint length	number of finger joints	nmax	Ident-No.
250	11.4	50	6	3.8	10/11	3	6000	181163 s
260	11.4	50	6	3.8	15/16,5	3	6000	181161 s
[mm]	[mm]	[mm]		[mm]	[mm]	[pc]	[min-1]	

127210

Finger Joint Cutters disc-type

Product

Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | finger joint machines Grecon/Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- | machines with cross-cutting device
- | for longitudinal joints in soft and hard woods

Design

- | high-tensile steel body
- | Topline grinding
- | Ø 160 mm: n max = 11,800 min-1
- | Ø 250 mm: n max = 7,400 min-1
- | Ø 260 mm: n max = 7,200 min-1

Advantages

- | optimal edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges

Notes

- | adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	division	finger joint length		Ident-No.
160	3,8	70	2	3.8	10/11	soft woods	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	hard woods/exotic woods	178253 s
[mm]	[mm]	[mm]		[mm]	[mm]		

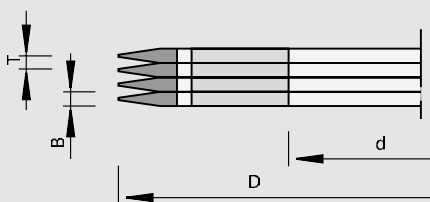
127230

Finger Joint Cutters disc-type

Product



Drawing



LEUCO
topcoat

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- machines with cross-cutting device
- for longitudinal joints in soft and hard woods

Design

- high-tensile steel body
- HW Topcoat coating
- Ø 160 mm: n max = 11,800 min-1
- Ø 250 mm: n max = 7,400 min-1

Advantages

- longest edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- compared to traditional HW finger joint cutters the edge live is 2 - 3 times as long

Notes

- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	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]		

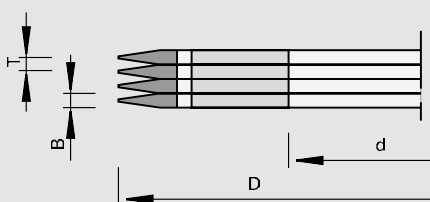
127230

Finger Joint Cutters disc-type

Product



Drawing



LEUCO
topcoat plus

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines Grecon/ Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT
- machines with cross-cutting device
- for longitudinal joints in soft woods

Design

- high-tensile steel body
- HW Topcoat plus coating
- Ø 250 mm: n max = 7,400 min-1

Advantages

- longest edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- compared to traditional HW finger joint cutters the edge live is 3 - 5 times as long

Notes

- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	division	finger joint length		Ident-No.
250	3,8	70	6	3.8	10/11	soft woods	182674
[mm]	[mm]	[mm]		[mm]	[mm]		

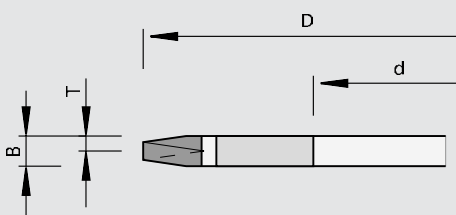
127310

Edge Finger Joint Cutters

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
239	11,4	70	6	3.8	10	181245
250	11,4	70	6	3.8	10	177576
[mm]	[mm]	[mm]		[mm]	[mm]	

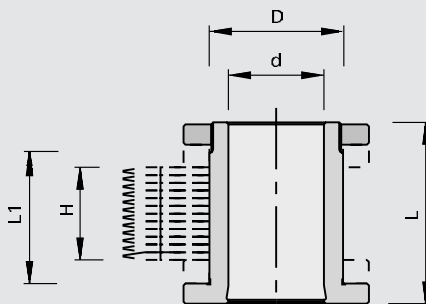
997300

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

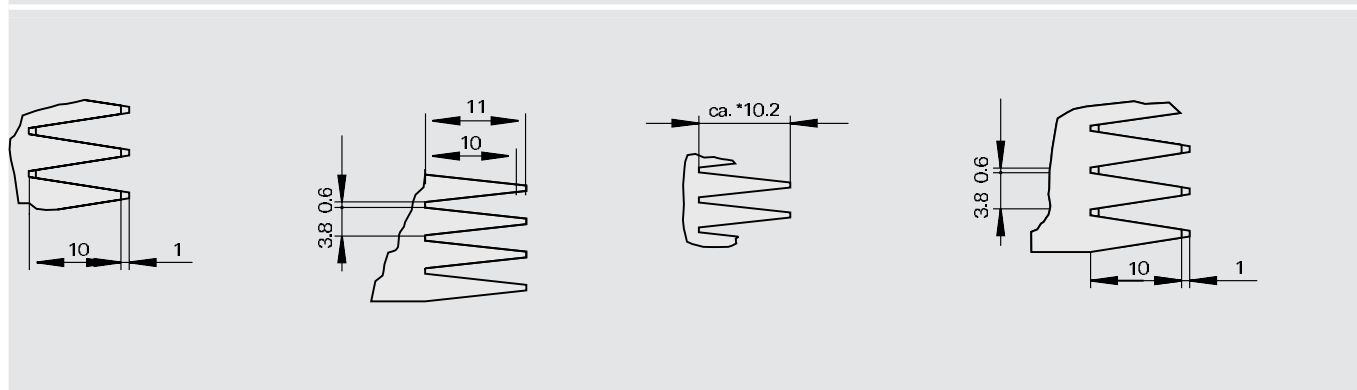
Combination of the cutter sets depending on the wood thickness

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

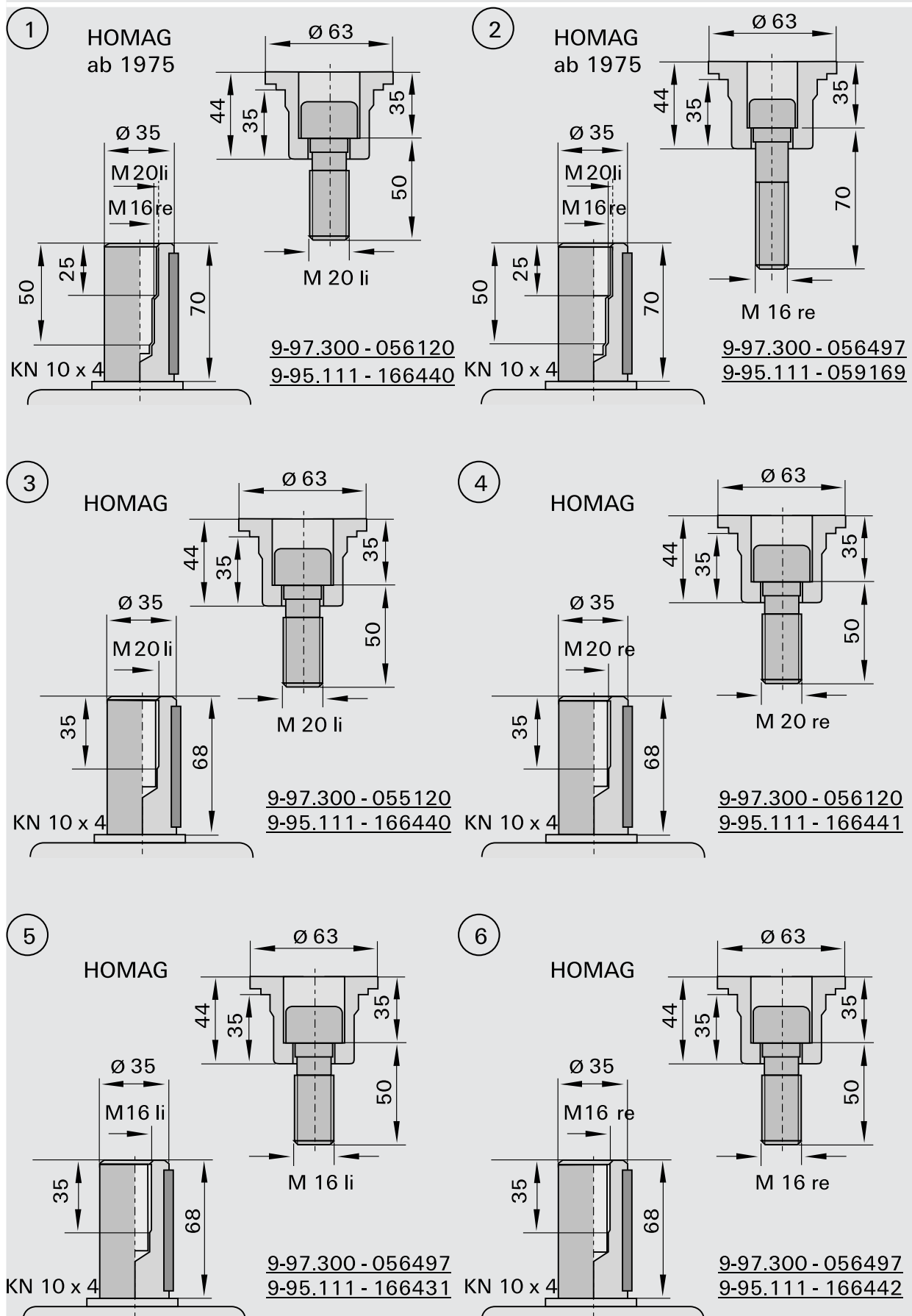
Finger joint cutters - cross cutting with extended finger joint profile

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

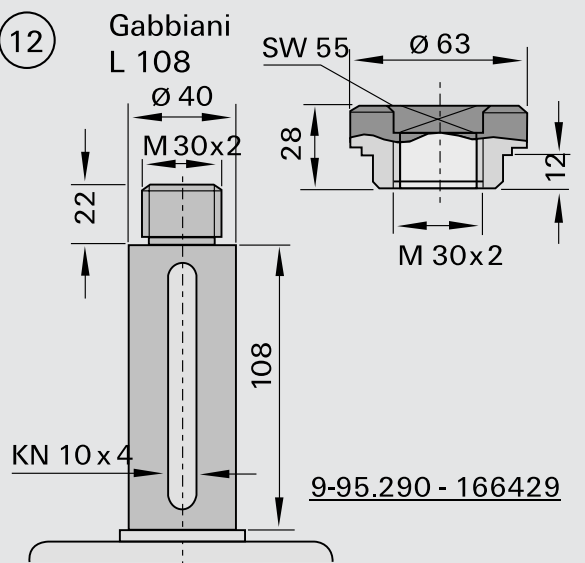
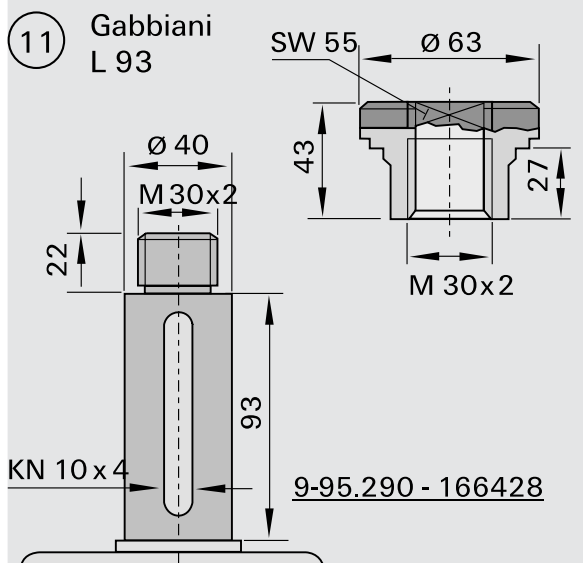
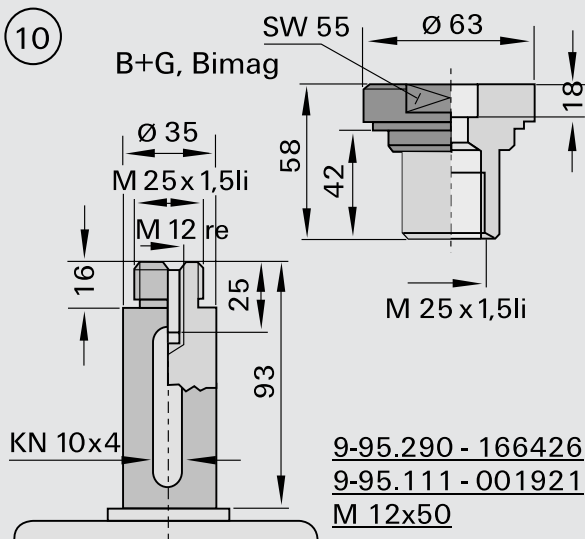
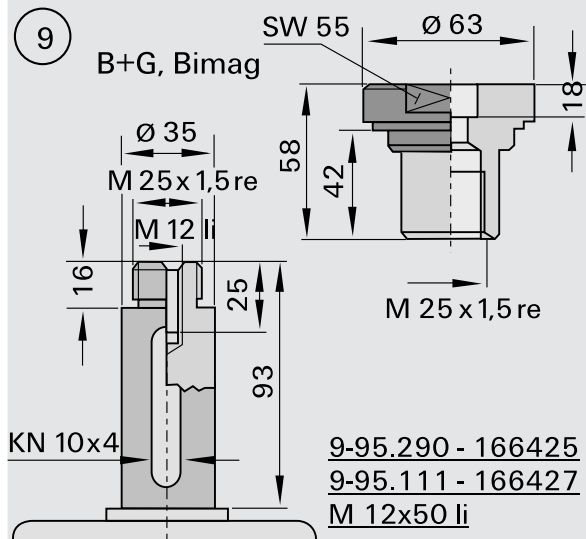
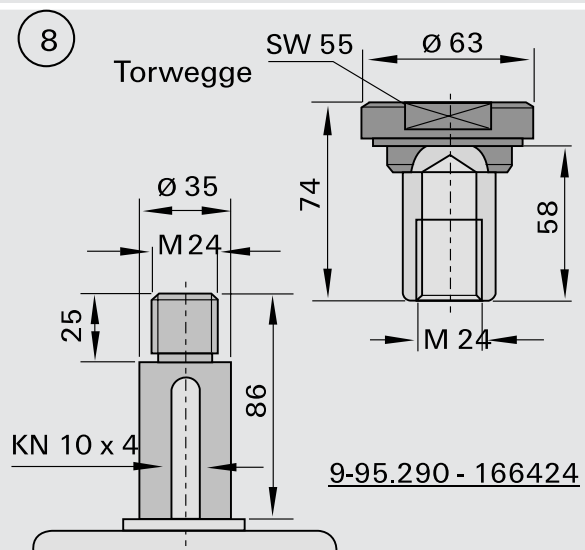
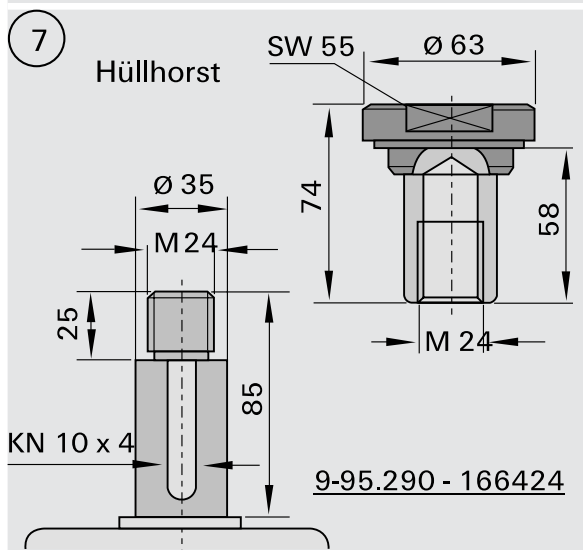
Drawing profile example



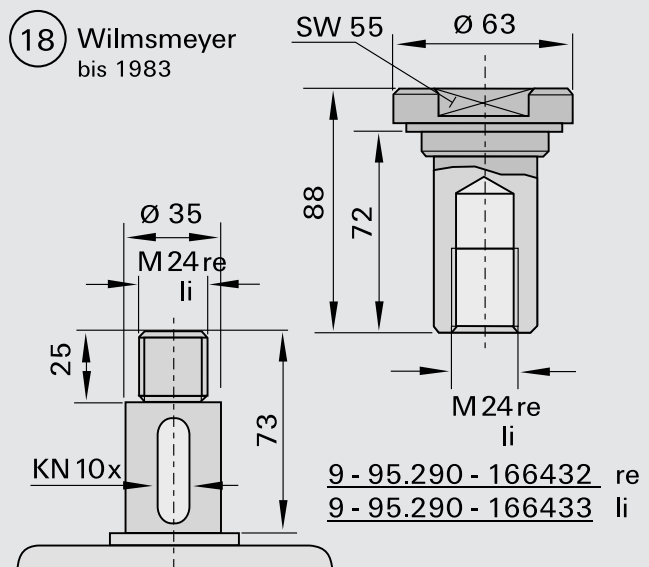
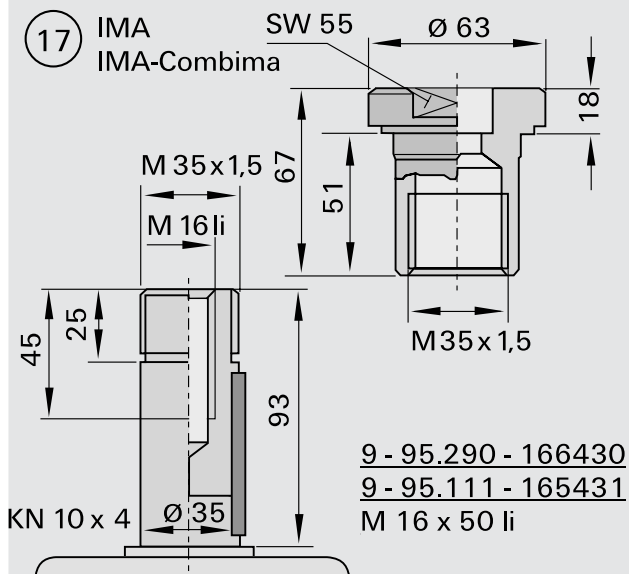
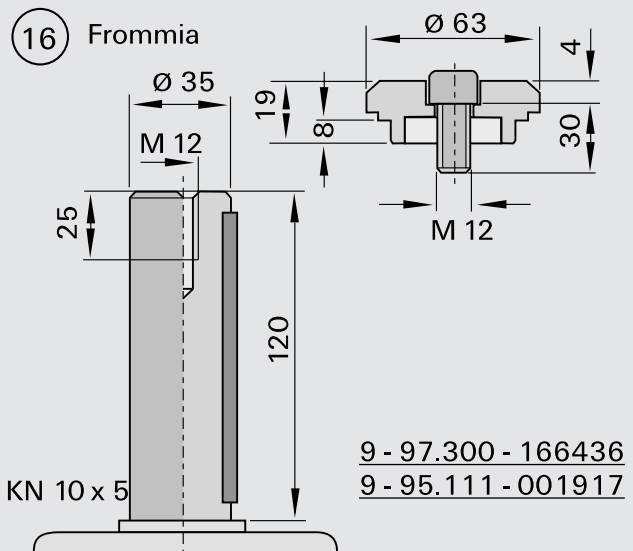
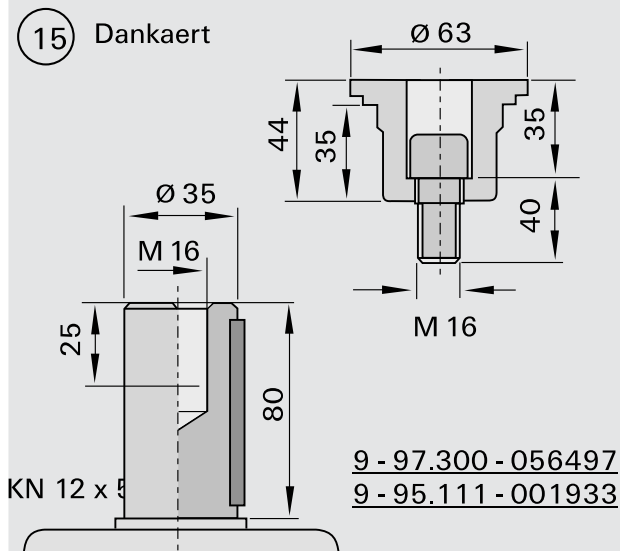
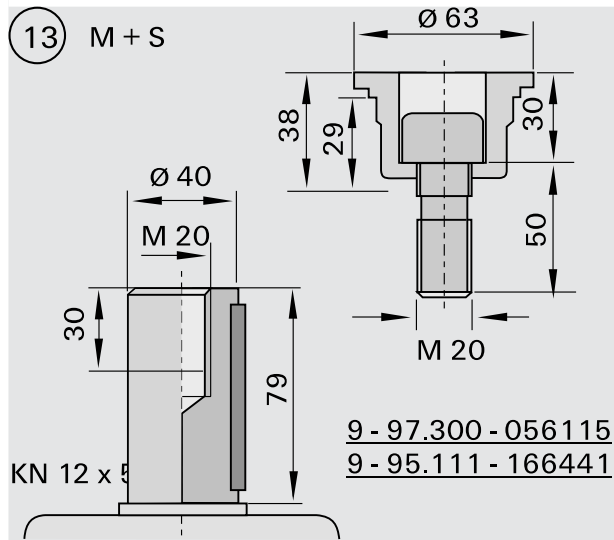
Fasteners for Jointing Cutterheads



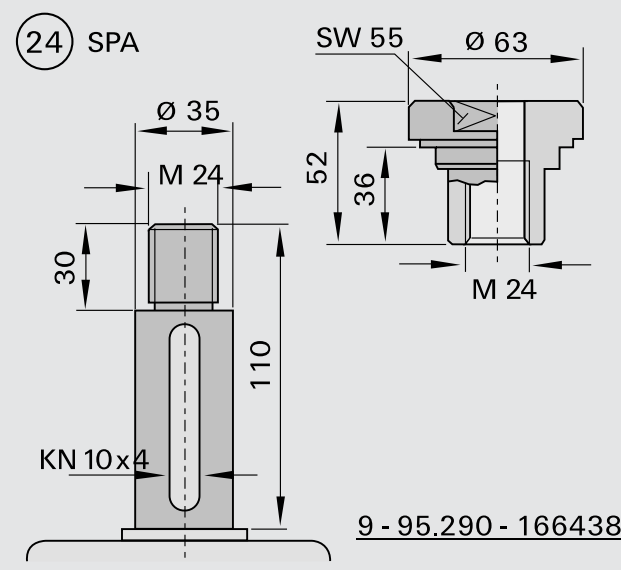
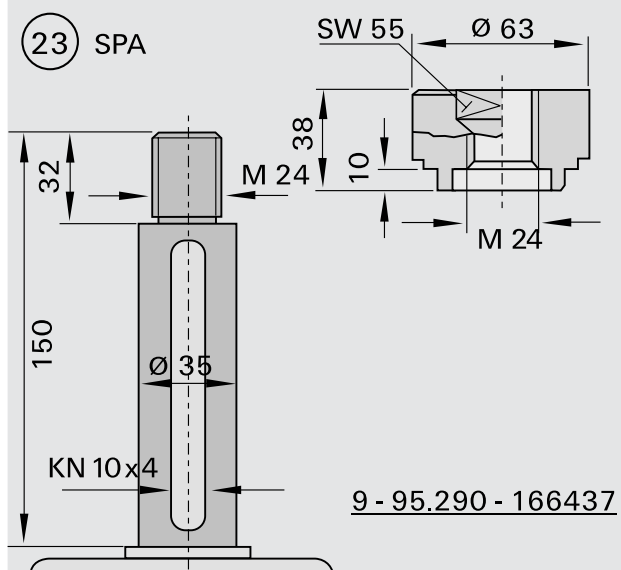
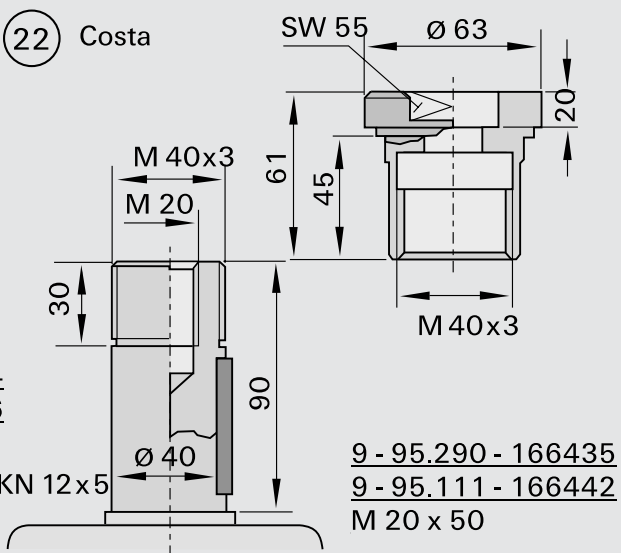
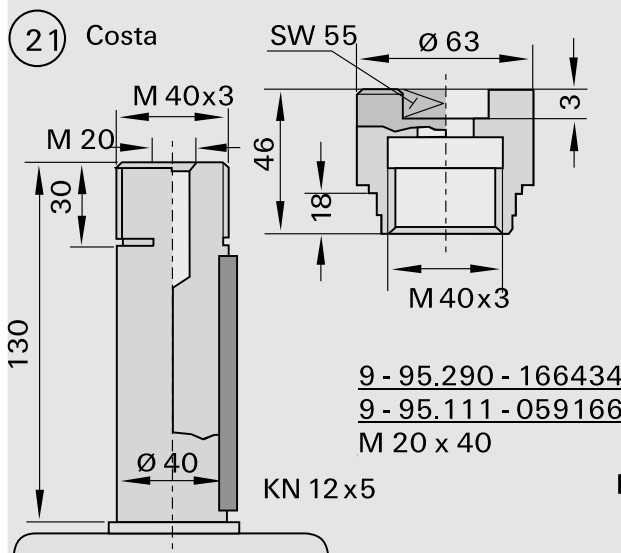
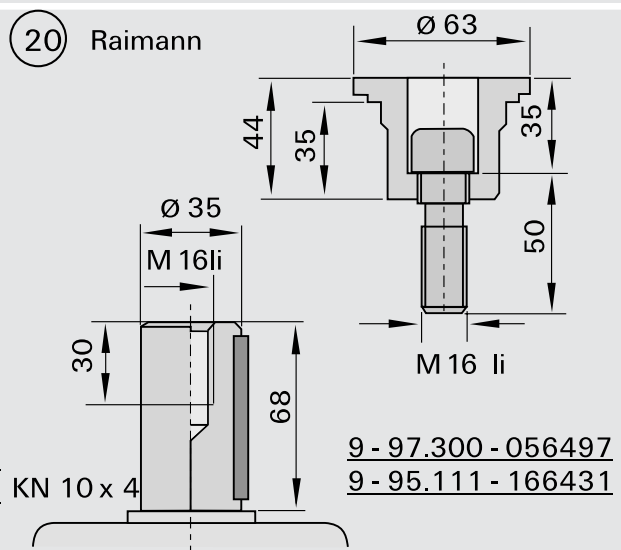
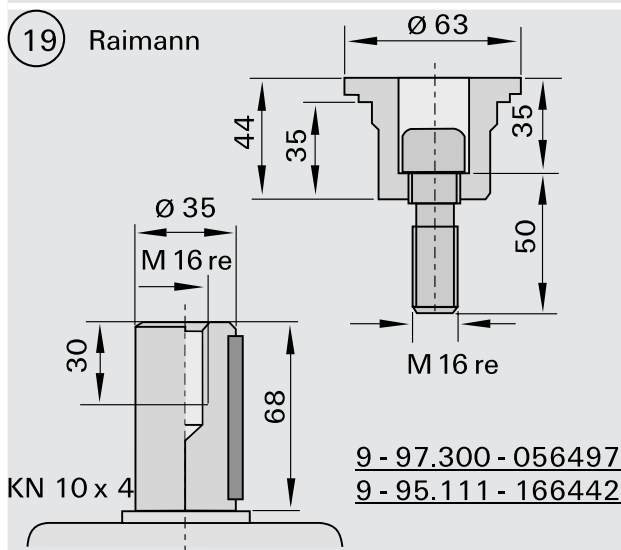
Fasteners for Jointing Cutterheads



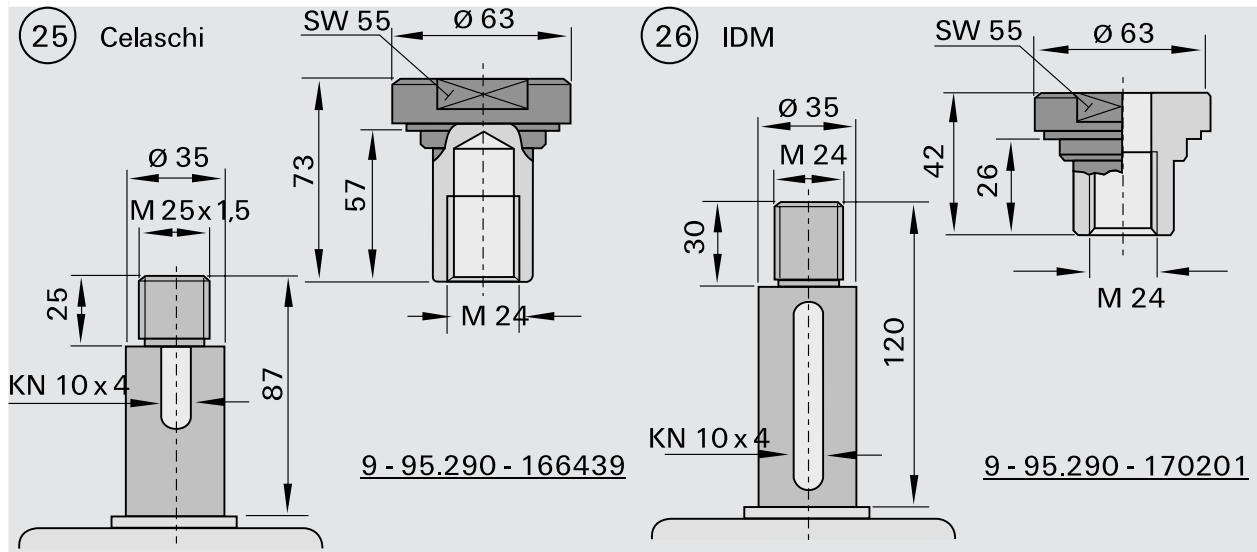
Fasteners for Jointing Cutterheads



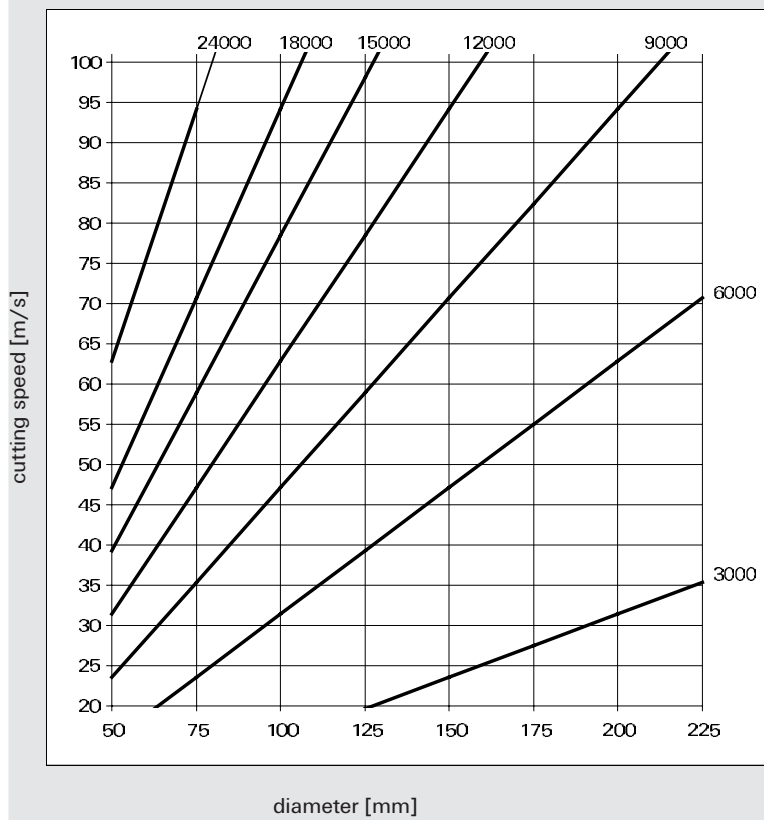
Fasteners for Jointing Cutterheads



Fasteners for Jointing Cutterheads



Determination of RPM [min-1]



Feedrate per tooth

Milling

workpiece material	feedrate 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	feedrate 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	_____	type of feed:	man	<input type="radio"/>	mec	<input type="radio"/>
machine	_____	sense of rotation:	left	<input type="radio"/>	right	<input type="radio"/>
model:	_____	mode of application:	against feed	<input type="radio"/>	with feed	<input type="radio"/>
type (e.g. DET, etc.):	_____	no. of teeth [pcs.]:	_____			
RPM range [min-1]	_____	rakers:	_____			
feedrate [m/min]:	_____	spur:	_____			

workpiece

description:	_____	edge breaker:	_____
cutting quality:	_____	arrangement of cutting edges:	
direction of cut:		shear angle: single-sided	<input type="radio"/>
		alternate	<input type="radio"/>

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"/>

coating

yes	<input type="radio"/>	no	<input type="radio"/>
description:	_____		
further information	_____		

tool

single tool	<input type="radio"/>
tool set:	
with tipped cutting edges:	<input type="radio"/>
with exchangeable cutting edges:	
EcoPro Cutterhead	<input type="radio"/>
SuperProfiler	<input type="radio"/>
UltraProfiler	<input type="radio"/>
standard	<input type="radio"/>

cutting diameter D [mm]:	_____
basic diameter D1 [mm]:	_____
cutting width B [mm]:	_____
depth of cut [mm]:	_____

interface

bore d:	_____
double keyway:	height width
keyway:	height width
clamping bushing [Ø]:	_____
hydro bushing [Ø]:	_____
Hydro-S-System:	_____
S-System:	_____

other

check if applicable

Please indicate the following on workpiece samples or drawings:

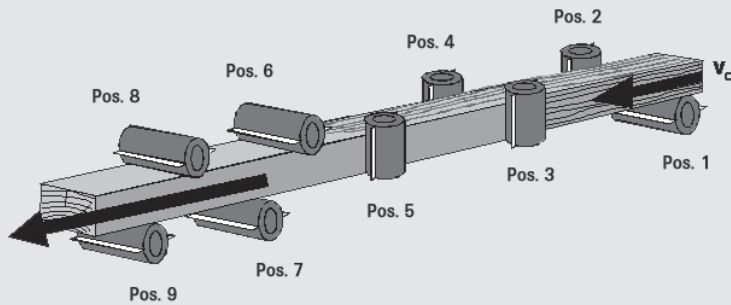
bottom side of workpiece	dimensions
sense of rotation	application conditions
motor spindle	profile drawing
hydro bushing [Ø]:	tool drawing

Please indicate clearly if the workpiece or the tool is shown.

Please indicate additional dimension and markings in the tool drawing.

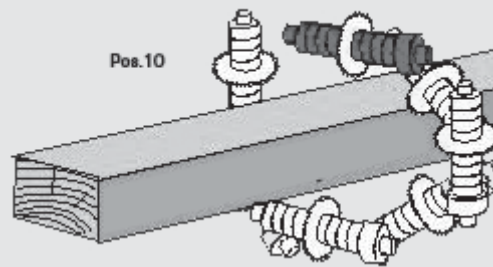
Checklist for molders (incl. „Weinig Powermat“ series)

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 (U/min): _____ 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 (U/min): _____ 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 (U/min): _____ 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 (U/min): _____ RPM variable: yes no from _____ to _____

max. vertical adjusting range (mm): _____

max. horizontal adjusting range (mm): _____

