

LEUCO

**CATALOG
SOLID WOOD PROGRAM
SW 03**



**SAWING
PLANING
PROFILING
FINGER JOINTING / JOINTING**

www.leuco.com

FIELDS OF APPLICATION FOR LEUCO TOOLS IN THE SOLID WOOD PROGRAM SW 03:



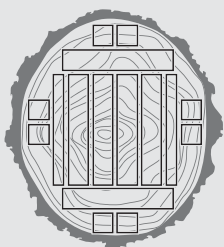
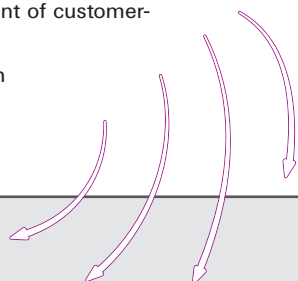
SOLID WOOD

LEUCO tools are used in the whole process chain of the woodworking industry for sawing, planing, profiling and finger jointing/jointing.

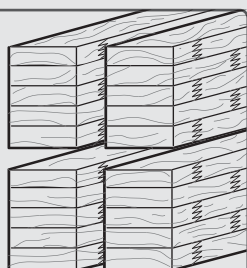
LEUCO is a manufacturer and service provider

We will be pleased to advise you: Whether it's about the selection of the most suitable tool from our standard product range or the development of customer-specific tools!

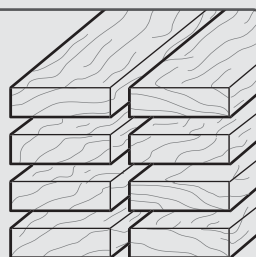
We attach great importance to offering you the best solution for your application and your machinery!



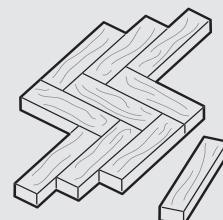
Saw mills



Beams and jointed products



Boards and planed material



Parquet

ALWAYS UP-TO-DATE: TOOLS, APPLICATION SOLUTIONS, NEWS, EVENTS ON OUR WEBSITE!



LEUCO.COM

BRANDS YOU CAN RELY ON

Cutterheads



Universal cutterhead system with standard body

LEUCO EcoPro

Flexible cutterhead system with direct knife clamping

LEUCO SetProfiler

Back-serrated knife system with large resharpenable area



High-performance diamond profile cutters for customized profiles, play-free and quick knife change



High-performance diamond profile cutters for highest feed rates

Cutting materials, coatings, and system tools



LEUCO HW cutting materials

HL Solid®

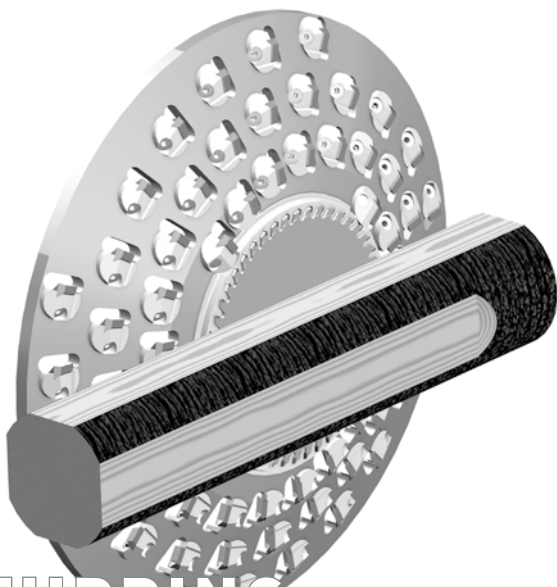
LEUCO HW cutting materials for solid wood machining



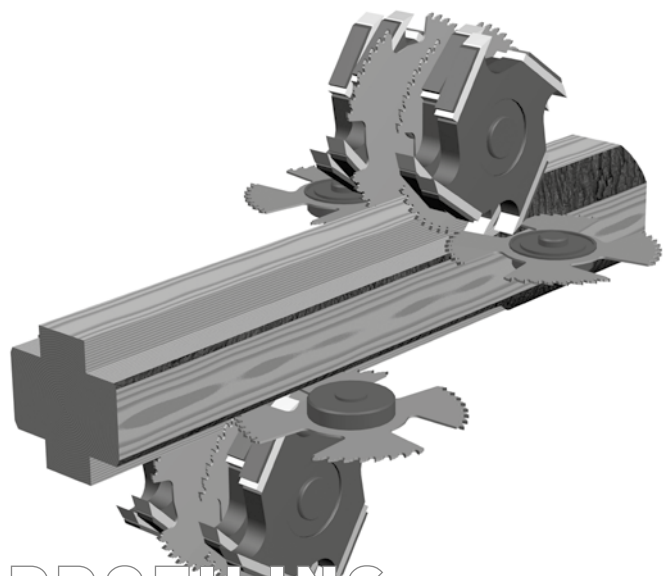
Coatings for the cutting edges, adapted for each application



Shank-type tools and bore-type cutters with a shear angle $\geq 55^\circ$ for the best cutting quality currently available on the market; long edge lives and additional applications that were previously considered technically impossible

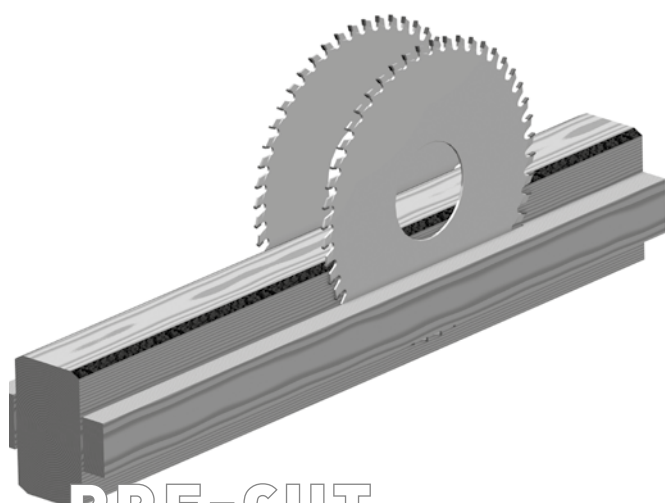


CHIPPING

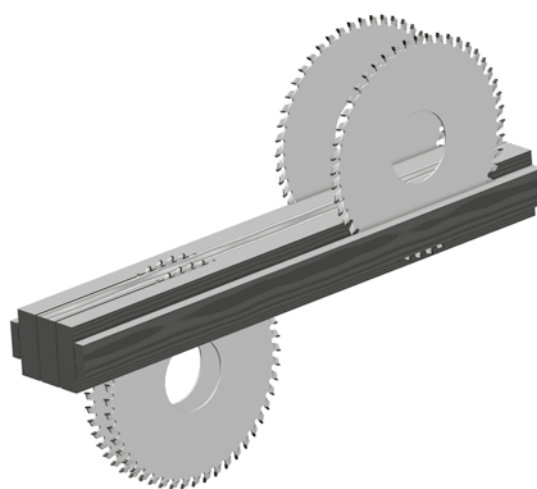


PROFILING

Sawmills



PRE-CUT



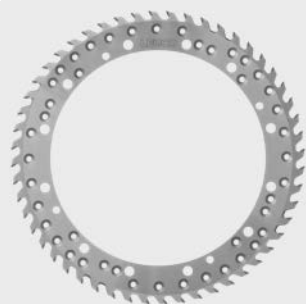
RE-CUT

Product	Page
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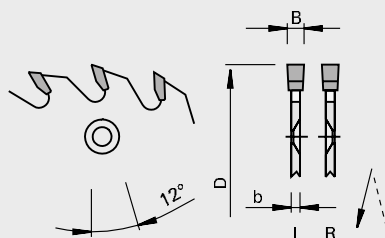
116413

Hogger Rings HW "F" - Linck

Product



Drawing

LEUCO
topline_{AS}LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

- extremely high bending strength and hardness of the teeth

Notes

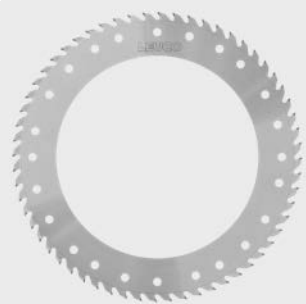
- the saw blade is optimized according to the LEUCO company standards as well as according to the customers specifications and machine parameters after consultation with the technical engineering
- Ident-No. is only for orientation

Ø D	B	b	b1	Ø D1	Ø d	Z		Ident-No. [L]	Ident-No. [R]
576	4,5	3.5	6.0	531	422	52	Linck V25	80347850 S	80347849 S
724	4,5	3.5	6.0	684	586	64	Linck VM45	80371095 S	80371094 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

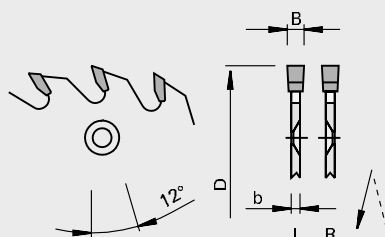
116413

Hogger Rings HW "F" - EWD

Product



Drawing

LEUCO
topline_{AS}LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

- extremely high bending strength and hardness of the teeth

Notes

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

Ø D	B	b	b1	Ø D1	Ø d	Z		Ident-No. [L]	Ident-No. [R]
745	6,6	5.0	6.0	700	520	60	EWD PF19	80291614 S	80291613 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				

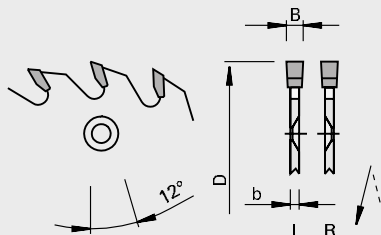
116410 / 116413

Hogger Rings HW "F"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

- extremely high bending strength and hardness of the teeth

Notes

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

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

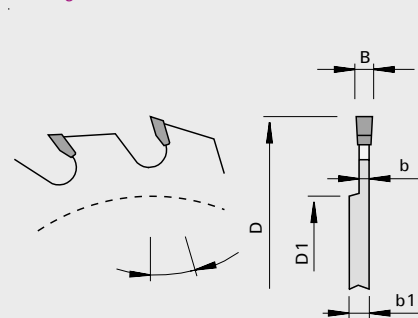
116313

HW Segments - for Linck VPM profiling aggregate

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

extremely high bending strength
and hardness of the teeth

Notes

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

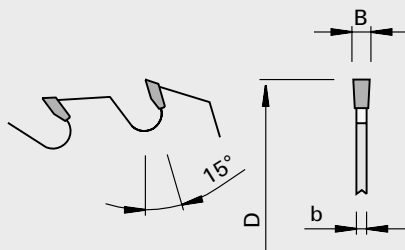
101310

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

extremely high bending strength
and hardness of the teeth

Notes

Ø D	B	b	Ø d	Z	Ident-No.	
566	5,0	4,0	80	36	80350084 S	
[mm]	[mm]	[mm]	[mm]			

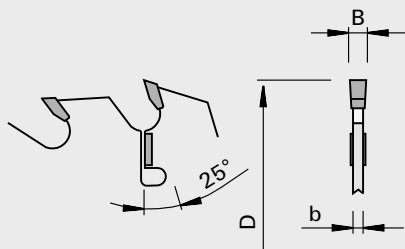
101315

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

extremely high bending strength
and hardness of the teeth

Notes

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

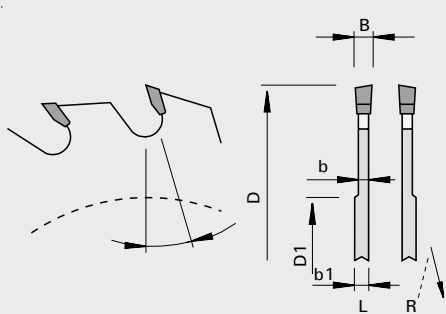
101353

Gang-Rip Saw Blades HW “ES” - for profiling aggregate HewSaw

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

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

Design

tooth configuration: top bevel “ES”
cutting material: HW HL Board 20

Advantages

extremely high bending strength and hardness of the teeth

Notes

Ø D	B	b	b1	Ø D1	Ø d	Z	DKN	Free slots	Ident-No. [L]	Ident-No. [R]
250	5,2	3.6	6.0	115	70	24-6	20x8	3	80363728 S	80363727 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]	[pc.]		

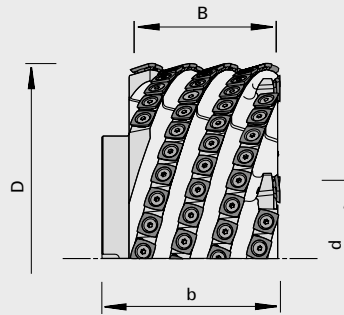
120281

p-System Profile Cutters HW

Product



Drawing

**LEUCO**
p-system

Tungsten Carbide [HW]

MEC

Machine / Application

- machine
- EWD FR15, FR16
- Linck VPF340
- for milling of corners / profiling

Design

- one part and segmented
- turnover knives can be used on all four sides
- extremely scoring cut
- cutting material: HW HL Solid 20

Advantages

- no chippings due to knots
- considerable improvement of surface quality compared to the existing chipping knives
- small chips suitable for pellet production
- extremely long edge lives (up to 8 million running meters)

Notes

- chips are not suitable for paper industry
- feed rate per tooth $f_z = 2-8$ mm

Ø D	B	b	Ø d	Z	Shear∠		
360	139,5	164	110	8+8	70	vertical axis top	EWD
360	139,5	164	110	8+8	70	vertical axis bottom	EWD
402	139	164	110	8+8	70	vertical axis top	EWD
402	139	164	110	8+8	70	vertical axis bottom	EWD
402	121	139	120/200	8+8	70	vertical axis top	Linck
402	121	139	120/200	8+8	70	vertical axis bottom	Linck
360	64	164	60	4+4	70	horizontal axis right	EWD
360	64	164	60	4+4	70	horizontal axis left	EWD
360	64	164	60	5+5	70	horizontal axis right	EWD
360	64	164	60	5+5	70	horizontal axis left	EWD
360	64	164	60	8+8	70	horizontal axis right	EWD
360	64	164	60	8+8	70	horizontal axis left	EWD
360	89,2	164	60	6+6	70	horizontal axis right	EWD
360	89,2	164	60	6+6	70	horizontal axis left	EWD
[mm]	[mm]	[mm]	[mm]		[°]		

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
for Ø D=360 mm	21	21	5.5	HL Solid 60	150569	10	186110 L
for Ø D=402 mm	21	21	5.5	HL Solid 60	150569	10	186111 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts		Dimension	Class-No.	PU	Ident-No.
Head Cap Screws		M14x60-12.9 DIN EN ISO 4762	995111	10	185008 L
Head Cap Screws		M14x80-12.9 DIN EN ISO 4762	995111	10	185181 L
Countersunk Screws		M7x17 T30 10.9	995125	10	185643 L
Conical Screws		M6x10 D7.8x20GRD 10.9	995191	10	184891 L
Repair set	thread inserts, twist drills, hand tap, spindle insert, tang break-off tool	M7	985200	1	185881 C
Helicoil®		M7x10,5	995490	10	50930340 L
		[mm]		[pc.]	

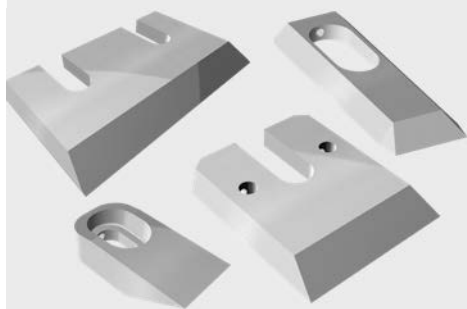
Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for Ø D=360 mm left and Helicoil® d=7.5 mm	997600	1	186440 S
Drilling fixture	for Ø D=360 mm right and Helicoil® d=7.5 mm	997600	1	186441 S
Drilling fixture	for Ø D=360 mm left and core hole d=5.5 mm	997600	1	186442 S
Drilling fixture	for Ø D=360 mm right and core hole d=5.5 mm	997600	1	186443 S
Drilling fixture	for Ø D=402 mm left and Helicoil® d=7.5 mm	997600	1	186444 S
Drilling fixture	for Ø D=402 mm right and Helicoil® d=7.5 mm	997600	1	186445 S
			[pc.]	

Accessories		Class-No.	PU	Ident-No.
Drilling fixture	for Ø D=402 mm left and core hole d=5.5 mm	997600	1	186446 S
Drilling fixture	for Ø D=402 mm right and core hole d=5.5 mm	997600	1	186447 S
				[pc.]

332321

Knives - Linck

Product



Drawing



High Speed Steel [HS]

Machine / Application

I Linck
I for hogger lines

Design

I cutting material: HS for the
machining of soft woods

Advantages

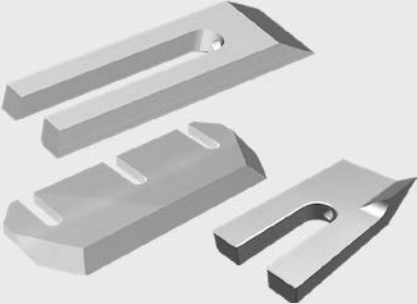
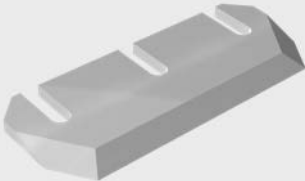
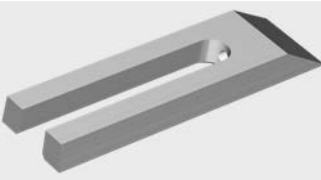
Notes

I packing unit 10 pieces

		Dimension		LEUCODUR	Ident-No.
	Chipping knives - Linck	105x41x8	1 long hole 1 threads M5 on the back	HS	185542 C
		[mm]			
	Chipping knives - Linck	105x92x12	1 opening 2 threads M6 on the back	HS	185540 C
		[mm]			
	Chipping knives - Linck	184x108x14	2 openings 2 threads M6 on the back	HS	185541 C
		[mm]			
	Finishing knives - Linck	76x35x20	1 thread M6 on back with chamfer edge of 20 mm/8° HS		185543 S
		[mm]	sides straight		

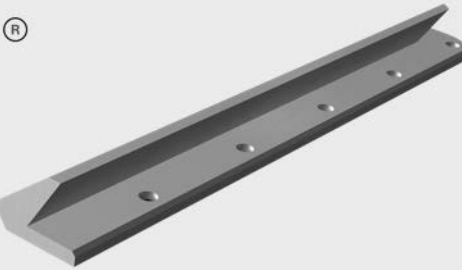
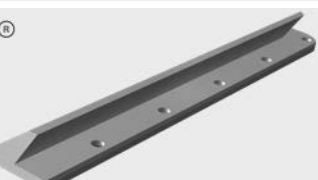
332321

Knives - EWD

Product		Drawing			
				 High Speed Steel [HS]	
Machine / Application	Design	Advantages		Notes	
I EWD I for hogger lines	I cutting material: HS for the machining of soft woods			I packing unit 2 pieces	
		Dimension	LEUCODUR		Ident-No.
		Rotor knives - EWD	289x115x12 [mm]	3 openings 2 threads M6 on the back side chamfer 29° side bevel 34° HS	185544 L
		Dimension	LEUCODUR		Ident-No.
		Chipping knives - EWD	153x40x14,5 [mm]	1 openings 1 threads M6 HS	186494 L
		Dimension	LEUCODUR		Ident-No.
		Chipper Knives - EWD	15,9/9x75x39 [mm]	1 openings 1 threads M5 HS	R 186514 S
		Chipper Knives - EWD	15,9/9x75x39 [mm]	1 openings 1 threads M5 HS	L 186515 S

332321

Chip Breakers - EWD

Product		Drawing			
				 High Speed Steel [HS]	
Machine / Application	Design	Advantages		Notes	
I EWD systems		I optimized chip breaking		I packing unit 2 pieces	
		Dimension	LEUCODUR		Ident-No.
		Chip Breakers - EWD	274x43x25 [mm]	HS	R 186470 S
		Chip Breakers - EWD	274x43x25 [mm]	HS	L 186469 S

332321

Knives - Veisto HewSaw

Product

Drawing



High Speed Steel [HS]

Machine / Application

Veisto HewSaw
for hogger lines

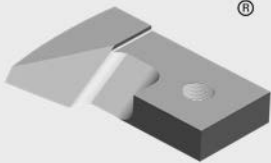
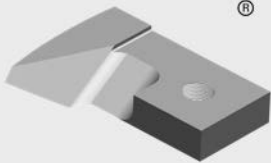
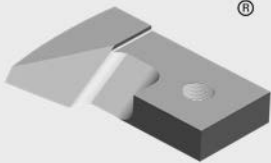
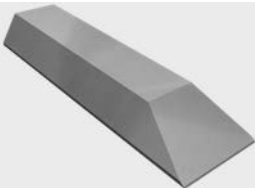
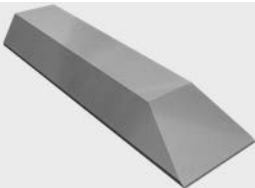
Design

cutting material: HS for the
machining of soft woods

Advantages

Notes

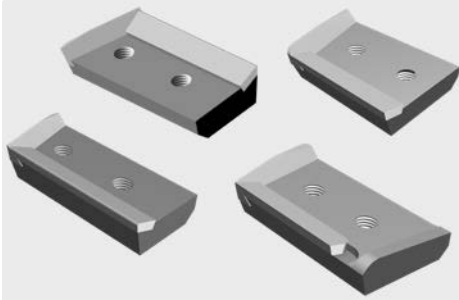
packing unit 2 pieces

	Dimension		LEUCODUR		Ident-No.
	Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	R 185882 C
	Knives - Veisto HewSaw	72x53x34/27,9	1 threads M12	HS	L 185883 C
		[mm]			
	Dimension		LEUCODUR		Ident-No.
	Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	R 185884 C
	Knives - Veisto HewSaw	94,5x19,9x74,5/45	1 threads M16	HS	L 185885 C
		[mm]			
	Dimension		LEUCODUR		Ident-No.
	Chipping knives - Veisto HewSaw	82x25x10	1 threads M6 on the back	HS	186449 S
		[mm]			

132321

Peel Knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

| for hogger lines

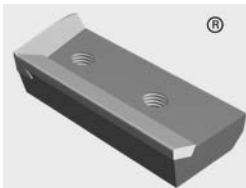
Design

| cutting material: HW HL Solid
20 for hard and soft woods

Advantages

Notes

| packing unit 2 pieces



Dimension

LEUCODUR

Ident-No.

Peel Knives

49,5x103x23

2 threads M12

HW

R

185886 S

Peel Knives

49,5x103x23

2 threads M12

HW

L

185887 S

[mm]



Dimension

LEUCODUR

Ident-No.

Peel Knives

90x60x21

2 threads M12

HW

R

185889 C

Peel Knives

105x60x20

2 threads M12

HW

R

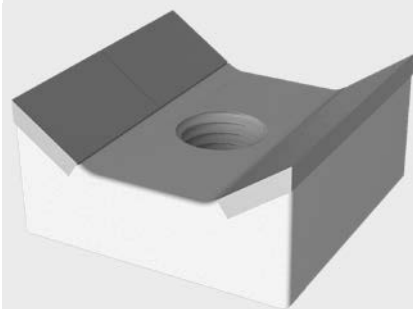
185888 C

[mm]

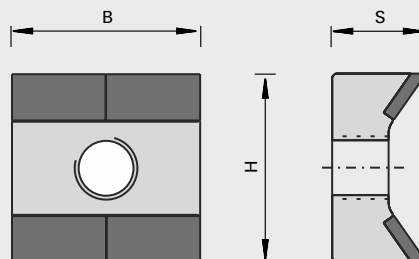
132271

Chipping knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

| Shredding machines for
particle boards
| for shredding of scrap panels to
reuse the chips

Design

| HW design to shred particle
boards

Advantages

| HW design with a higher edge
life than conventional steel
cutting knives

Notes

| Other versions available on
request

B	H	S	PU	Ident-No.
60	60	30	80	80479564 C
[mm]	[mm]	[mm]	[pc.]	

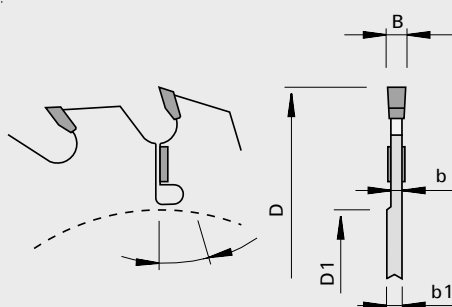
101315 / 101317

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

Product



Drawing

LEUCO
topline
A/SLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

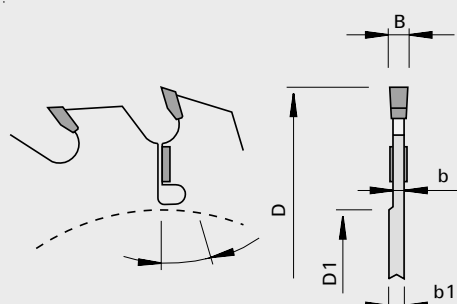
101317

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

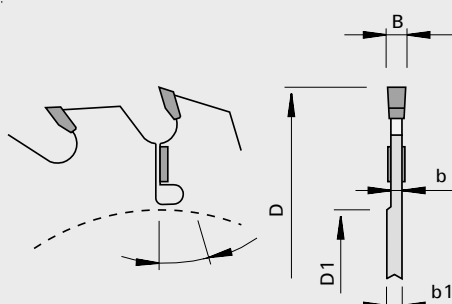
101317

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

Product



Drawing

LEUCO
topline
7/15LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

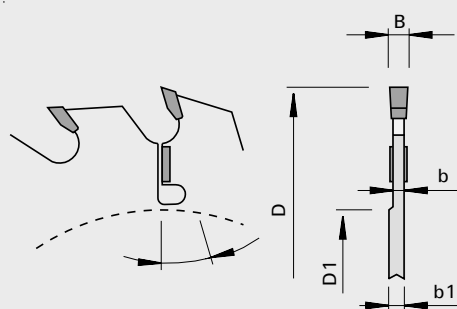
101315 / 101317

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	b1	Ø D1	Ø d	Z	Number of rakers	DKN		Ident-No.
520	3,6	2.2			150	36	4	37x10	Linck MKV	80231924 S
520	4,6	3.2			150	28	6	37x10	Linck MKV	80255324 S
540	4,8	3.4			150	24	4	37x10	Linck MKV	80254014 S
540	4,4	2.8	4.9	230	150	28	6	37x10	Linck MKV	80259614 S
540	3,2	2.0			150	46	4	37x10	Linck MKV	80273199 S
540	3,4	2.1	3.9	345	150	45	6	37x10	Linck MKV	80337192 S
540	4,0	2.6			150	36	6	36,5x9	Linck MKV	80293102 S
540	4,0	2.6			150	30	6	36,5x9	Linck MKV	80307378 S
545	2,8	1.8			150	57	3	37x10	Linck MKV	80326780 S
570	4,8	3.4			150	20	6	37x10	Linck MKV	80270360 S
570	3,2	2.2	4.6	400	150	54	6	37x10	Linck MKV	80293546 S
570	2,9	1.9	3.9	400	150	56	6	37x10	Linck MKV	80332037 S
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

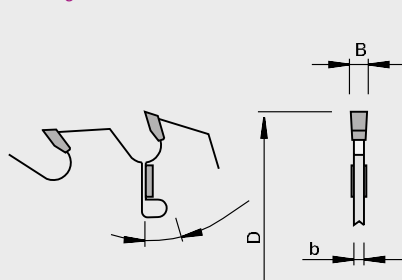
101315

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

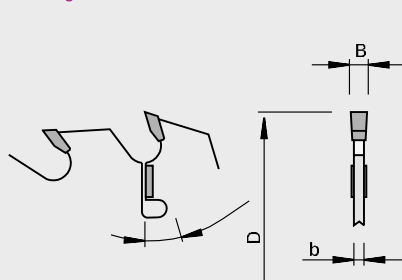
101316

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

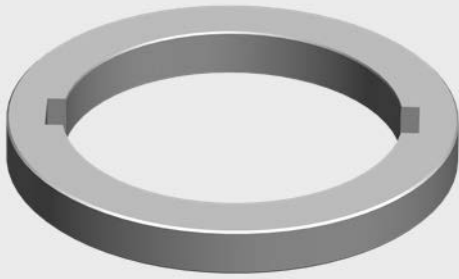
Notes

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

955520

Spacer rings - steel

Product



Notes

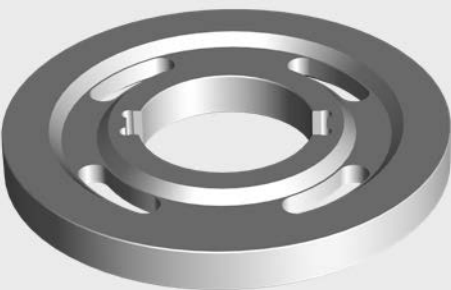
- | Spacer rings for sawmills
- | Other designs and dimensions on request

Ø D	B	Ø d	DKN	Ident-No.
150	0,5	115	29x131	80370453 C
150	1,0	115	29x131	80370454 C
190	2,0	150	36,3x167	80383237 O
190	3,0	150	36,3x167	80383238 O
190	5,0	150	36,3x167	80383239 O
190	10,5	150	37x170	80387052 O
190	11,5	150	37x170	80387053 O
190	12,5	150	37x170	80387054 O
190	40,4	150	37x170	80387912 C
200	1,0	150	37x157,8	80291659 C
200	2,0	150	37x157,8	80291660 C
200	3,0	150	37x157,8	80291661 C
200	6,8	150	37x157,8	80404151 C
200	21,6	150	37x157,8	80291663 C
200	31,6	150	37x157,8	80291662 S
220	10,4	150	37x170	80283020 O
270	10	150	36,3x167	80363407 O
270	30	150	36,5x168	80386011 O
270	150	150	36,3x167	80354756 S
320	10,4	150	37x170	80283019 O
[mm]	[mm]	[mm]	[mm]	

955520

Spacer rings - aluminum, stepped

Product



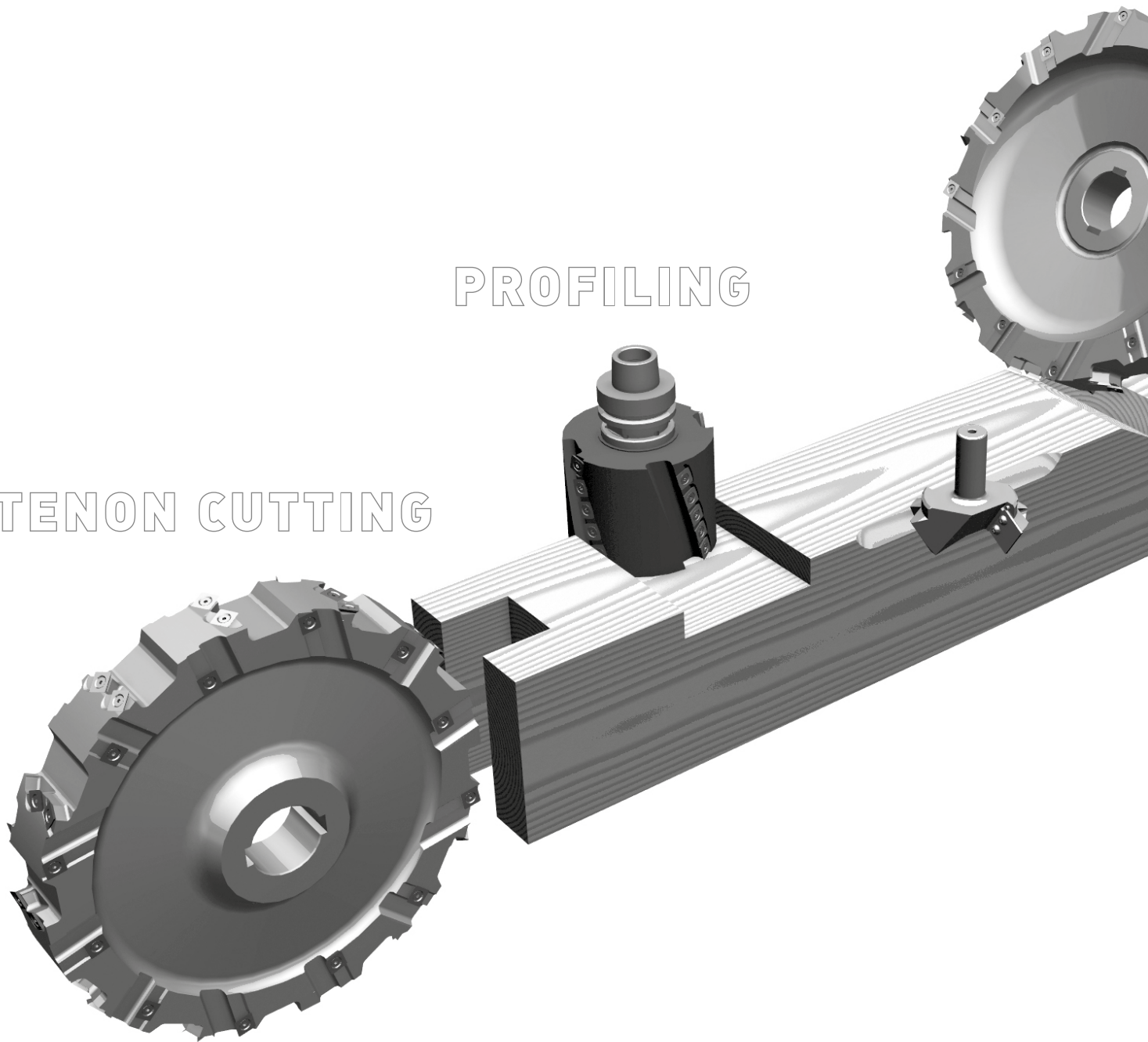
Notes

- | Spacer rings for sawmills
- | Other designs and dimensions on request

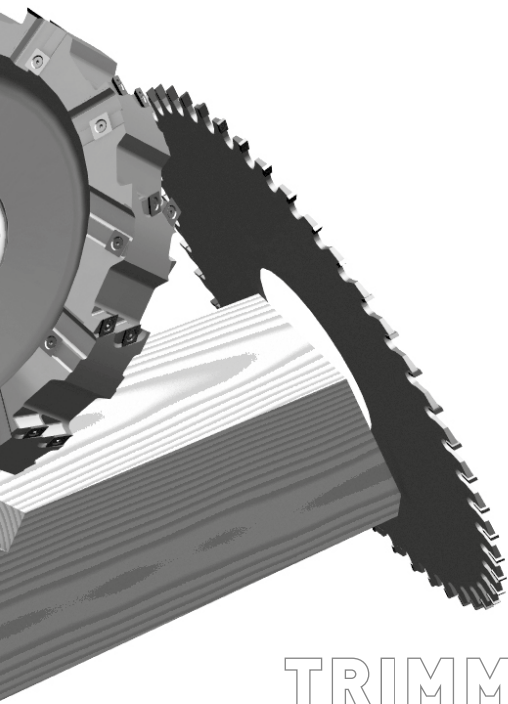
Ø D	B	Ø d	DKN	Ident-No.
380	37,7	150	37x170	80187182 S
[mm]	[mm]	[mm]	[mm]	

PROFILING

TENON CUTTING



Joinery Technique



TRIMMING

Product	Page
Sawing	21
Milling	25

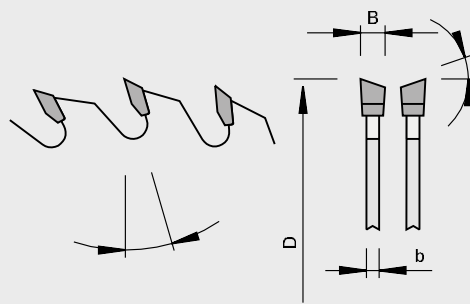
101320

Sizing Saw Blades HW "WS" - Weinmann

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

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

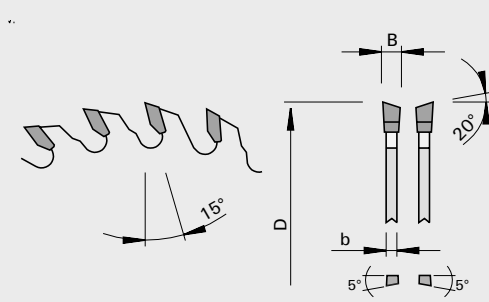
101320

Double Clipping Saw Blades HW with cooling slots "WSA"

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

Ø D	B	b	Ø d	Z	DKN	NL	Ident-No.
350	4,0	2.6	30	54		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189788 L
400	4,4	3.0	30	60		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189789 L
450	4,4	3.0	30	72		2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	189790 L
500	4,8	3.2	30	72		2/10/80	189792 L
500	4,8	3.2	30	108		2/10/80 + 2/15/63	189794 L
500	4,0	3.2	70	108	20x6		192954 L
550	4,8	3.2	30	72		2/10/80	189795 L
630	5,4	4.0	40	72		2/10/60	189797 C
650	5,6	4.0	30	96		2/10/80 + 2/15/63 + 2/14/100	189798 L
650	5,6	4.0	30	54		2/10/80 + 2/15/63	189799 C
720	6,2	4.4	30	48		Hundegger 2/8,5/90	189800 C
735	6,2	4.4	30	48		Hundegger 2/8,5/90	189802 C
735	6,2	4.4	30	72		Hundegger 2/8,5/90	189803 C
760	6,2	4.4	30	48		Hundegger 2/14/400 + 4/8,5/90	189804 C
760	6,2	4.4	30	72		Hundegger 2/14/400 + 4/8,5/90	189805 C
760	6,2	4.4	30	96		Hundegger 2/14/400 + 4/8,5/90	189806 L
800	6,2	4.4	30	48		Paul	189807 C
[mm]	[mm]	[mm]	[mm]		[mm]		

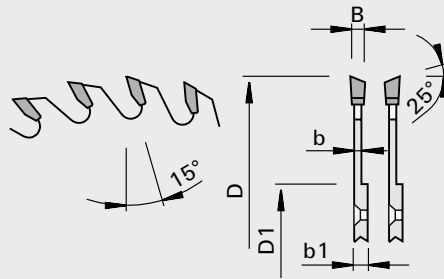
101327

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

l extremely high bending strength and hardness of the teeth

Notes

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

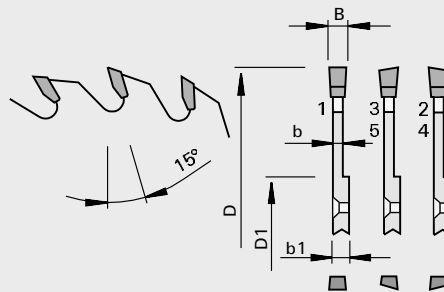
101347

Clipping Saw Blades HW with cooling slots - crosscut- and shifter cuts "G5"

Product



Drawing

LEUCO
g5 systemLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

l positive hook angle
l with cooling elements
l tooth configuration: "G5"
l cutting material: HW HL Board 20

Advantages

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

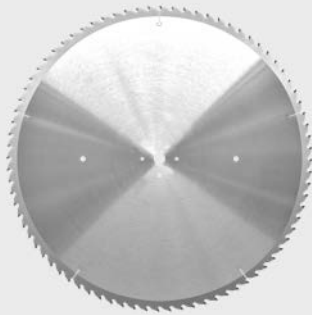
Notes

Ø D	B	b	b1	Ø D1	Ø d	Z	NL	Ident-No.
555	5,2	3.6	6.0	115	55	70	6/6,6/75 Weinmann	193220 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			

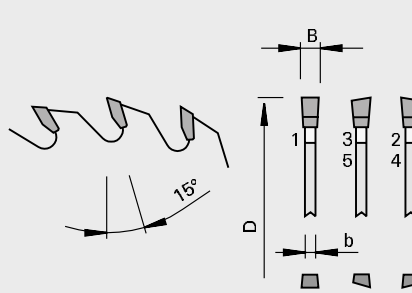
101340 / 101345

Clipping Saw Blades HW - joinery "G5"

Product



Drawing

LEUCO
G5 systemLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

l positive hook angle
l tooth configuration: "G5"
l cutting material: HW HL Board
09

Advantages

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

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
450	4,4	3.0	30	65	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42	80481000 L
450	5,0	3.5	45	65	2/15/63	80481001 C
500	4,8	3.2	30	110	2/10/80 + 2/15/63	80481002 L
500	4,8	3.2	30	70	2/10/80 + 2/15/63	80481003 L
500	5,6	4.0	30	95	2/10/80	80481004 L
550	4,8	3.2	30	70	2/10/80	80481006 L
550	4,8	3.2	40	70		80481007 O
600	5,4	4.0	30	70	2/10/80 + 2/13/100	80481009 C
600	5,7	4.0	30	95	2/11/60 + 2/13/100	80481010 L
600	5,4	3.8	40	70		80481011 C
650	5,6	4.0	30	95	2/15/63 + 2/10/80 + 2/14/100	80481013 C
650	6,2	4.0	30	60		Krüsi 80481014 C
700	6,0	4.2	30	80	2/11/60 + 2/13/100	80481015 C
720	6,2	4.4	30	70	2/8,5/90	Hundegger 80481016 C
750	6,5	4.5	30	60	2/10,5/60	80481018 C
750	7,0	4.8	60	120		Springer 80481019 C
760	6,2	4.4	30	95	4/8,5/90 + 2/14/400	Hundegger 80481020 C
800	6,5	5.0	30	80	4/9/90 + 2/14/400 + 8/9/160	Hundegger 193097 L
[mm]	[mm]	[mm]	[mm]			

Ø D	B	b	Ø d	Z	NL	Ident-No.
500	4,2	2.8	30	35+2+2		Krüsi 80481005 L
550	4,6	3.2	30	35+2+2+2		Krüsi 80481008 C
640	5,4	3.6	30	40+2+2		Mafell 80481012 C
750	6,5	4.5	40	50+2+2	2/10,5/60	Krüsi, Schneider 80481017 C
[mm]	[mm]	[mm]	[mm]			

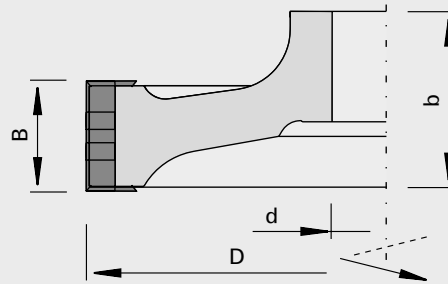
120261

Tenoning Cutterheads surfCut HW

Product



Drawing

LEUCO
surfCut

Tungsten Carbide [HW]

MEC

Machine / Application

l Hundegger, Weinmann joinery centers
l for milling tenons, lap joints, profiles and notches

Design

l with shear angle
l with four-sided turnover knives
l spurs HW
l high-tensile aluminum body

Advantages

l high milling performance
l less rework
l clean-cut look
l variable use
l reduced frequency of cutting edge replacement
l longer edge life

Notes

l for HSK mounting arbors with double key without spacer
l exact dimensions and hub design to be cleared with the LEUCO Application Engineering Dept.

Ø D	B	b	Ø d	Z	DKN		Ident-No.
250	125	125	55	4+4		Weinmann	186169 S
300	20	80	55	4+4		Weinmann	186170 S
300	40	80	55	4+4		Weinmann	186171 S
350	40	75	55	4+4	16x4,3	Hundegger	186174 C
350	20	75	55	4+4	16x4,3	Hundegger	186175 S
350	60	75	55	4+4	16x4,3	Hundegger	186176 C
[mm]	[mm]	[mm]	[mm]		[mm]		

Turnover Knives	B	H	S	LEUCODUR	For Ident-No.	Class-No.	PU	Ident-No.
	13,8	13,8	2,5	HL Solid 20	186170, 186175	150567	10	184942 L
	20,6	20,6	5,5	HL Solid 30	186169, 186171, 186174, 186176	150568	10	186667 L
	[mm]	[mm]	[mm]				[pc.]	

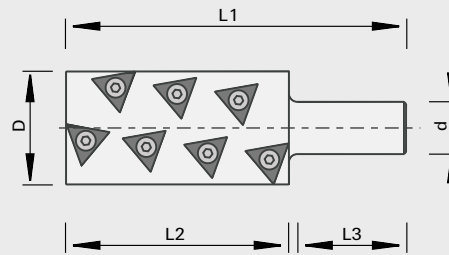
128260

Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing


LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC and joinery machines
 | For offset- and chip-free
 jointing, rabbeting and sizing of
 solid wood

Design

| Rounded triangular turnover
 knives with cutting edges
 drawing from bottom to top
 and from top to bottom
 | Cutting material: HW
 | HL Solid 20 for hard wood and
 soft wood
 | HL Board 06 for wood-based
 materials, plastics and hard
 woods
 | topcoat coating for increased
 edge lives

Advantages

| absolutely chip-free jointing and
 rabbeting
 | Thanks to the rounded turnover
 knives the machined surface is
 offset-free
 | excellent edge and surface
 quality
 | very high milling performance
 | spiral plunge-cutting for free
 form milling
 | Triangular turnover knives with
 rounded edges 3 edge lives

Notes

| spiral plunge-cutting, pockets
 larger than Ø 60
 | feed rate per tooth fz =
 0.2-0.5 mm
 | turnover knife 9209773
 scoring without projection,
 suitable for jointing without
 groove

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	78	20	52	133.5	2+2	14	187268 L
54	63	25	52	120	2+2	12	187299 L
54	78	25	52	133.5	2+2	14	187300 L
54	106,5	25	52	162.5	2+2	18	187113 L
61	79,1	25	52	139.2	2+2	14	187330 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives

B	H	S	Class-No.	PU	Ident-No.
20,38	17.9	3.0	HL Solid 20	150557 10	9209773 L
20,88	18.3	3.0	HL Board 06	150566 10	187692 L
20,88	18.3	3.0	HL Solid 20	150567 10	187251 L
20,88	18.3	3.0	HL Solid 20 topcoat	150667 10	187694 L
[mm]	[mm]	[mm]			[pc.]

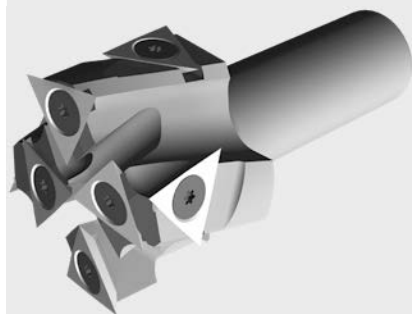
Spare parts

	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
Lock washer with screw	D=26 / M6x16	997300	1	9260834 L
	[mm]			[pc.]

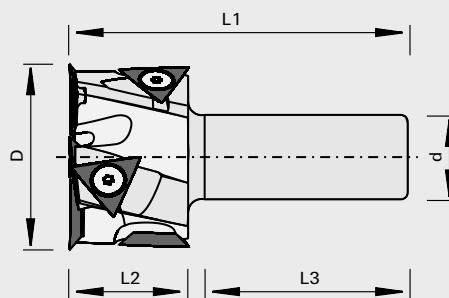
128260

Rabbeting Shank-Type Cutters with HW Turnover Knives - t3-System

Product



Drawing

LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

l CNC and joinery machines
l for offset and chip-free
rabbeting of solid wood and
wood-based materials

Design

l Rounded triangular turnover
knives with cutting edges
drawing from top to bottom
l also for rabbets <21 mm
l Cutting material: HW
l HL Solid 20 for hard wood and
soft wood
l HL Board 06 for wood-based
materials, plastics and hard
woods
l topcoat coating for increased
edge lives

Advantages

l absolutely chip-free rabbeting
l Thanks to the rounded turnover
knives the machined surface is
offset-free
l excellent edge and surface
quality
l very high milling performance
l spiral plunge-cutting for free
form milling
l Triangular turnover knives with
rounded edges 3 edge lives

Notes

l spiral plunge-cutting, pockets
larger than Ø 60
l feed rate per tooth fz =
0.2-0.5 mm
l turnover knife 9209773
scoring without projection,
suitable for jointing without
groove

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
54	35	25	61	100	2+2	8	187269 C
61	35	25	61	100	2+2	8	187369 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives

B	H	S	Class-No.	PU
20,38	17.9	3.0	HL Solid 20	150557 10 9209773 L
20,88	18.3	3.0	HL Solid 20	150567 10 187251 L
20,88	18.3	3.0	HL Solid 20 topcoat	150667 10 187694 L
20,88	18.3	3.0	HL Board 06	150566 10 187692 L
[mm]	[mm]	[mm]		[pc.]

Spare parts

	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
Lock washer with screw	D=26 / M6x16	997300	1	9260834 L
	[mm]		[pc.]	

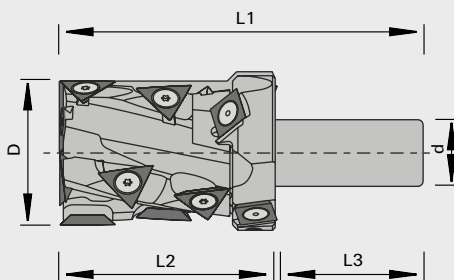
128260

Socket hole milling cutter HW - t3-System

Product



Drawing

LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

Joinery machines, e.g. Hundegger, Weinmann, Krüsi
for milling of socket holes in soft and hard wood, glued laminated timber, wood and panel materials as well as gypsum board and hardwood laminated, beech veneer lumber

Design

Rounded triangular turnover knives with cutting edges drawing from top to bottom
Cutting material: HW
HL Solid 20

Advantages

Drilling and chamfering 2x45° in the same operation
Thanks to the rounded turnover knives the machined surface is offset-free
Excellent edge and surface quality
Very high milling performance
spiral plunge-cutting for free form milling
Triangular turnover knives with rounded edges, 3 edge lives

Notes

Ø D	L2	Ø d	L3	L1	Z	Number of cutting edges	Ident-No.
61	80	25	55	136.5	2+2+2	16	80479566 C
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

Turnover Knives	B	H	S	LEUCODUR	Class-No.	PU	Ident-No.
	14	14	2.0	HL Solid 30	150558	10	003079 L
	20,38	17.9	3.0	HL Solid 20	150557	10	9209773 L
	20,88	18.3	3.0	HL Solid 20	150567	10	187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667	10	187694 L
	20,88	18.3	3.0	HL Board 06	150566	10	187692 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts

Dimension

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T20x100	985730	1	166092 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
	[mm]		[pc.]	

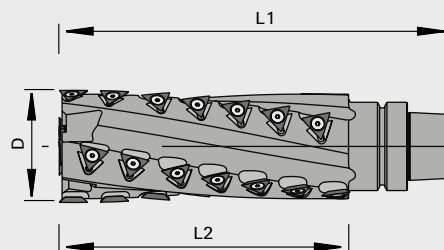
128260

Monolithic shank-type cutter HSK 63E with turnover knives - t3-System

Product



Drawing


LEUCO
t3system

Tungsten Carbide [HW]

MEC

Machine / Application

| CNC and joinery machines
 | for shoulder- and chip-free
 jointing, rabbeting and sizing
 of soft and hard wood, glued
 laminated timber, wood and
 panel materials as well as
 gypsum board and hardwood
 laminated, beech veneer
 lumber

Design

| Triangular turnover knives with
 rounded cutting edges drawing
 from bottom to top and from
 top to bottom
 | Monolithic design thanks to the
 removal of the interface

Advantages

| Absolutely chip-free jointing and
 rabbeting
 | Thanks to the rounded turnover
 knives the machined surface is
 offset-free
 | Excellent edge and surface
 quality
 | Very high milling performance
 | spiral plunge-cutting for free
 form milling
 | Triangular turnover knives with
 rounded edges, 3 edge lives
 | further optimization of the
 concentricity due to the removal
 of the interface

Notes

Ø D	L2	Ø d	L1	Z	Number of cutting edges	Ident-No.
80	207,6	HSK 63E	280.5	2+2	32	80482108 C
[mm]	[mm]	[mm]	[mm]		[pc.]	

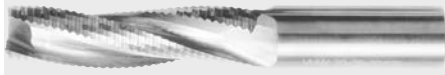
Turnover Knives	B	H	S	Class-No.	PU
	20,38	17.9	3.0	HL Solid 20	150557 10 9209773 L
	20,88	18.3	3.0	HL Solid 20	150567 10 187251 L
	20,88	18.3	3.0	HL Solid 20 topcoat	150667 10 187694 L
	20,88	18.3	3.0	HL Board 06	150566 10 187692 L
	[mm]	[mm]	[mm]		[pc.]

Spare parts / Accessories	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x9 T15	995125	10	80492032 L
Screwdrivers	T15x100	985730	1	80504539 L
Torque Screwdrivers without insert	4,2 Nm	985730	1	80504561 L
	[mm]		[pc.]	

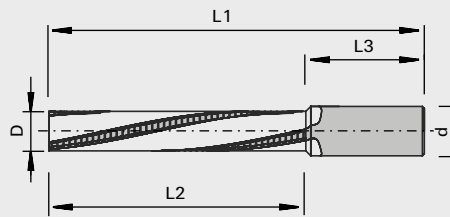
129450

Roughing Cutters VHW - joinery machines

Product



Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| Joinery machines
 | Portal processing systems
 | for separating, sizing, grooving, drilling and milling of soft and hard wood, glued laminated timber, gluelam construction timber and solid wood boards

Design

| Roughing cutters VHW for long edge life
 | Shaft for shrinking or stepped shaft for collet chuck ER 40 (Hundegger shaft)
 | Central cutting edge

Advantages

| positive spiral direction for improved chip evacuation
 | Roughing tool for larger chip versions

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No.	
20	75	20	55	130	3	R	80484531 C
20	135	20	55	190	3	R	80484532 C
20	175	20	45.8	230	3	R	80484518 C
20	130	25	60	190	3	R	80484522 C
20	130	25	57.5	190	3	R	80484523 C
25	55	25	60	115	3	R	80484530 C
25	55	25	53	115	3	Hundegger shaft	R 80484533 C
25	145	25	60	210	3	R	80452219 C
25	170	25	60	230	3	R	80484519 C
25	190	25	60	250	3	R	80484520 C
30	120	30	53	195	3	Hundegger shaft	R 80484529 C
30	125	30	53.5	195	3	Hundegger shaft	R 80371692 C
30	125	30	53.5	195	3	Hundegger shaft	L 80371693 C
30	180	30	60	250	3	R	80484521 C
40	120	30	60	190	3	R	80484524 C
40	120	30	53	195	3	Hundegger shaft	R 80484528 C
40	160	30	53	235	3	Hundegger shaft	R 80484527 C
40	170	30	60	250	3	R	80484525 C
40	180	30	60	250	3	R	80484526 C
[mm]	[mm]	[mm]	[mm]	[mm]			

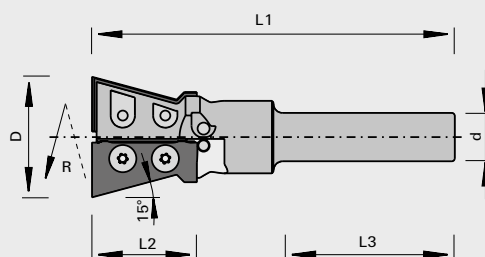
128610

Dove-tail Cutterheads with HW Knives

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

for joinery machines Weinmann
for joining of construction
timber and for machining of
solid wood

Design

cutting edges parallel to cutter
axis
cutting material: HW HL Solid
20
n max = 17,800 min-1

Advantages

Notes

Ø D	L2	Ø d	L3	L1	Z	Ident-No. [L]
40	34,7	16	56	120	2	185617 L
60	34,9	25	56	120	3	80374550 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Knives	B	H	S	Class-No.	PU	Ident-No.
without serration	34,9	18.6	2.0	151587	2	185363 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M4x5,9 T15	995195	10	167966 L
Screwdrivers	T15	985730	1	163161 L
	[mm]		[pc.]	

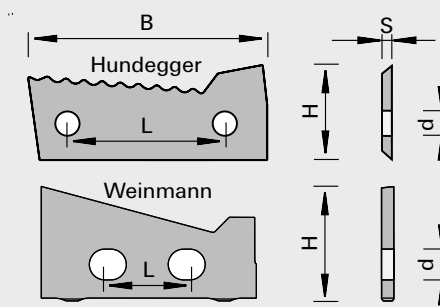
151587

Profile knives HW - for dove-tail profiles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for dove-tail cutterheads by
Hundegger, Weinmann
joinery machining

Design

cutting material: HW
HL Solid 20 for hard and soft
woods

Advantages

Notes

packing unit see table

B	H	S	Ø d	L	Wedge	Profile	PU	Ident-No. [L]	Ident-No. [R]
39,5	15.7	1.5	4,0	26	55	A	3	185205 L	185510 L
39,5	15.7	1.5	4,0	26	55	B	3	185206 L	185511 L
39,5	15.7	1.5	4,0	26	55	C	3	185207 L	185512 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		[pc.]		

B	H	S	Ø d	L	Wedge	PU	Ident-No.
34,9	18.6	2.0	5,0	13,8	55	without serration	2
[mm]	[mm]	[mm]	[mm]	[mm]	[°]	Weinmann	[pc.]
							185363 L

FRAME JOINTS

DOOR LEAVES

DOOR FILLINGS

HANDLE HOLE /
KEY HOLE



Door Manufacturing

Product	Page
Frame joints	34
Door fillings	35
Door leaves	37
Handle hole / key hole, glass cut-outs	39
Lock-case, forend, holes	41

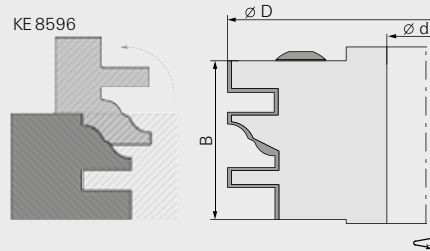
121625

Counter Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

| spindle moulder
 | for milling of length- and counterprofiles on doors, furniture parts and door panels in solid woods and wood-based panels

Design

| body made from high-strength aluminium
 | cutting edges parallel to cutter axis
 | cutting material: HW HL Board 06
 | chip limiter design

Advantages

| cutterhead for mounting of several profile knives
 | simple knife change

Notes

| counter profile set with profile KE8596
 | alternative profiles not included in delivery

Ø D	B	Ø d	Z	nmin-nmax	Ident-No.
130 [mm]	40 [mm]	30 [mm]	2	6000-12000 [min-1]	50664637 L

Turnover Knives

LEUCODUR

Class-No.

PU

Profile Knives KE7824	HL Board 06	151586	6	50687824 C
Profile Knives KE7826	HL Board 06	151586	2	50687826 L
Profile Knives KE7828	HL Board 06	151586	6	50687828 C
Profile Knives KE8596	HL Board 06	151586	6	50688596 S
Profile Knives KE8598	HL Board 06	151586	6	50688598 C
[pc.]				

Spare parts

Dimension

Class-No.

PU

Ident-No.

Pressure Bars	B=36	925300	2	50773906 S
Set Screws	M6x16 SW3	995161	10	001617 L
Screwdrivers	SW3x100	985730	1	166090 L
[mm]				
[pc.]				



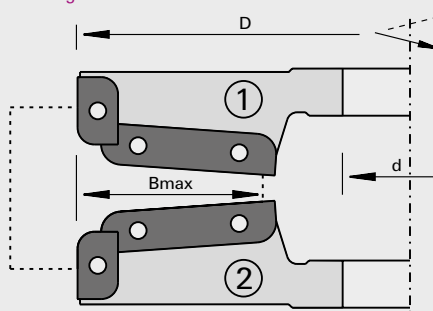
120645

Panel Raising Cutterheads HW - Silverline

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

| spindle moulder
 | for panel-raising of door panels
 in solid woods and wood-based
 panels

Design

| tool body made from steel
 | cutting edges parallel to cutter
 axis
 | cutting material: HW HL Board
 05

Advantages

| up to 12 different profiles in the
 same tool body possible
 | further versions possible thanks
 to height adjustment

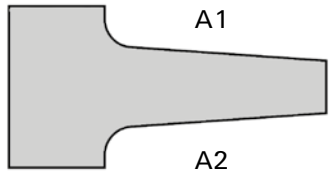
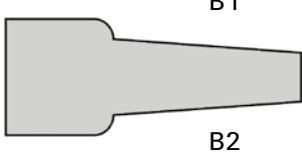
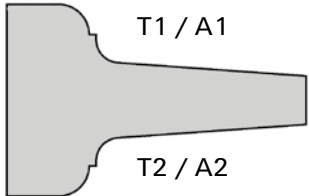
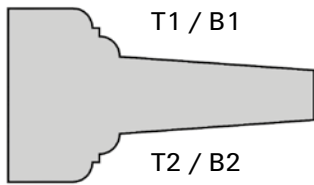
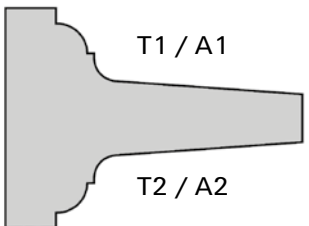
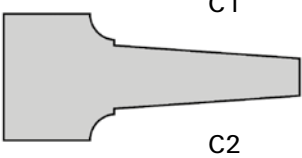
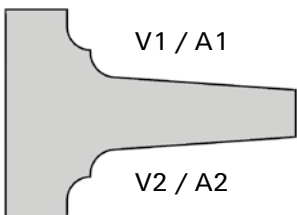
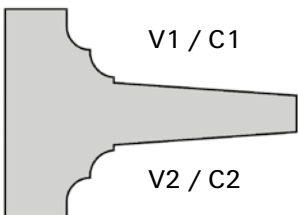
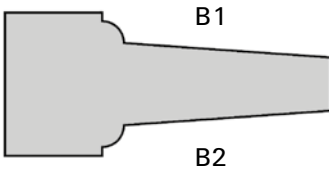
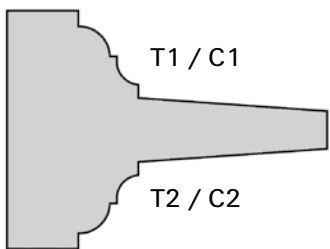
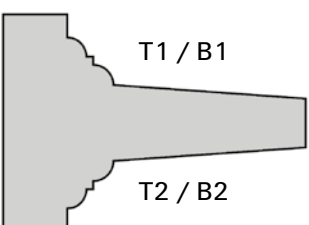
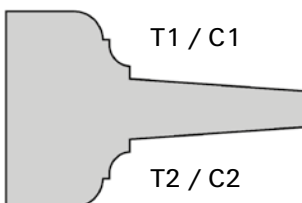
Notes

| included in delivery: 1
 panel raising cutterhead with
 mounted knives for profile B
 (62556021, 62556022)
 | alternative profiles not
 included in delivery

Cutter-no.	Ø D	Bmax	Ø d	Z	nmin-nmax	Ident-No.
1	200	60	30	2+2	3800 - 6500	L 68255130 C
2	200	60	30	2+2	3800 - 6500	R 68255230 C
1	200	60	40	2+2	3800 - 6500	L 68255140 C
2	200	60	40	2+2	3800 - 6500	R 68255240 C
1	200	60	50	2+2	3800 - 6500	L 68255150 C
2	200	60	50	2+2	3800 - 6500	R 68255250 C
	[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Profile Panel Raising Cutting Edges A1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556011 C
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255250, 68255240	151549	6 R	62556012 C
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556021 C
Profile Panel Raising Cutting Edges B2	60x12x1,5	68255230, 68255250, 68255240	151549	6 R	62556022 C
Profile Panel Raising Cutting Edges C1	60x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556031 C
Profile Panel Raising Cutting Edges C2	60x12x1,5	68255230, 68255250, 68255240	151549	6 R	62556032 C
Profile peripheral cutting edge T1	20x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556023 C
Profile peripheral cutting edge T2	20x12x1,5	68255230, 68255250, 68255240	151549	6 R	62556024 C
Profile peripheral cutting edge V1	20x12x1,5	68255130, 68255140, 68255150	151549	6 L	62556013 C
Profile peripheral cutting edge V2	20x12x1,5	68255230, 68255250, 68255240	151549	6 R	62556014 C
	[mm]			[pc.]	

Profile combinations

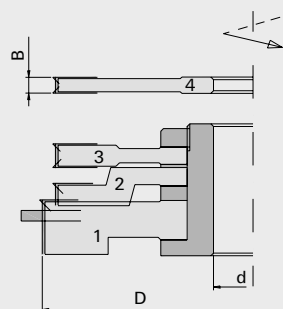
	A		B
	A/T		BT
	A/T		C
	A/V		CV
	B		CT
	B/T		CT

120450 / 121450

Door leaf set HW

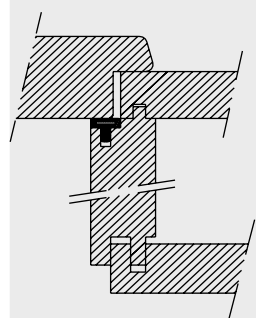
Product

Drawing



Tungsten Carbide [HW]

MAN



Machine / Application

Design

Advantages

Notes

I molders

I for manufacturing door leaves and cladding in solid woods and wood-based materials

I no tool change needed since different profiles are manufactured with the same cutter set

I Ident-No. 199399 with 887060 for complete processing

I Ident-No. 199398 as construction set for Poly Rabbeting Cutterhead

Ø D	B	Ø d	Z		Ident-No. top
150		30	2+2	Cutter 2/3 on clamping bushing	199398 L
150		30	2+2	Cutter 1/2/3 on clamping bushing	199399 L
150	9,0	30	4+4	Cutter 3	887059 S
150	6,0	30	4+4	Cutter 4	887060 L
[mm]	[mm]	[mm]			

Turnover Knives	B	H	S		Class-No.	PU	Ident-No.
Spurs	14	14	2.0	for cutters 1/2/3	150558	10	003079 L
Spurs	14	14	1.2	for cutter 4	150558	10	163701 L
VHW grooving cutter	4,0			for cutter 1	151512	10	199699 L
Turnover Knives	20	12	1.5	for cutter 1	150515	10	003082 L
Turnover Knives	7,5	12	1.5	for cutter 2	150515	10	052543 L
Turnover Knives	8,6	12	1.5	for cutter 3	150512	10	881585 L
Turnover Knives	18	18	2.9	for cutter 4	150514	10	418977 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts

Dimension

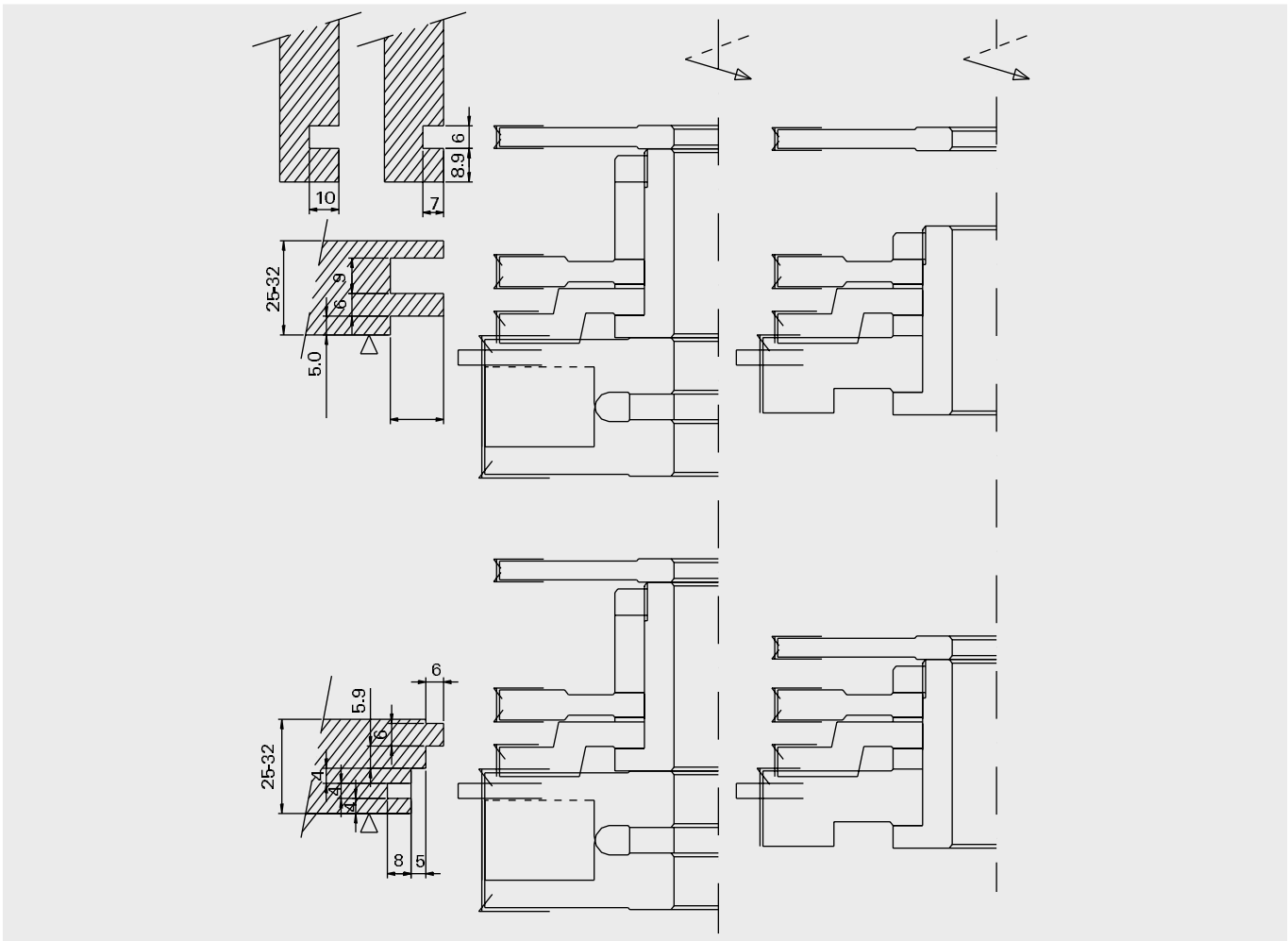
Class-No.

PU

Ident-No.

Pressure Bars		for cutter 1	925300	2	882863 S
Pressure Bars	B=7,2	for cutters 2/3	925300	2	870829 L
Countersunk Screws	M5x7 T15	for cutters 1/2/3	995125	10	900512 L
Set Screws	M6x16 SW3	for cutter 1	995161	10	001617 L
Set Screws	M5x16 DIN EN ISO 4028	for cutter 3	995161	10	873731 L
Special Nuts	M4x0,5x1,6	for cutter 4 / 163701	995290	10	163704 L
Special Nuts	M4x0,5x2,2	for cutter 4	995290	10	874748 L
Countersunk Screws	M4x0,5x4,2 T9 D=Ø6	for cutter 4	995125	10	165908 L
Countersunk Screws	M5x13,5 T20 D=Ø10	for cutter 1	995125	10	171238 L
Screwdrivers	T15	for cutters 1/2/3	985730	1	013953 L
Screwdrivers	T20	for cutter 1	985730	1	013954 L
	[mm]			[pc.]	

Spare parts	Dimension		Class-No.	PU	Ident-No.
Cranked Wrench Keys	SW2,5 DIN ISO 2936	for cutters 1/2/3	985730	1	009671 L
Hook Wrenches	68-75	for clamping bushing	985720	1	873631 L
Magnetic Stops	0,5	for cutters 1/2/3	997800	1	166093 L
	[mm]			[pc.]	

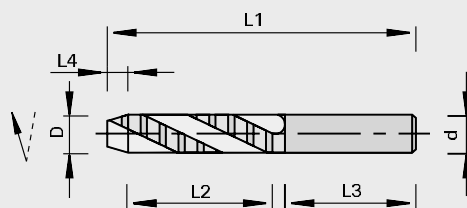


129450

Roughing Plunge Cutters VHW - door manufacturing

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for drilling of latchholes and keyholes

Design

| positive spiral
 | n max = 30,000 min-1

Advantages

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

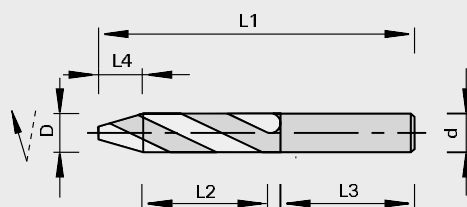
Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	5.0	75	16	48	130	2	185831 L
20	5.0	75	20	50	135	3	185832 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

129450

Finishing Plunge Cutters VHW - door manufacturing

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for drilling of peepholes and for through holes

Design

| positive spiral
 | n max = 30,000 min-1

Advantages

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
12	10	47	12	53	110	2	185826 L
12	10	70	12	50	130	2	185828 L
14	10	47	14	45	110	2	185829 L
16	11	52	16	60	130	2	185830 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

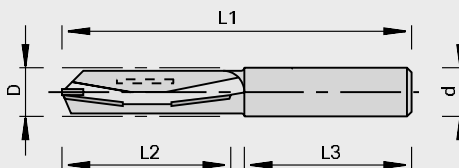
129860

Router Bits for Sash Openings HW-tipped with shear angle

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- stationary routers
- CNC routers
- for cutting of cut-outs in doors, countertops and furniture parts in hard and exotic woods and wood-based panels

Design

- with shear angle
- $n_{max} = 24.000 \text{ min}^{-1}$

Advantages

- optimum cutting quality on veneered and plastic laminated parts

Notes

- face cutting design allows plunge-cuts
- clamping elements: draw-in collet chuck, centric clamping chuck

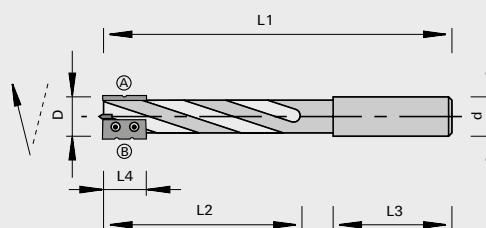
$\varnothing D$	L2	$\varnothing d$	L3	L1	Z	Ident-No.
14	50	14	48	100	1+1+1	167662 C
[mm]	[mm]	[mm]	[mm]	[mm]		

129410

Lock-Case Cutters with HW Knives - door manufacturing

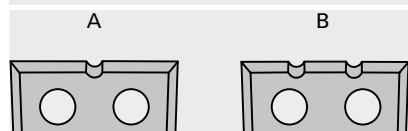
Product

Drawing



Tungsten Carbide [HW]

MEC



Machine / Application

| CNC machining centers
 | for cutting of lock-cases and
 | face-plates in doors

Design

| Positive spiral
 | High-strength carrier material
 | (heavy metal)
 | With HW-tipped (soldered)
 | plunge tip
 | Tipped with 2 knives with chip
 | breaker, one in form A and one
 | in form B
 | n max=18,000 min-1

Advantages

| optimum chip evacuation thanks
 | to positive spiral
 | high balance quality thanks to
 | cutting edges with chip breakers
 | constant diameter thanks to
 | exchangeable knives

Notes

| clamping elements: ps-System
 | with reducing sleeves Class-
 | No. 933280, TRIBOS, draw-in
 | collet chuck
 | for attachment in horizontal
 | boring-cutting aggregat
 | (Homag, Weeke) side clamp-
 | ing surfaces are necessary
 | (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	Ident-No.
16	16	105	16	55	170	2	183750 O
16	16	105	20	55	170	2	183751 O
18	16	105	20	55	170	2	183752 O
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		

Turnover Knives	B	H	S	Type	Class-No.	PU	Ident-No.
	16	7.0	1.5	A	150525	10	183753 L
	16	7.0	1.5	B	150525	10	183754 L
	[mm]	[mm]	[mm]			[pc.]	

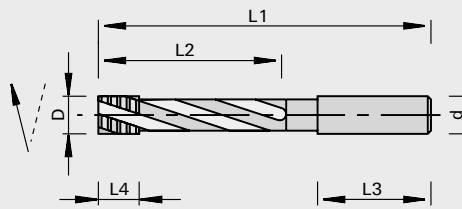
Spare parts	Dimension	Class-No.	PU	Ident-No.
Round Head Screws	M3x4 T9	995195	10	180449 L
Screwdrivers	T9x60	985730	1	173796 L
	[mm]		[pc.]	

129450

Lock-Case Roughing Cutters VHW - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for cutting of lock-cases in doors

Design

| positive spiral
 | roughing design

Advantages

| optimum chip evacuation thanks to positive spiral
 | high smoothness of running

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
 | for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

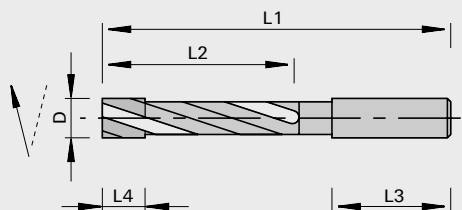
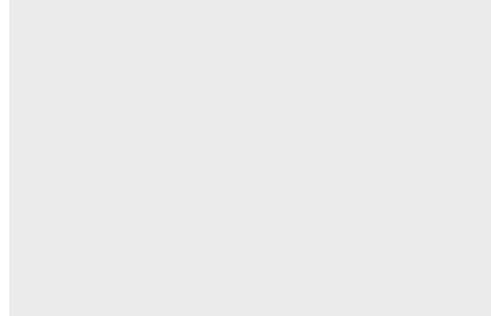
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	3	24000	185835 L
16	25	115	16	50	175	3	24000	185836 L
18	25	115	20	50	175	3	24000	185837 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129450

Lock-Case Finishing Cutters VHW - door manufacturing

Product

Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

| CNC machining centers
 | for cutting of lock-cases and face-plates in doors

Design

| positive spiral
 | finishing design

Advantages

| optimum chip evacuation thanks to positive spiral
 | high smoothness of running

Notes

| clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck
 | for attachment in horizontal boring-cutting aggregate (Homag, Weeke) side clamping surfaces are necessary (see Technical Information)

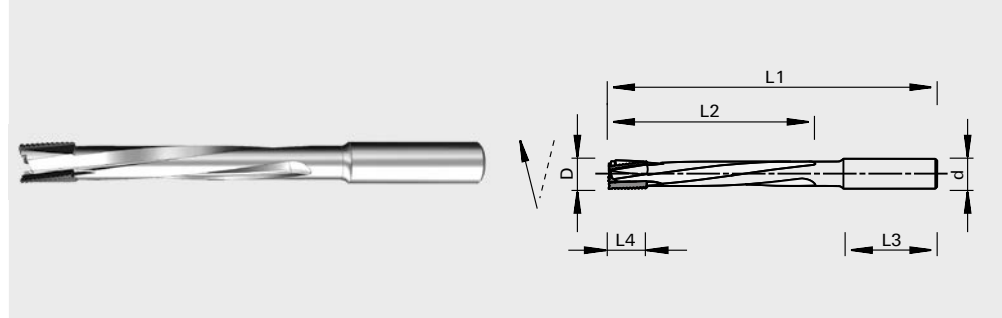
Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No.
14	25	95	14	50	155	2	24000	185833 L
16	25	115	16	50	175	2	24000	185834 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

129450

Lock-Case Roughing Cutters VHW - negative spiral - door manufacturing

Product

Drawing



Solid Tungsten Carbide

MEC

Machine / Application

- | High-performance door machining systems
- | CNC machining centers
- | Machines with lock-case units
- | For cutting lock-cases in doors

Design

- | Negative spiral
- | Fine roughing design
- | High-quality cutting material

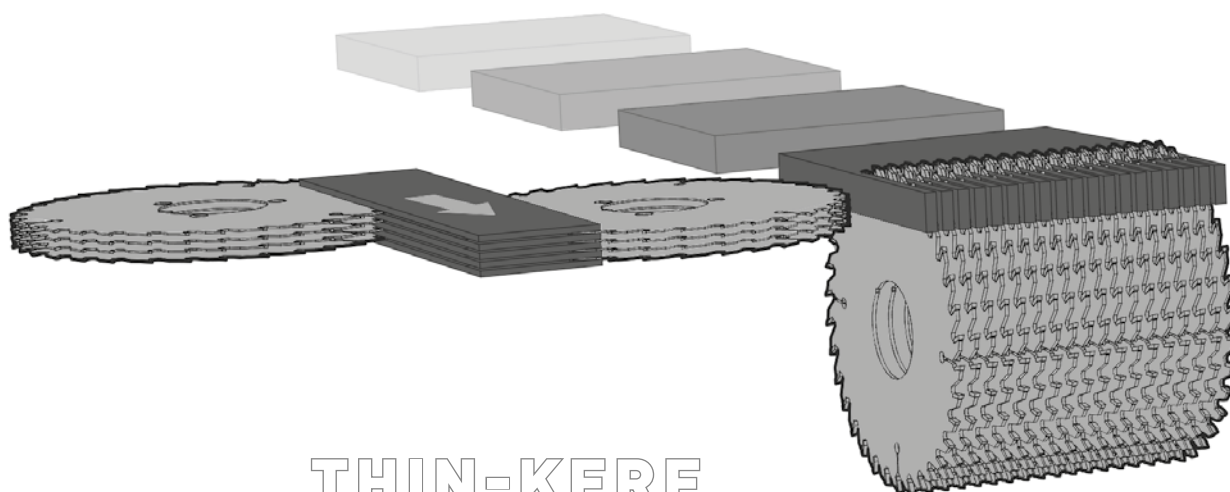
Advantages

- | Very smooth running and therefore very gentle on the milling units
- | Lowest load even when changing the milling direction
- | Longer edge lives

Notes

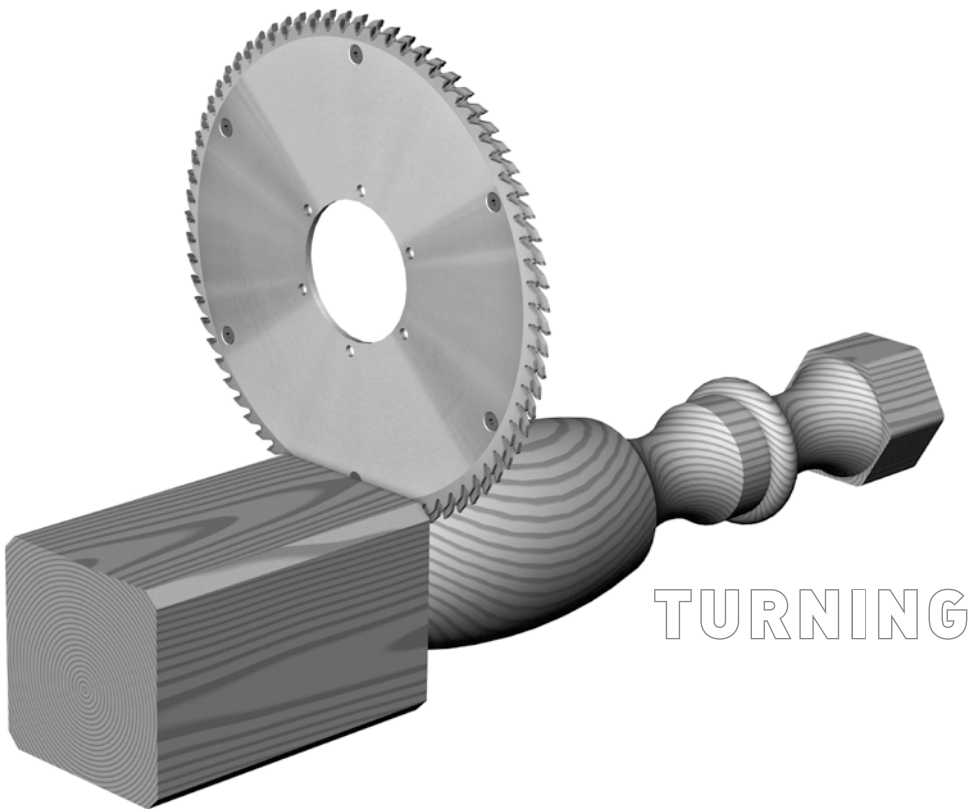
- | Recommended for use in hydraulic expansion chucks or heat-shrinking chucks
- | For mounting in horizontal drilling-milling aggregate (Homag, Weeke), lateral clamping surfaces are required (see Technical Information)

Ø D	L4	L2	Ø d	L3	L1	Z	nmax	Ident-No. [L]
16	25	115	16	50	175	3	24000	186763 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	



THIN-KERF PARQUET

Further Processing, Sawing in general



Product

Longitudinal cut

Cross cut

Page

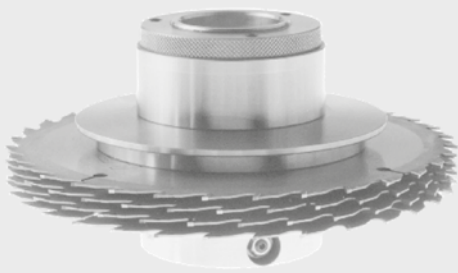
46

53

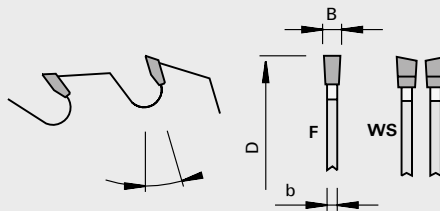
102317 / 102327

Thin-Kerf Saw Blades HW for parquet manufacturing

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

- l optimum wood yield thanks to thin kerfs

Notes

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

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

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

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

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

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Cover flange top with handhold	130	16	60	997300	1	182194 C
Cover flange top with handhold	130	16	65	997300	1	182196 S
Cover flange bottom	130	14	60	997300	1	182195 C
Cover flange bottom	130	14	65	997300	1	182197 S
Spacers	130	4,2	60	955520	1	182200 S
Spacers	130	4,4	60	955520	1	182202 C
Spacers	130	4,5	60	955520	1	182203 S
Spacers	130	5,0	60	955520	1	182208 S
	[mm]	[mm]	[mm]			

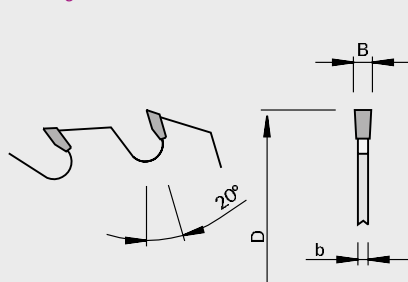
101310 / 101311

Gang-Rip Saw Blades HW "F"

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

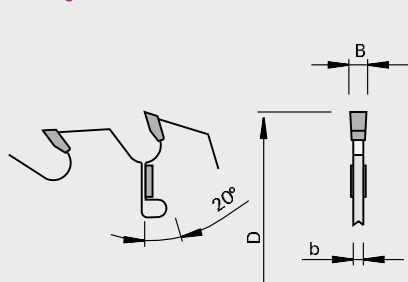
101715

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

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
400	4,2	3.0	50	100	150	24	2+2	189272 L
450	4,2	3.0	50	100	160	24	2+2	189273 L
500	4,6	3.3	50	100	180	28	2+2+2	189274 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

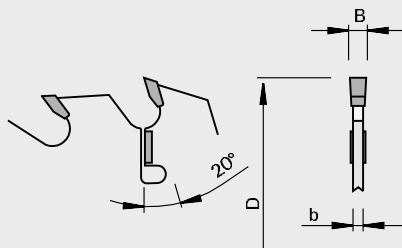
101315

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	DKN	NL	Ident-No.
180	2,4	1.6	40	55	95	16	2			188096 L
200	2,0	1.4	40	75	115	16	2			188097 L
200	2,4	1.6	40	75	115	16	2			188098 L
225	2,4	1.6	40	80	120	16	2			188100 L
250	2,4	1.6	40	80	125	16	2			188101 L
250	2,8	1.8	70		125	24	2	20x5		189290 L
300	3,2	2.2	70		120	16	2+2	20,0x5		189293 L
300	3,4	2.2	80		120	16	2+2	12,5x4,5		189296 L
300	3,2	2.2	70		120	28	2+2	20,0x5		189294 L
300	3,2	2.2	80		125	16	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189295 L
350	3,5	2.5	70		120	20	2+2	20x5		189297 L
350	3,8	2.5	80		125	20	2+2	18,5x5	6/5,5/91 + 4/6,6/95 + 2/13/100	189299 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	[mm]		

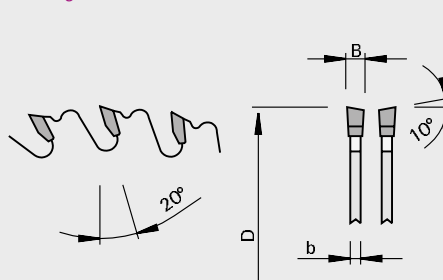
101725

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

Product



Drawing

LEUCO
solidLEUCO
DUR

Tungsten Carbide [HW]

MAN

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	NL	Ident-No.
350	3,5	2.5	30	70	140	24	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189643 L
400	3,5	2.5	30	80	160	28	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189644 L
450	4,2	2.8	30	80	160	36	2+2	2/7/42 + 2/9,5/46,5 + 2/10/60	189645 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]		

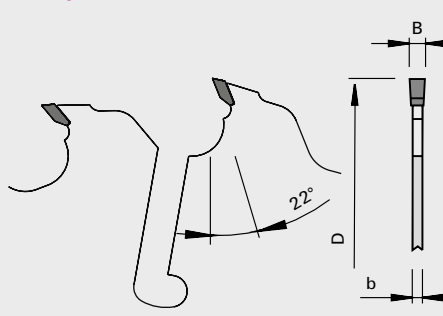
101715

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

Product



Drawing

LEUCO
solidLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

- Gang rip machine with low feed rates
- Gang-rip machines with one or two shafts
- for longitudinal cuts in wet and dry solid woods

Design

- Tooth configuration: flat tooth "F"
- Cutting material: HW HL Board 20
- with internal and external HW rakers

Advantages

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

Notes

Ø D	B	b	Ø d	Ø dmax	Max. flange Ø	Z	Number of rakers	Ident-No.
300	3,4	2.0	50	90	130	20	2+2	80495223 L
350	4,0	2.6	50	100	140	20	2+2	80495224 L
400	4,4	3.0	50	100	150	24	2+2	80495225 L
450	4,8	3.2	50	100	160	24	4+2	80495226 L
500	5,0	3.4	50	100	180	24	4+2	80495227 C
550	5,2	3.6	50	140	180	24	4+2	80495228 L
600	5,8	4.0	50	140	180	24	4+2	80495229 C
630	6,0	4.0	50	140	180	24	4+2	80495230 C
650	6,0	4.0	50	140	180	24	4+2	80495231 C
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

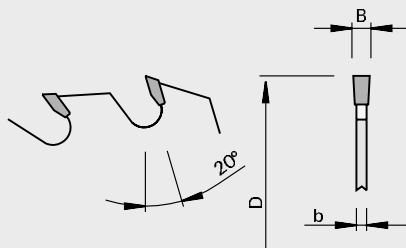
101310

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

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

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

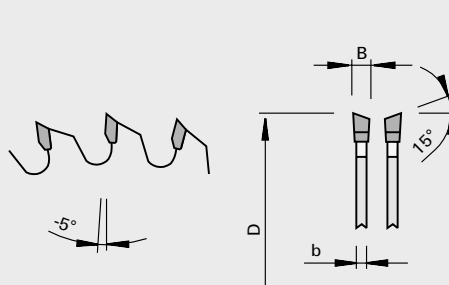
101320 / 102328

Trimming and sizing saw blades HW "WS" - easyFix

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

easyFix

Machine / Application

- chop and miter saws
- For cross cuts in solid wood and wood-based materials

Design

- Tooth configuration: alternate top bevel "WS"
- Cutting material: HW
- Class-No. 101320 HL Board 20 for wood-based materials
- Class-No. 102328 HL Board 06 for solid wood

Advantages

- easyFix: NEW, EASY HANDLING, easy and smooth mounting of the saw blade on the machine despite high-precision bore tolerance
- High cutting quality and safe handling thanks to negative hook angle
- Noise reduction thanks to laser ornaments

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
300	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193245 L
350	3,4	2.2	40	42	2/9/55 + 4/12/64	Graule	193246 L
350	3,2	2.2	40	72	2/9/55 + 4/12/64	Graule	193247 L
420	4,0	2.8	40	54	2/9/55 + 4/12/64	Graule	193248 L
420	3,5	2.5	40	84	2/9/55 + 4/12/64	Graule	193249 L
520	4,4	3.2	50	60	2/9/55 + 4/12/64	Graule	193250 L
[mm]	[mm]	[mm]	[mm]				

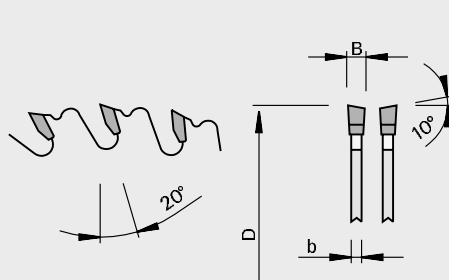
101320

Trimming Saw Blades HW - with chip limiter "WS" - topline

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

- Table saws
- Suitable for manual feed
- for sizing cuts in solid woods
- especially for knotty woods

Design

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

Advantages

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

Notes

Ø D	B	b	Ø d	Z	NL		Ident-No.
300	3,2	2.2	30	28	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		193240 L
350	3,5	2.5	30	32	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		193241 L
400	4,0	2.8	30	36	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		193242 L
450	4,4	3.0	30	40	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		193243 L
500	4,4	3.2	30	44	2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42		193244 L
[mm]	[mm]	[mm]	[mm]				

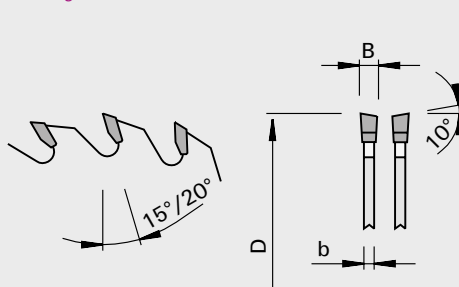
101620/107520

Trimming Saw Blades HW "WS"

Product



Drawing

LEUCO
highlineLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise**Machine / Application**

- I table saws
- I for sizing cuts in solid woods

Design

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

Advantages

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

Notes

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

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

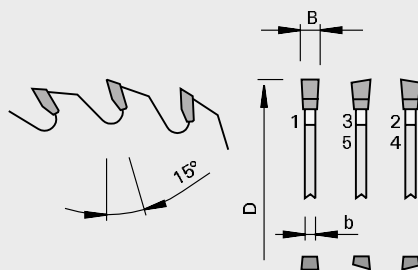
102348

Sizing Saw Blades HW "G5"

Product



Drawing

LEUCO
G5 systemLEUCO
DUR

Tungsten Carbide [HW]

LOW
noise

Machine / Application

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

Design

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

Advantages

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

Notes

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

Ø D	B	b	Ø d	Z	NL**	nmax	Ident-No.
200	3,0	2.2	30	65		7630	192789 L
220	3,0	2.2	30	70		6940	192790 L
240	3,0	2.2	30	75		6360	192791 L
250	3,0	2.2	30	80	Combi3	6110	192792 L
280	3,0	2.2	30	85	Combi3	5450	192793 L
300	3,0	2.2	30	100	Combi3	5090	192794 L
303	3,2	2.2	30	100	Combi3	5040	192795 L
315	3,0	2.2	30	100	Combi3	4850	192801 L
350	3,0	2.2	30	100	Combi3	4400	192796 L
380	3,0	2.2	32	120		3340	192802 L
400	3,0	2.2	30	120	Combi3	3340	192797 L
450	3,6	2.8	30	130	Combi3	3180	192798 L
500	3,6	2.8	30	145	Combi3 + 2/10/70	2670	192799 L
550	4,0	3.2	30	160	Combi3	2780	192803 L
[mm]	[mm]	[mm]	[mm]			[min-1]	

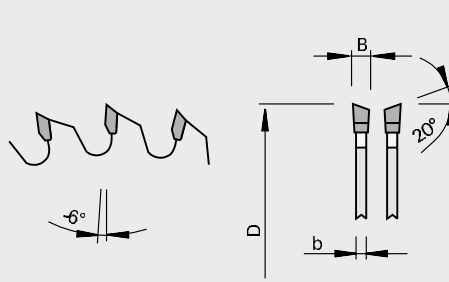
101322

Clipping Saw Blades HW "WS"

Product



Drawing

LEUCO
top lineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

Advantages

Notes

Ø D	B	b	Ø d	Z	Ident-No.
450	4,4	3.2	30	54	188045 L
500	4,4	3.2	30	60	188046 L
[mm]	[mm]	[mm]	[mm]		

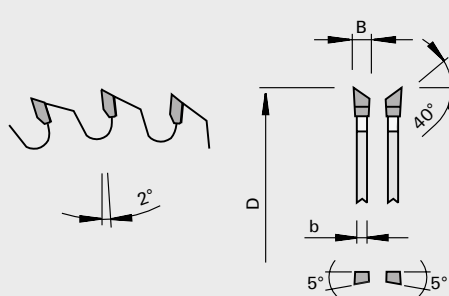
101322

Clipping Saw Blades HW for wood optimization "WSA"

Product



Drawing

LEUCO
top lineLEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

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

Design

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

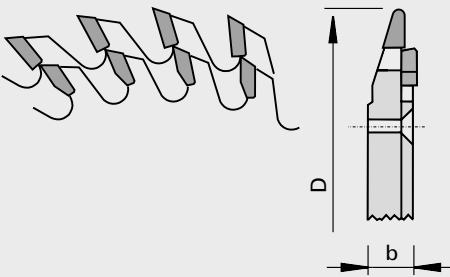
Advantages

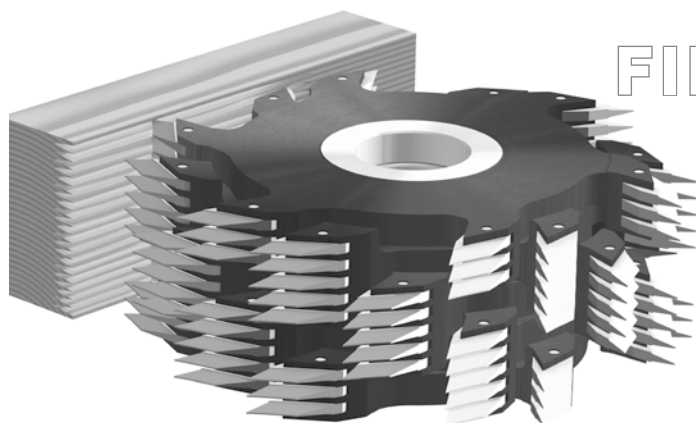
l reduced cutting pressure thanks to alternating shear angle
l long edge lives provide for the necessary productivity and economic efficiency

Notes

Ø D	B	b	Ø d	Z	NL	Ident-No.
400	3,4	2.8	30	120	2/10/60	DIMTER QUANTUM 189896 L
400	4,6	3.5	30	120	2/10/60	DIMTER 189833 L
450	4,6	3.5	30	132	2/15/63	DIMTER 189834 L
500	4,6	3.5	30	144	2/15/63	DIMTER 189835 L
520	4,6	3.5	30	144	2/15/63	DIMTER 189836 L
600	5,2	3.8	30	172	2/15/63	DIMTER 189838 L
630	5,4	4.0	30	180	2/15/63	DIMTER 189839 L
[mm]	[mm]	[mm]	[mm]			

106384
Turnery saw blades HW

Product		Drawing			LEUCO topliner LEUCO DUR Tungsten Carbide [HW]	
						
Machine / Application		Design		Advantages	Notes	
Special woodturning lathes (Zuckermann, Hempel, CMS-HIT)		carbide tipped				
for woodturning applications in solid wood		special tooth configuration				
		bore tolerance H7				
Ø D	b	Ø d	Z	NL	Ident-No.	
350	11.3	60	2x64	6/11/170	185248 S	
350	11.3	60	2x90	6/11/170	185249 C	
[mm]	[mm]	[mm]				



FINGER JOINT CUTTERS

LEUCO FINGER JOINT CUTTER PROGRAM

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

Application / Design		Finger joint cutters									Finger joint cutters disc-type							Cutterhead			
		Finger joint cutters HS			Finger joint cutters HS Solid 34			Finger joint cutters HW			Finger joint cutters disc-type HW soft wood		Finger joint cutters, disc-type HW hard wood		Finger joint cutters, disc-type for tropical wood			Finger joint cutterhead			
Glue- ing	normal	++			++			++			++		++		++			++			
	fiber-free	++			o			o			o		o		o			o			
Wood types	Coniferous wood	++			++			o			++		++		o			++			
	Deciduous wood	+			++			++			-		++		++			o			
	Tropical wood	o			+			+			-		+		++			o			
Dimensions on machine	Finger jointing line (with hogger)	10/11	15/16,5	20/22	10/11	15/16,5	20/22	10/11	15/16,5	-	10/11	10/11	15/16,5	-	10/11	15/16,5	-	-			
	Compact line (without hogger)	10/10	15/15	20/20	10/10	15/15	20/20	10/10	15/15	-	-	-	-	-	-	-	-	10/10	10/11	15/15	15/16,5
Coating options	Non-stick coating	-			-			-			topcoat		topcoat		-			-			
	Edge life coating	topcoat			topcoat			topcoat			topcoat/ topcoat plus		(*)		(*)			topcoat			
Comparison of edge lives	uncoated	100%			up to 300% – 400%			up to 400% (increased risk of breaking)			100%		100%		100%			100%			
	topcoat	up to 200% – 300%			> 500% (*)			(*)			up to 200%		up to 200%		-			up to 200% – 300%			
	topcoat plus	-			-			-			> 400%		(*)		(*)			-			

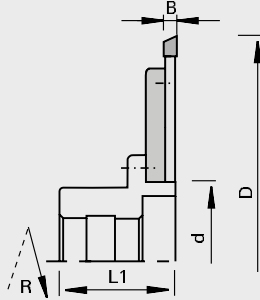
*on request ++ very well suited + well suited o possible – not possible / not suitable

Finger Jointing Technology

Product	Page
Saw blade hogs	58
Finger jointing cutters	62
Finger jointing cutters disc-type	77

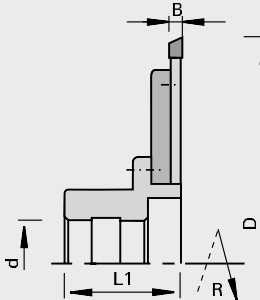
115775

Saw Hoggers HW for finger jointing lines - Grecon

Product				Drawing							
								 Tungsten Carbide [HW] MEC			
Machine / Application				Design				Advantages			
finger jointing lines for chip-free cross-cutting of solid woods								clean, chip-free cuts and long edge lives thanks to special cutting geometry precise fit for finger joints low noise level			
								Notes			
								included in delivery: hogger saw blade, flange, screws and screwdrivers (not mounted); sleeve not included in delivery sense of rotation acc. to VDMA 8849			
Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]		Ident-No. [R]	
250	8,0	44	59	80	60	12x3,3		Grecon		182379 O	
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]				182378 O	
Spare parts				Dimension				Class-No.	PU	Ident-No. [L]	
Hogging Saw Blades				Ø250x6,3/5xØ75 Z80				102352	1	189033 L	
Hogging Saw Blades				Ø250x8,0/6,1xØ80 Z60				102352	1	189223 L	
Flanges				Ø210x8,4xØ80				997300	1	182377 L	
Countersunk Screws				M8x20 DIN 7991-8.8				995121	10	056378 L	
Countersunk Screws				M5x12 T20 D=Ø9,3				995125	10	166709 L	
Screwdrivers				T20x100				985730	1	166092 L	
Bushings for Grecon				Ø113x59x40DKN				997300	1	189100 L	
Bushings for NKT				Ø206x100,3x38 DKN				997370	1	178294 L	
				[mm]				[pc.]			

115775

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

Product				Drawing							
								 Tungsten Carbide [HW] MEC			
Machine / Application				Design				Advantages			
- finger jointing lines - for chip-free cross-cutting of solid woods								- clean, chip-free cuts and long edge lives thanks to special cutting geometry - precise fit for finger joints - low noise level			
								Notes			
								sense of rotation acc. to VDMA 8849			
Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]		Ident-No. [R]	
250	8,0	44	59	40	60	12x3,3		Grecon		182599 O	
350	10	44	59	40	60+12	12x3,3		Grecon		182611 O	
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]				182612 O	

Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x6,3/5xØ75 Z80	102352	1	189033 L	189032 L
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102352	1	189223 L	189222 L
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102352	1	189246 L	189247 L
Flanges	Ø210x8,4xØ80	997300	1		182377 L
Countersunk Screws	M8x20 DIN 7991-8.8	995121	10		056378 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10		166709 L
Screwdrivers	T20x100	985730	1		166092 L
Bushings for Grecon	Ø113x59x40DKN	997300	1		189100 L
Bushings for Grecon-Combipact	Ø250x8x40	997370	1		178783 S
	[mm]		[pc.]		

115775

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

Product	Drawing	
		Tungsten Carbide [HW] MEC

Machine / Application	Design	Advantages	Notes
- I finger jointing lines - I for chip-free cross-cutting of solid woods		- I clean, chip-free cuts and long edge lives thanks to special cutting geometry - I precise fit for finger joints - I low noise level	I sense of rotation acc. to VDMA 8849

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

Spare parts	Dimension	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
Hogging Saw Blades	Ø250x8,0/6,1xØ80 Z60	102352	1	189223 L	189222 L
Hogging Saw Blades	Ø300x8,0/6,1xØ80 Z60	102352	1	189244 L	189245 L
Hogging Saw Blades	Ø350x10,0xØ80 Z60+12	102352	1	189246 L	189247 L
Countersunk Screws	M5x12 T20 D=Ø9,3	995125	10		166709 L
Screwdrivers	T20x100	985730	1		166092 L
Bushings for NKT	Ø206x100,3x38 DKN	997370	1		178294 L
	[mm]		[pc.]		

115775

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

Product	Drawing								
			Tungsten Carbide [HW] MEC						
Machine / Application	Design	Advantages	Notes						
finger jointing lines for chip-free cross-cutting of solid woods		clean, chip-free cuts and long edge lives thanks to special cutting geometry precise fit for finger joints low noise level	sense of rotation see drawing						
Ø D	B	b	L1	Ø d	Z	DKN		Ident-No. [L]	Ident-No. [R]
250	16,3	44	59	40	48+(6x4)	12x3,3	Grecon	189097 O	189096 O
[mm]	[mm]	[mm]	[mm]	[mm]		[mm]			
Spare parts		Dimension		Class-No.		PU	Ident-No. [L]		Ident-No. [R]
Hogger Saw Blade		Ø250x4,0/2,8xØ120 Z48		102312		1	189092 L		189093 L
HW segments		Ø250 Z=4		116200		12	189094 L		189094 L
Bushings for Grecon		Ø113x59x40DKN		997300		1			189100 L
Countersunk Screws		M6x10 SW4 DIN EN ISO 10642		995121		10			182598 L
Countersunk Screws		M5x10-8.8 DIN EN ISO 2009		995122		10			055881 L
Head Cap Screws		M8x16-8.8 DIN EN ISO 4762		995111		10			001891 L
Screwdrivers		SW4x100		985730		1			166091 L
Screwdrivers		8,0		985730		1			053874 L
		[mm]				[pc.]			

105320

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

Product		Drawing				 Tungsten Carbide [HW]		
Machine / Application		Design		Advantages		Notes		
- finger jointing lines Grecon - for scoring of solid woods		6 countersunk pin holes on both sides each - for clockwise and counter-clockwise rotation - tooth configuration: alternate top bevel "WS" - cutting material: HW HL Board 06				along and across the grain, from below		
Ø D	B	b	Ø d	Z	NL	Hook angle	Corner	Ident-No.
200	7,0	4.0	75	48	2x6/6,5/95	10	10	Grecon
[mm]	[mm]	[mm]	[mm]			[°]	[°]	189539 L

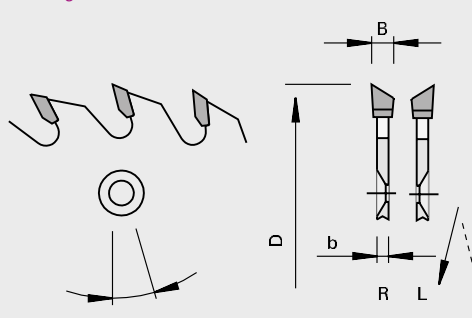
105350

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

Product



Drawing

LEUCO
toplineLEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

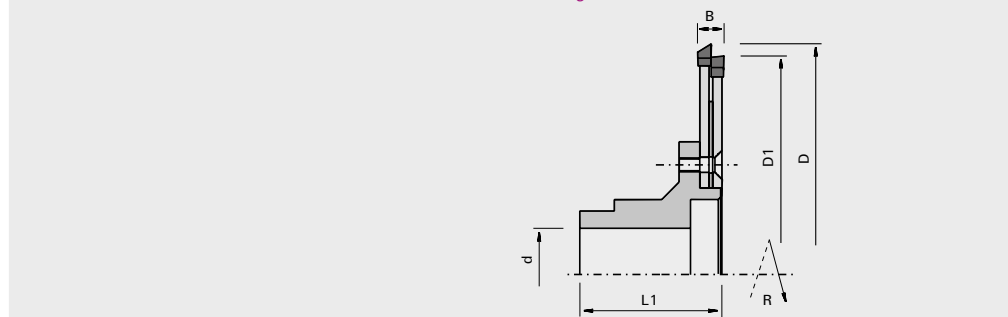
- I along and across the grain, from above and below
- I sense of rotation see drawing

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

105355

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

Product

LEUCO
DUR

Tungsten Carbide [HW]

MEC

Machine / Application

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

Design

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

Advantages

Notes

- I along and across the grain, from below
- I sense of rotation according to VDMA 8849

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

Spare parts

Dimension

Class-No.

PU

Ident-No.

Scoring Saw Blades	Ø200x6,0/4,0xØ75 Z48	105350	1	189537 C
Scoring Saw Blades	Ø190x6,0/4,0xØ75 Z48	105350	1	189538 L
Bushings for Grecon	Ø115x61xØ40DKN	997300	1	189543 L
Spacers	Ø150x1,5xØ75	955520	1	189542 L
Countersunk Screws	M6x20-8.8 SW4 DIN EN ISO 10642	995121	10	183114 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

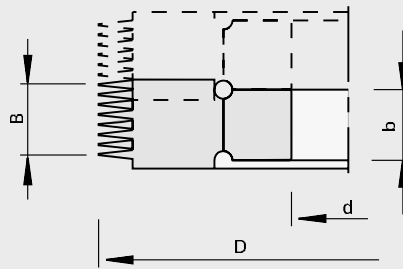
827110 / 827130

Finger Joint Cutters HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

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

Design

| standard and topcoat
 | HS Solid 24

Advantages

| increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.	
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	HS Solid 24	182122 C
250	26	24	50	3+3	1.6	4/4,5	16	6000	HS Solid 24	182113 C
250	30	28	50	6+6	2.8	6/7	10	6000	HS Solid 24	192467 L
255	30	28	50	6+6	2.8	6/7	10	6000	HS Solid 24	192468 S
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.	
160	32,4	30.4	50	3+3	1.6	4/4,5	20	9000	HS Solid 24, topcoat	192202 S
250	26	24	50	3+3	1.6	4/4,5	16	6000	HS Solid 24, topcoat	192201 C
250	30	28	50	6+6	2.8	6/7	10	6000	HS Solid 24, topcoat	192466 C
255	30	28	50	6+6	2.8	6/7	10	6000	HS Solid 24, topcoat	192469 S
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

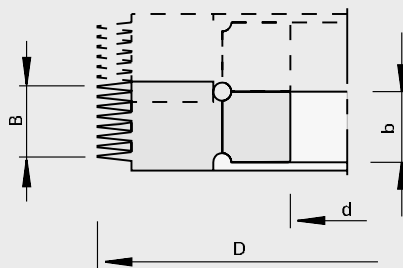
3271.. / 5271.. / 127110

Finger Joint Cutters 10/10

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines without cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- Finger length of 10 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS	187376 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS, topcoat 104	187379 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS Solid 34	187380 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HS Solid 34, topcoat 104	187377 C
160	28,6	26.6	50	2+2	3.8	10/10	7	8000	HW	187378 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS	187382 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS, topcoat 104	187384 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS Solid 34	187386 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HS Solid 34, topcoat 104	187383 C
250	28,6	26.6	50	3+3	3.8	10/10	7	6000	HW	187385 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

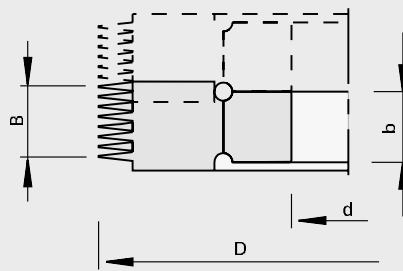
3271.. / 5271.. / 127110

Finger Joint Cutters 10/11

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- Finger length of 10 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods
- HW suitable for hard and exotic woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS	187389 L
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS, topcoat 104	187391 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS Solid 34	187388 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HS Solid 34, topcoat 104	187390 C
160	28,6	26.6	50	2+2	3.8	10/11	7	8000	HW	187392 L
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS	187397 L
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS, topcoat 104	187395 C
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS Solid 34	187396 C
160	32,4	30.4	50	2+2	3.8	10/11	8	8000	HS Solid 34, topcoat 104	187394 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS	187399 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS, topcoat 104	187401 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS Solid 34	187402 C
160	28,6	26.6	50	3+3	3.8	10/11	7	8000	HS Solid 34, topcoat 104	187400 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS	187406 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS, topcoat 104	187408 C
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS Solid 34	187407 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HS Solid 34, topcoat 104	187409 L
250	28,6	26.6	50	3+3	3.8	10/11	7	6000	HW	187405 L
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

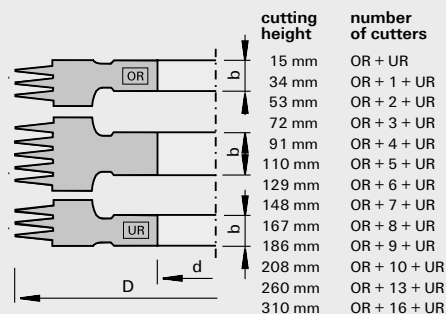
327610 / 327630 / 5276..

Finger Joint Cutters 10/11 - real Z=6

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines with cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 10 mm

Design

- I Real Z=4 or Z=6 for high feed rates
- I Finger length of 10 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- I no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter, HS	187424 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS	187411 L
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter, HS	187416 L
250	26,4	15.4	50	6	3.8	10/11	3	6000	top finish cutter, HS, topcoat 104	187423 C
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS, topcoat 104	187412 C
250	26,4	15.4	50	6	3.8	10/11	3	6000	bottom finish cutter, HS, topcoat 104	187418 C
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter, HS Solid 34	187425 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS Solid 34	187413 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter, HS Solid 34	187417 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	top finish cutter, HS Solid 34, topcoat 104	187426 L
250	41	19	50	6	3.8	10/11	5	6000	base cutter, HS Solid 34, topcoat 104	187414 L
250	26,4	14.8	50	6	3.8	10/11	3	6000	bottom finish cutter, HS Solid 34, topcoat 104	187420 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

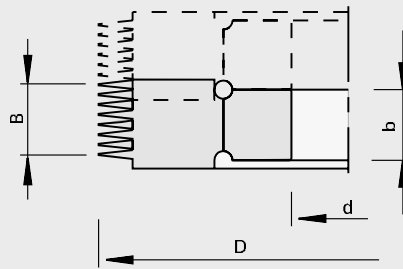
3271.. / 5271.. / 127110

Finger Joint Cutters 15/15

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines without cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- I Finger length of 15 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods
- I HW suitable for hard and exotic woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS	187432 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS, topcoat 104	187706 C
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34	187433 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34, topcoat 104	187436 C
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HW	187435 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS	187491 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS, topcoat 104	187488 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34	187487 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34, topcoat 104	187494 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HW	187490 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

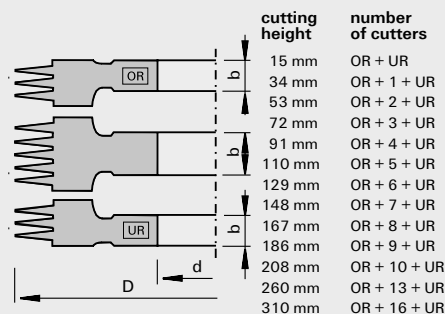
327610 / 327630 / 5276..

Finger Joint Cutters 15/15 - real Z=4 or Z=5

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines with cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- I Real Z=4 or Z=5 for high feed rates
- I Finger length of 15 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- I no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS, topcoat 104
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS, topcoat 104
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS, topcoat 104
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34
170	26,4	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34, topcoat 104
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34, topcoat 104
170	26,4	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34, topcoat 104
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
180	26,4	14.8	50	5	3.8	15/15	3	6000	top finish cutter, HS Solid 34, topcoat 104
180	41	19	50	5	3.8	15/15	5	6000	base cutter, HS Solid 34, topcoat 104
180	26,4	14.8	50	5	3.8	15/15	3	6000	bottom finish cutter, HS Solid 34, topcoat 104
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

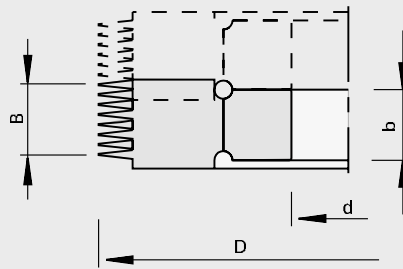
3271.. / 5271.. / 127110

Finger Joint Cutters 15/15 - PUR glueing

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | finger joint machines
- | machines without cross-cutting device
- | For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm
- | Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- | Standard for PUR glueing
- | Finger length of 15 mm
- | HS suitable for soft woods
- | HS Solid 34 suitable for knotty soft woods

Advantages

- | HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- | topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS	187428 L
170	28,6	26.6	50	2+2	3.8	15/15	7	8000	HS Solid 34, topcoat 104	187429 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS	187482 C
260	28,6	26.6	50	3+3	3.8	15/15	7	6000	HS Solid 34, topcoat 104	187484 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

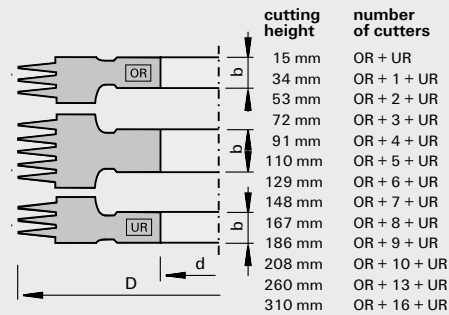
327610 / 327630 / 5276..

Finger Joint Cutters 15/15 - real Z=4 for PUR glueing

Product



Drawing



Machine / Application

- I finger joint machines
- I machines without cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm
- I Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- I Standard for PUR glueing
- I Real Z=4 for high feed rates
- I Finger length of 15 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- I no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	25,8	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS	187711 C
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS	187439 C
170	25,8	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS	187709 C
170	25,8	14.8	50	4	3.8	15/15	3	8000	top finish cutter, HS Solid 34, topcoat 104	187448 L
170	41	19	50	4	3.8	15/15	5	8000	base cutter, HS Solid 34, topcoat 104	187440 L
170	25,8	14.8	50	4	3.8	15/15	3	8000	bottom finish cutter, HS Solid 34, topcoat 104	187444 L
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

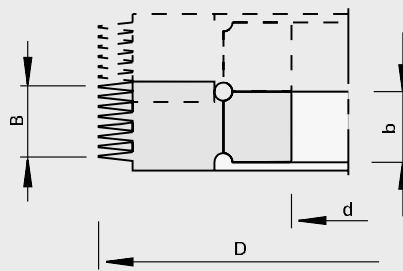
3271.. / 5271.. / 127110

Finger Joint Cutters 15/16,5

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines with cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- I Finger length of 15 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods
- I HW suitable for hard and exotic woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS	187718 L
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS, topcoat 104	187501 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS Solid 34	187502 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HS Solid 34, topcoat 104	187504 C
170	28,6	26.6	50	2+2	3.8	15/16,5	7	8000	HW	187503 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS	187514 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS, topcoat 104	187511 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS Solid 34	187513 C
170	28,6	26.6	50	3+3	3.8	15/16,5	7	8000	HS Solid 34, topcoat 104	187518 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS	187558 L
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS, topcoat 104	187561 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS Solid 34	187559 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HS Solid 34, topcoat 104	187693 C
260	28,6	26.6	50	3+3	3.8	15/16,5	7	6000	HW	187560 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

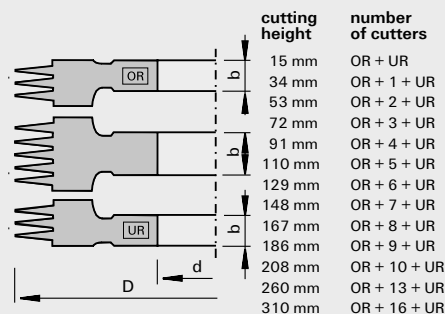
327610 / 327630 / 5276..

Finger Joint Cutters 15/16,5 - real Z=4

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 15 mm

Design

- Real Z=4 for high feed rates
- Finger length of 15 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS	187540 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS	187524 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS	187532 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS, topcoat 104	187538 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS, topcoat 104	187523 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS, topcoat 104	187531 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34	187536 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34	187720 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34	187530 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34, topcoat 104	187722 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34, topcoat 104	187525 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34, topcoat 104	187533 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34, topcoat 103	187549 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34, topcoat 103	187721 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34, topcoat 103	187534 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	top finish cutter, HS Solid 34 O, topcoat 103	187557 C
170	41	19	50	4	3.8	15/16,5	5	8000	base cutter, HS Solid 34 O, topcoat 103	187527 C
170	26,4	14.8	50	4	3.8	15/16,5	3	8000	bottom finish cutter, HS Solid 34 O, topcoat 103	187535 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

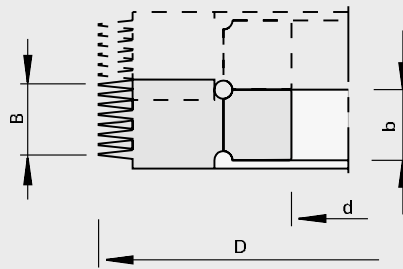
3271.. / 5271..

Finger Joint Cutters 20/20

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines with cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm

Design

- I Finger length of 20 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.
180	33	31	50	2+2	6.2	20/20	5	8000	HS 187572 L
180	33	31	50	2+2	6.2	20/20	5	8000	HS, topcoat 104 187575 C
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34 187573 L
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34, topcoat 104 187576 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]	

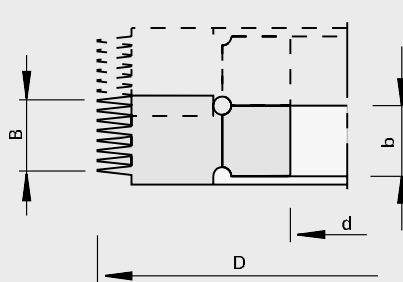
327140 / 5271160

Finger Joint Cutters 20/20 - PUR glueing

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines without cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm
- I Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- I Standard for PUR glueing
- I Finger length of 20 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.	
180	33	31	50	2+2	6.2	20/20	5	8000	HS	187568 C
180	33	31	50	2+2	6.2	20/20	5	8000	HS Solid 34, topcoat 104	187569 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		
Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax	Ident-No.	
260	33	31	50	3+3	6.2	20/20	5	6000	HS	187599 C
260	33	31	50	3+3	6.2	20/20	5	6000	HS Solid 34, topcoat 104	187600 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

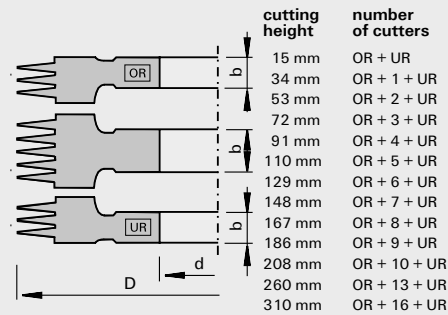
327640 / 527660

Finger Joint Cutters 20/20 - real Z=3 for PUR glueing

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- I finger joint machines
- I machines without cross-cutting device
- I For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm
- I Flexible tool for finger joints when using fibrous and non-fibrous PU glue

Design

- I Standard for PUR glueing
- I Real Z=3 for high feed rates
- I Finger length of 20 mm
- I HS suitable for soft woods
- I HS Solid 34 suitable for knotty soft woods

Advantages

- I HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- I topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

- I no. of cutters: see table

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter, HS	187591 C
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter, HS	187579 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter, HS	187586 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	top finish cutter, HS Solid 34, topcoat 104	187593 C
180	39,6	19.1	50	3	6.2	20/20	3	8000	base cutter, HS Solid 34, topcoat 104	187580 C
180	27,2	17.2	50	3	6.2	20/20	2	8000	bottom finish cutter, HS Solid 34, topcoat 104	187587 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

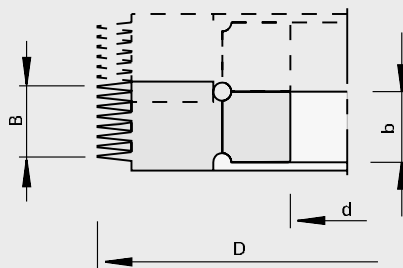
3271.. / 5271..

Finger Joint Cutters 20/22

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- machines with cross-cutting device
- For longitudinal joints in soft, hard and exotic woods, with a finger length of 20 mm

Design

- Finger length of 20 mm
- HS suitable for soft woods
- HS Solid 34 suitable for knotty soft woods

Advantages

- HS Solid 34: high bending strength, compared to HS finger joint cutters the edge life is 1.5 - 2 times as long
- topcoat 104: the edge life is 2 times as long compared to HS finger joint cutters

Notes

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
180	33	31	50	2+2	6.2	20/22	5	8000	HS	187603 L
180	33	31	50	2+2	6.2	20/22	5	8000	HS, topcoat 104	187605 C
180	33	31	50	2+2	6.2	20/22	5	8000	HS Solid 34	187604 C
180	33	31	50	2+2	6.2	20/22	5	8000	HS Solid 34, topcoat 104	187606 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

Ø D	B	b	Ø d	Z	Partition	Finger joint length	Number of finger joints	nmax		Ident-No.
260	33	31	50	3+3	6.2	20/22	5	6000	HS	187609 L
260	33	31	50	3+3	6.2	20/22	5	6000	HS, topcoat 104	187610 C
260	33	31	50	3+3	6.2	20/22	5	6000	HS Solid 34	187611 C
260	33	31	50	3+3	6.2	20/22	5	6000	HS Solid 34, topcoat 104	187612 C
[mm]	[mm]	[mm]	[mm]		[mm]	[mm]	[pc.]	[min-1]		

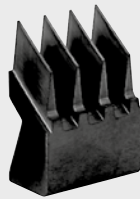
396291

Finger Joint Cutterheads - with exchangeable HS cutting edges

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- finger joint machines
- for longitudinal joints in highly stressed components

Design

- tool body made from steel
- 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates
- secured against twisting
- cutting material: HS-topcoat

Advantages

- multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to topcoat coating

Notes

- included in delivery: tool body without knife inserts

Ø D	Ø D1	B	b	Ø d	Z	nmax	Ident-No.
129.8	160/170	30,4	30.4	50	2+2	8500	192180 S
129.8	160/170	30,4	30.4	50	3+3	8500	192181 S
216	250/260	30,4	30.4	50	2+2	6000	192182 S
216	250/260	30,4	30.4	50	3+3	6000	192183 S
216	250/260	30,4	30.4	50	4+4	6000	192188 S
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	

Overview

wood width in mm	Number of cutters	wood width in mm	Number of cutters
27	1	179	6
58	2	210	7
88	3	240	8
118	4	271	9
149	5	297	10

Knives

	Class-No.	PU	Ident-No.
HS insert topcoat 10/10	332924	4	192184 S
HS insert topcoat 10/11	332924	4	192185 C
HS insert topcoat 15/15	332924	4	192186 S
HS insert topcoat 15/16.5	332924	4	192187 L
		[pc.]	

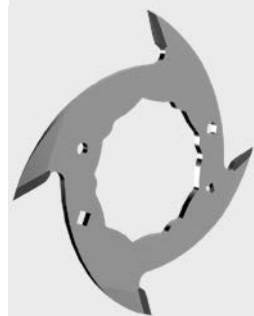
Spare parts

	Dimension	Class-No.	PU	Ident-No.
Set Screws	M8x20 DIN EN ISO 4028	995161	10	001625 L
	[mm]		[pc.]	

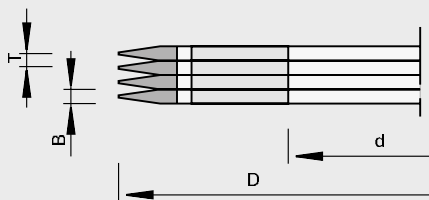
127210

Finger Joint Cutters disc-type HW - easyFix

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 210 mm: n max = 7,400 min-1
- Ø 250 mm: n max = 7,400 min-1
- Ø 260 mm: n max = 7,200 min-1

Advantages

- extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges
- higher process stability thanks to reinforced back
- Pin holes for a possible Fibonacci arrangement
- easyFix adapter for a more comfortable equipment

Notes

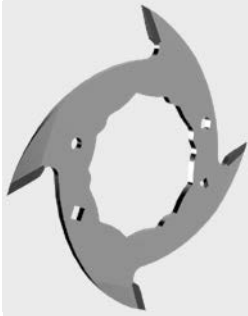
- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length		Ident-No.
160	3,6	70	2	3.8	10/11	hard woods/exotic woods	80478287 C
160	3,6	70	4	3.8	10/11	hard woods/exotic woods	80478285 L
210	3,95	70	6	4.0	10/11	hard woods/exotic woods	187833 C
250	3,6	70	6	3.8	10/11	hard woods/exotic woods	80478283 L
260	3,6	70	6	3.8	15/16	Soft wood	80478284 C
[mm]	[mm]	[mm]		[mm]	[mm]		

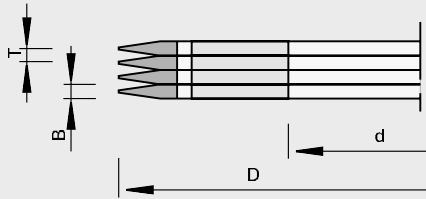
127230

Finger Joint Cutters disc-type HW - coated - easyFix

Product



Drawing

LEUCO
TOP
COAT

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 210 mm: n max = 7,400 min-1
- Ø 250 mm: n max = 7,400 min-1

Advantages

- extremely long edge lives thanks to coated cutting edge material and the spiral arrangement of the cutting edges
- compared to traditional HW finger joint cutters the edge life is 2 - 3 times as long
- higher process stability thanks to reinforced back
- Pin holes for a possible Fibonacci arrangement
- easyFix adapter for a more comfortable equipment

Notes

- adjustable to any wood thickness with bushing

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
160	3,6	70	4	3.8	10/11	80478281 C
210	3,95	70	6	4.0	10/11	187834 C
250	3,6	70	6	3.8	10/11	80478280 C
250	2,75	70	8	2.8	6/7	187832 C
250	2,75	70	12	2.8	6/7	187829 C
[mm]	[mm]	[mm]		[mm]	[mm]	

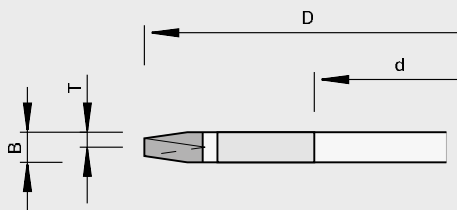
127310

Disc-type Edge Finger Joint Cutters HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- finger joint machines
- for cutting of closed visible longitudinal joints in hard and soft woods

Design

- high-tensile steel body
- Ø 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

- extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges
- higher process stability thanks to reinforced back

Notes

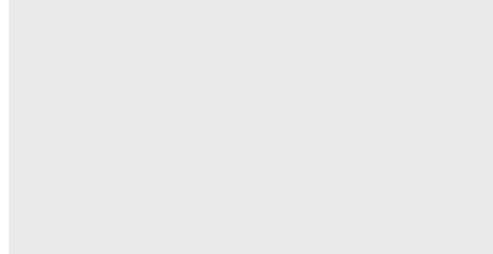
- in combination with finger joint cutters with same Ø and pitch
- Ø 239 mm (half shoulder) only with scoring saw blade

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
160	11,2	70	4	3.8	10	80478293 L
239	11,2	70	6	3.8	10	80478289 L
250	11,2	70	6	3.8	10	80478292 L
[mm]	[mm]	[mm]		[mm]	[mm]	

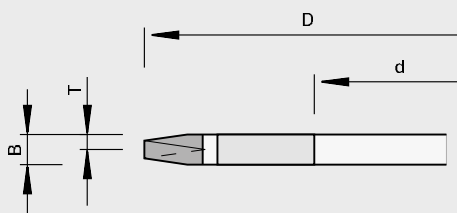
127310

Disc-type Edge Finger Joint Cutters HW - easyFix

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 239 mm: n max = 7,900 min-1

Advantages

- extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges
- higher process stability thanks to reinforced back
- Pin holes for a possible Fibonacci arrangement
- easyFix adapter for a more comfortable equipment

Notes

- in combination with finger joint cutters with same Ø and pitch
- Ø 149 mm and Ø 239 mm (half shoulder) only with scoring saw blade

Ø D	B	Ø d	Z	Partition	Finger joint length	Ident-No.
149	3,6	70	4	3.8	5	80478291 C
239	3,6	70	6	3.8	10	80478290 C
[mm]	[mm]	[mm]		[mm]	[mm]	

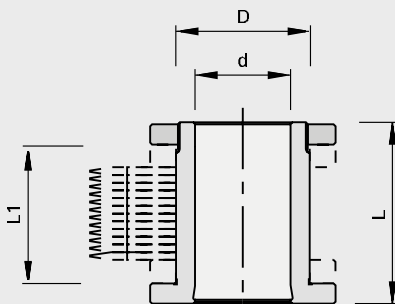
997300

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 Ø 97 mm for cutters Ø 160-210 mm (not required)

Advantages

high concentric and runout accuracy
for varying wood thicknesses

Notes

fill intermediate sizes with spacers
for cutter Ø 250 mm install at least one spacer Ø 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

Ø D	Ø d	L	L1	Ident-No.
70	50	90	57	178188 L
70	50	120	87	181035 L
70	50	130	97	178171 C
70	50	195	162	178172 L
70	50	220	187	178173 C
70	50	240	207	178174 C
[mm]	[mm]	[mm]	[mm]	

Spacer Rings	Ø D	B	Ø d	Class-No.	PU	Ident-No.
	100	7,6	70	955520	1	180940 L
	100	11,4	70	955520	1	180941 L
	175	7,6	70	955520	1	186163 S
	175	11,4	70	955520	1	181034 L
	[mm]	[mm]	[mm]			

Spare parts	Dimension	Class-No.	PU	Ident-No.
Mounting Devices		997300	1	177103 L
Pin-type face wrenches		985720	1	177102 L
Fastening Nut	M68x1,5x14	995290	1	177104 L
Hydraulic Clamping Nuts	M68x1,5x56	933090	1	178787 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

Finger Joint Cutters - Calculation of cutting width

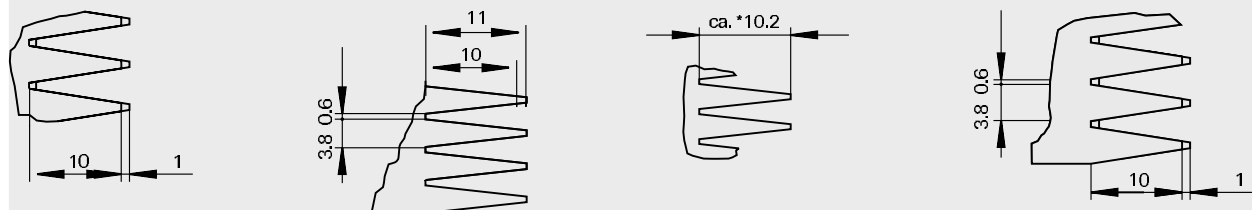
Combination of the cutter sets depending on the wood thickness

Finger length [mm]	Wood thickness [mm]	Number of cutters	Finger length [mm]	Wood thickness [mm]	Number of cutters
10+15	24	1	20	28	1
10+15	51	2	20	59	2
10+15	77	3	20	90	3
10+15	104	4	20	121	4
10+15	131	5	20	152	5
10+15	157	6	20	183	6
10+15	184	7	20	214	7
10+15	210	8	20	245	8
10+15	237	9	20	276	9
10+15	264	10	20	307	10

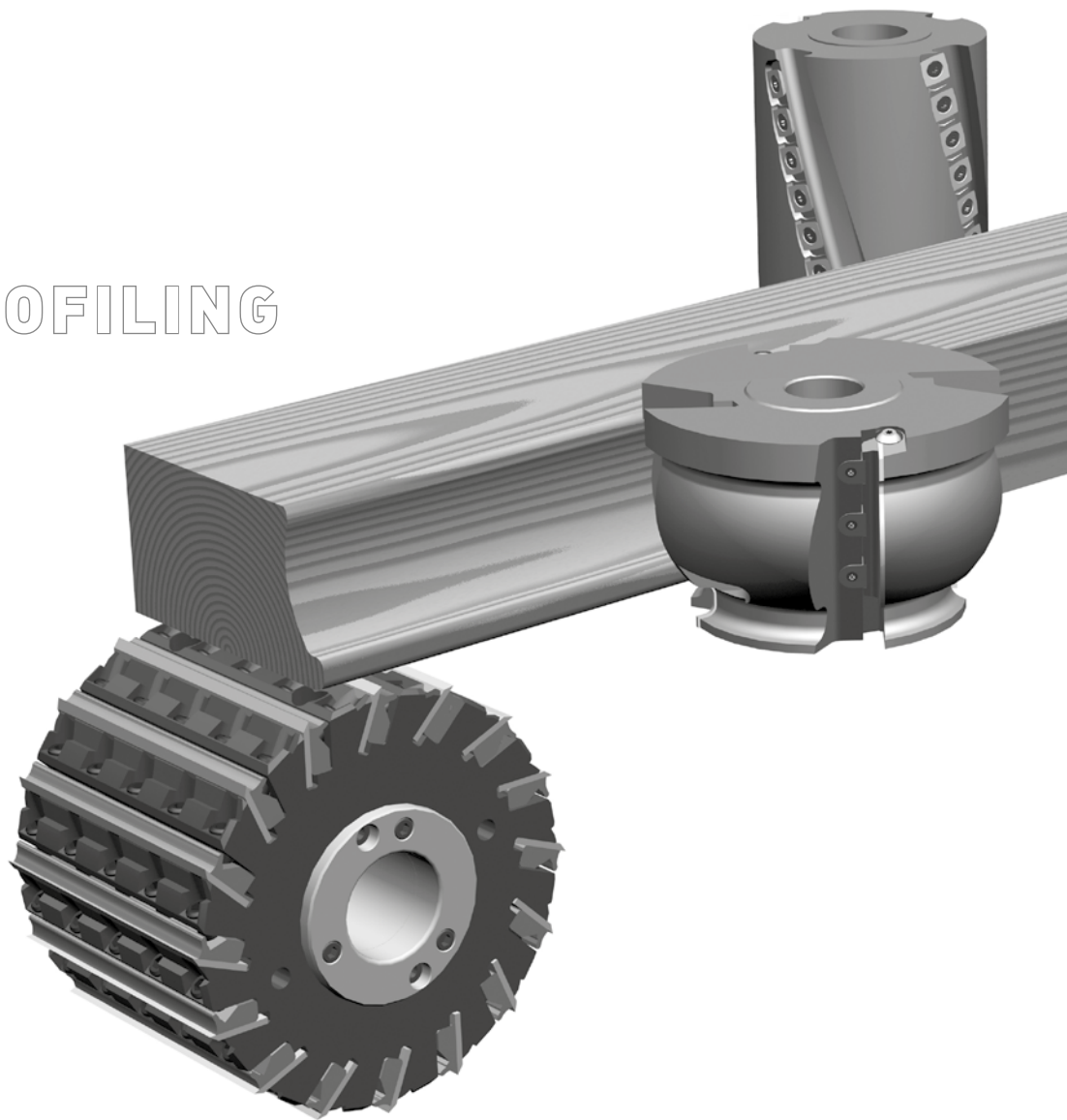
Finger joint cutters - cross cutting with extended finger joint profile

Finger length [mm]	For machines with sizing device	For machines without sizing device	Finger length [mm]
10/10		X	No
10/11	X		10-11
15/15		X	No
15/16,5	X		15-16,5
20/20		X	No
20/22	X		20-22

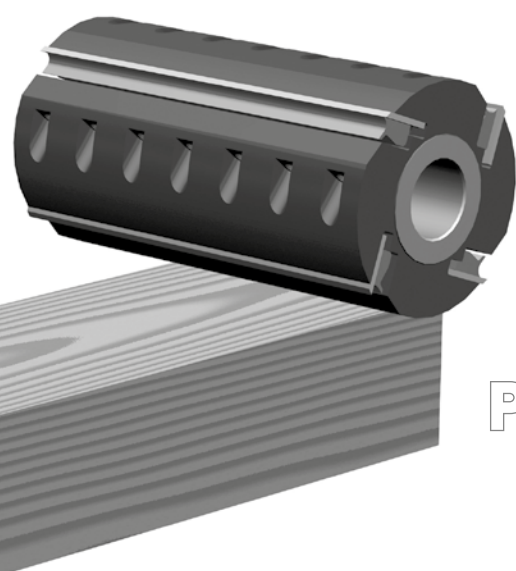
Drawing profile example



PROFILING



Planing/Profiling



PLANING

Product	Page
Planing	84
Profiling	91

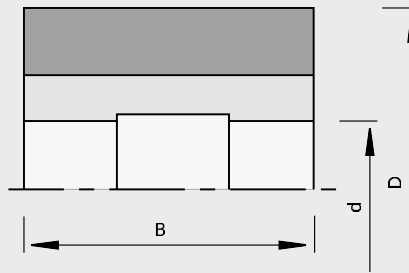
320700

Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- | multi spindle plunging machines
- | for planing of solid woods

Design

- | n max = 9,000 min-1

Advantages

Notes

- | HS-tipped knives (18%) 30x3 mm
- | for adjusting the planing knives 2 adjustment rings are needed
- | alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Ident-No.
125	80	40	4	179204 L
125	100	40	4	181195 L
125	130	40	4	179194 L
125	150	40	4	179195 L
125	180	40	4	179196 C
125	230	40	4	181190 L
[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Pressure Bars	B=80	925300	2	179205 S
Pressure Bars	B=100	925300	2	181191 S
Pressure Bars	B=130	925300	2	179198 C
Pressure Bars	B=150	925300	2	179199 S
Pressure Bars	B=180	925300	2	179200 C
Pressure Bars	B=230	925300	2	181192 C
Adjustment Rings	125x40	985200	2	179201 C
Set Screws	M10x25 DIN EN ISO 4028	995161	10	168108 L
Cranked Wrench Keys	SW5 DIN ISO 2936	985730	1	009674 L
	[mm]		[pc.]	

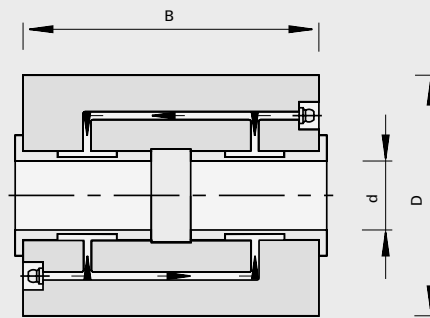
320700

Hydro Planing Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- n max = 9,000 min-1

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
143	60	40	4	27	178104 C
143	130	40	4	27	178105 C
143	230	40	4	27	178106 C
163	60	50	4	27	178107 C
163	100	50	4	27	178108 C
163	130	50	4	27	178109 C
163	150	50	4	27	178110 C
163	180	50	4	27	178112 C
163	230	50	4	27	178113 C
163	260	50	4	27	178115 C
163	310	50	4	27	178116 C
163	60	50	6	27	178117 L
163	100	50	6	27	178118 L
163	130	50	6	27	178119 C
163	150	50	6	27	178120 L
163	180	50	6	27	178122 L
163	230	50	6	27	178123 L
163	260	50	6	27	178125 C
163	310	50	6	27	178126 C
163	60	50	8	25	178127 C
163	100	50	8	25	178128 C
163	130	50	8	25	178129 C
163	150	50	8	25	178130 C
163	230	50	8	25	178131 C
163	260	50	8	25	178132 C
[mm]	[mm]	[mm]		[°]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

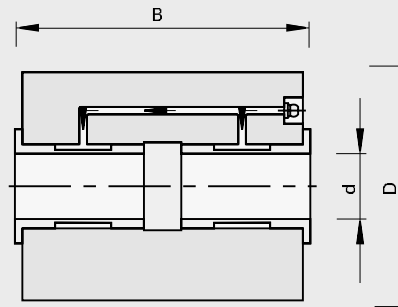
320700

Hydro-Rotaplane Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

- $n_{max} = 6,000 \text{ min}^{-1}$

Advantages

- high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance
- high feed rates and optimum cutting quality

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Ø D	B	Ø d	Z	Hook angle	Ident-No.
203	150	50	6	27	178133 C
203	230	50	6	27	178134 C
203	150	50	8	27	178136 C
203	230	50	8	27	178137 C
203	310	50	8	27	178139 C
203	150	50	10	23	178141 C
203	230	50	10	23	178142 C
203	100	50	12	23	178145 C
203	150	50	12	23	178146 C
203	230	50	12	23	178147 C
203	100	50	16	20	178150 S
203	150	50	16	20	178151 C
[mm]	[mm]	[mm]		[°]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

Spare parts	Class-No.	PU	Ident-No.
Hammer for Releasing the Knives	985740	1	181746 S
HSK-Mounting Device	985202	1	181747 S
		[pc.]	

320608

Profile Cutterheads HS - Powerlock with Weinig HSK (blanks S=5,8,10 mm)

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

- | 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

- | adjustable knives
- | possibility of sideways stop in the cutterhead
- | control of adjusting range of the knives through lunettes
- | picture shows sense of rotation right (acc. to DIN right)
- | for all 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. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 C	182314 C
90	60	Weinig-HSK	2	181766 C	181775 C
90	80	Weinig-HSK	2	181767 C	181776 C
90	100	Weinig-HSK	2	181768 C	181777 C
90	130	Weinig-HSK	2	181769 C	181778 C
90	150	Weinig-HSK	2	181770 C	181779 C
90	170	Weinig-HSK	2	181771 C	181780 C
90	190	Weinig-HSK	2	182313 C	181781 C
90	210	Weinig-HSK	2	181773 C	181782 C
90	240	Weinig-HSK	2	181774 C	181783 C
90	80	Weinig-HSK	4	181785 C	181794 C
90	100	Weinig-HSK	4	181786 C	181795 C
90	130	Weinig-HSK	4	181787 C	181796 C
90	150	Weinig-HSK	4	181788 C	181797 C
90	170	Weinig-HSK	4	181789 C	181798 C
90	190	Weinig-HSK	4	181790 C	181799 C
90	210	Weinig-HSK	4	181791 C	181800 C
90	40	Weinig-HSK	4	182315 C	182316 C
90	60	Weinig-HSK	4	181784 C	182317 C
90	240	Weinig-HSK	4	181792 C	182318 C
[mm]	[mm]	[mm]			

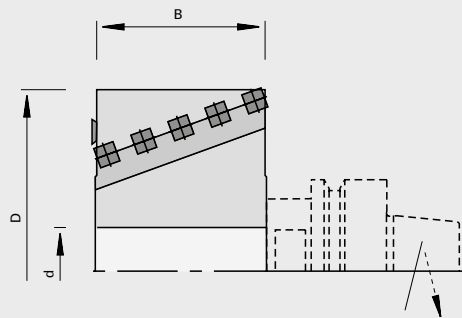
120760

Spiral Cutterheads HW - with spur

Product



Drawing

**LEUCO**
CNC

Tungsten Carbide [HW]

MEC

Machine / Application

| stationary milling centers
 | for dressing, rough-planing,
 jointing, rabbeting, copying
 of solid woods and laminated
 timber

Design

| with four-sided turnover knives,
 with rounded edges
 | 2 front spurs HW
 | spiral cutting layout of turnover
 knives and cut division
 | high-tensile aluminum body

Advantages

| easy hogging, low cutting
 pressure and low noise level
 | high hogging volume

Notes

| for HSK mounting arbors with
 double key without spacers
 | for Ident-No. 183678
 clamping length 50 mm with
 HSK mounting arbor
 | for Ident-No. 183679
 clamping length 80 mm with
 HSK mounting arbor
 | use for HSK mounting arbor
 cutter retaining bolt 173592

Ø D	B	Ø d	Z	DKN	nmax	Ident-No.
80	80	30	2+2+V2	8x3	18000	183678 L
80	100	30	2+2+V2	8x3	18000	183679 L
[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079 L
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150567	10	180454 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws	M5x6 T20 D=Ø9,3	995125	10	176199 L
Countersunk Screws with collar 6 mm	M5x13 T20	995195	10	80306012 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

Accessories	Dimension	Class-No.	PU	Ident-No.
Cutter Retaining Bolts	M16x26xØ42	995190	1	173592 L
	[mm]		[pc.]	

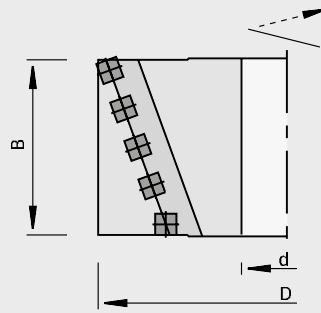
120710

Spiral Cutterheads HW - Steel

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

| Molders
 | Stationary milling centers
 | For trimming, 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
 | Tool body made of steel for particularly high loads

Advantages

| easy hogging, low cutting pressure and low noise level

Notes

| For a medium quality finish cut

Ø D	B	Ø d	Z	DKN	nmax	Ident-No.
125	80	40	2+2	8x3	12000	187665 C
125	100	40	2+2	8x3	12000	187666 C
125	130	40	2+2	8x3	12000	187667 C
125	180	40	2+2	8x3	12000	187668 C
125	230	40	2+2	8x3	12000	187669 C
125	100	40	3+3	8x3	12000	187670 C
125	130	40	3+3	8x3	12000	187671 L
125	150	40	3+3	8x3	12000	187672 C
125	180	40	3+3	8x3	12000	187673 C
125	230	40	3+3	8x3	12000	187674 C
125	240	40	3+3	8x3	12000	187675 C
140	240	40	3+3	8x3	10700	187676 C
[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover knives with rounded edges (rounded R=150 mm)	15	15	2.5	150567	10	187323 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws with collar 6 mm	M5x13 T20	995195	10	80306012 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

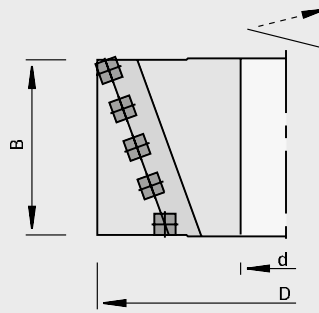
120710

Spiral Cutterheads HW - Aluminum

Product



Drawing



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 a medium quality finish cut

Ø D	B	Ø d	Z	nmax	Ident-No.
100	80	40	2+2	15000	187642 C
125	100	40	2+2	12000	187643 C
125	130	40	2+2	12000	187644 C
125	170	40	2+2	12000	187646 C
125	180	40	2+2	12000	187649 C
125	210	40	2+2	12000	187650 C
125	230	40	2+2	12000	187651 C
125	240	40	2+2	12000	187654 C
125	100	40	3+3	12000	187656 C
125	130	40	3+3	12000	187657 L
125	150	40	3+3	12000	187658 C
125	180	40	3+3	12000	187659 C
125	230	40	3+3	12000	187661 C
125	240	40	3+3	12000	187660 C
140	240	40	3+3	10700	187662 C
[mm]	[mm]	[mm]		[min-1]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Turnover Knives (with rounded edges R=50 mm)	15	15	2.5	150567	10	180454 L
Turnover knives with rounded edges (rounded R=150 mm)	15	15	2.5	150567	10	187323 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Countersunk Screws with collar 6 mm	M5x13 T20	995195	10	80306012 L
Screwdrivers	T20x100	985730	1	166092 L
	[mm]		[pc.]	

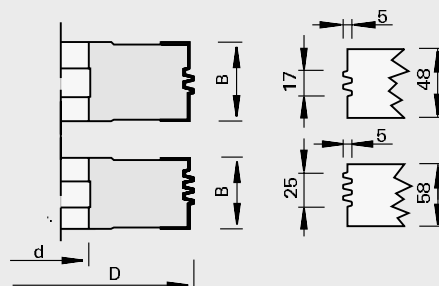
120505

Glue Joint Profile Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- l molders
- l table shapers
- l for cutting of edge glue joints in solid woods

Design

- l cutting edges parallel to cutter axis
- l $n = 5,700 - 9,800 \text{ min}^{-1}$

Advantages

- l continuous high profile accuracy thanks to turnover knives

Notes

- l application against feed
- l fit of joints can be defined by moving the knives sideways by means of dials (see spare parts)
- l when delivered, tool is set to 0.3 mm joint play

Ø D	B	Ø d	Ø dmax	Z	H	Ident-No.
135	50	30	50	2	17-48	177007 L
135	60	30	50	2	25-58	177008 C
[mm]	[mm]	[mm]	[mm]		[mm]	

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
	50	23	2.0	151555	2	180431 L
	60	23	2.0	151555	2	180432 L
	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	177007	925300	2	50591365 L
Pressure Bars	58x11x6	177008	925300	2	180434 L
Clamping Pieces	12x8,5/M8L	For all	925100	2	180357 L
Clamping Set Screws	M8x26 SW4	For all	995191	10	180340 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Setting Discs	0,1 + 0,15	995490	1	180435 L
Setting Discs	0,15 + 0,2	995490	1	180436 L
Setting Discs	0,2 + 0,25	995490	1	180437 L
Setting Discs	0,25 + 0,3	995490	1	180438 L
Setting Discs	0,3 + 0,35	995490	1	180439 L
	[mm]		[pc.]	

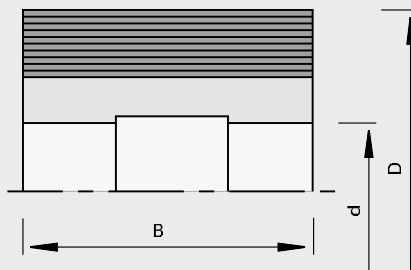
320600

Profile Cutterheads

Product



Drawing



MEC

Machine / Application

- l molders
- l for profiling of solid woods

Design

- l hook angle 25 degrees

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 Ø 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

Ø D	B	Ø d	Z	Ident-No.
122	40	40	4	179208 L
122	60	40	4	179209 L
122	80	40	4	179210 L
122	100	40	4	179211 L
122	130	40	4	179212 L
122	150	40	4	179213 L
122	180	40	4	179214 L
122	230	40	4	179215 C
137	60	50	4	179216 L
137	80	50	4	179217 C
137	100	50	4	179218 C
137	150	50	4	179219 C
137	180	50	4	179220 C
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	B=40	925300	2	179221 S
Pressure Bars	B=60	925300	2	179222 C
Pressure Bars	B=80	925300	2	179223 C
Pressure Bars	B=100	925300	2	179224 C
Pressure Bars	B=130	925300	2	179225 S
Pressure Bars	B=150	925300	2	179226 S
Pressure Bars	B=180	925300	2	179227 S
Pressure Bars	B=230	925300	2	179228 S
Dummy Pieces	40x20x8	925900	2	179229 C
Dummy Pieces	60x20x8	925900	2	179230 C
Dummy Pieces	80x20x8	925900	2	179231 S
Dummy Pieces	100x20x8	925900	2	179232 C
Dummy Pieces	130x20x8	925900	2	179233 C
Dummy Pieces	150x20x8	925900	2	179234 C
Dummy Pieces	180x20x8	925900	2	179235 S
Dummy Pieces	230x20x8	925900	2	179236 C
Set Screws	M10x20 DIN EN ISO 4028	995161	10	815807 L
Screwdrivers	SW5x150	985730	1	168703 L
	[mm]		[pc.]	

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
Dmax at D=137	176	176	186	196	196	216	216

Maximum RPM

B (mm)	50	55	60	70
Dmax at D=122	161	171	181	201
Max.RPM (min-1):	9000	8400	8000	7200
Dmax at D=137	176	186	196	216
Max.RPM (min-1):	8200	7700	7300	6600

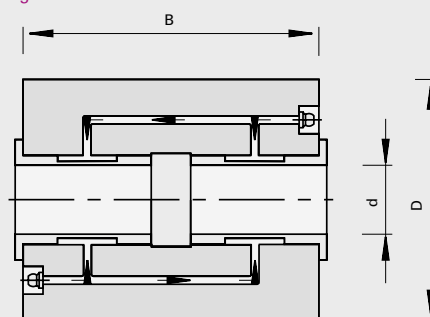
320600

Hydro Profile Cutterheads HS

Product



Drawing



MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- the max. RPM depends from the knife height (see table "Max. RPM")

Advantages

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

Notes

- adjustable knives
- profile depth and cutting circle Ø see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutter-head and wedges; for blanks see chapter Turnover knives, Profile Knives, Knives

Ø D	B	Ø d	Z	Ident-No.
137	60	40	4	176342 C
137	100	40	4	176343 C
137	130	40	4	176344 C
137	150	40	4	176345 C
137	180	40	4	176346 C
137	230	40	4	176347 C
150	60	50	4	176348 L
150	60	50	6	176349 L
150	100	50	4	176350 C
150	100	50	6	176351 C
150	130	50	4	176352 C
150	130	50	6	176353 C
150	150	50	4	176354 C
150	150	50	6	176355 C
150	180	50	4	176356 C
150	180	50	6	176357 C
[mm]	[mm]	[mm]		

Ø D	B	Ø d	Z	Ident-No.
150	230	50	4	176358 C
150	230	50	6	176359 C
150	260	50	4	176360 C
150	260	50	6	176361 C
150	310	50	4	176362 C
150	310	50	6	176363 C
163	60	50	8	176364 L
163	100	50	8	176365 C
163	130	50	8	176366 C
163	150	50	8	176367 C
163	180	50	8	176368 C
163	230	50	8	176369 C
163	260	50	8	176370 C
163	310	50	8	176371 C
195	60	50	10	176372 C
195	100	50	10	176373 C
195	130	50	10	176374 C
195	150	50	10	176375 C
215	60	50	12	176380 C
215	100	50	12	176381 C
215	130	50	12	176382 C
215	150	50	12	176383 C
[mm]	[mm]	[mm]		

Spare parts	Dimension	Class-No.	PU	Ident-No.
Set Screws	M12x25 DIN EN ISO 4028	995161	10	181466 L
Screwdrivers	SW6x200	985730	1	167817 L
Grease presses		993270	1	163706 L
Grease Cartridges		993270	1	163707 L
	[mm]		[pc.]	

Maximum cutting circle diameter

	HS	HW	ST	HS	HW	HS	ST
Knife height H [mm]	50	50	55	60	60	70	70
Knife thickness S [mm]	8	10	10	8	10	8	10
Profile depth T [mm]	12	10	15	20	18	30	27
Dmax at D=137	174	174	184	194	194	214	214
Dmax at D=150	189	189	199	209	209	229	229
Dmax at D=163	202	202	212	222	222	242	242

Maximum RPM

	50	55	60	70
Dmax for D=215				
Dmax at D=137	174	184	194	214
Max.RPM (min-1):	8300	7800	7400	6700
Dmax at D=150	189	199	209	229
Max.RPM (min-1):	7700	7300	6900	6300
Dmax at D=163	202	212	222	242
Max.RPM (min-1):	7200	6800	6500	6000
Dmax for D=195	254	264	274	294
Max.RPM (min-1):	5700	5400	5200	4900

320608

Profile Cutterheads HS - Powerlock with Weinig HSK (blanks S=5,8,10 mm)

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

- | 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

- | adjustable knives
- | possibility of sideways stop in the cutterhead
- | control of adjusting range of the knives through lunettes
- | picture shows sense of rotation right (acc. to DIN right)
- | for all 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. [L]	Ident-No. [R]
90	40	Weinig-HSK	2	182312 C	182314 C
90	60	Weinig-HSK	2	181766 C	181775 C
90	80	Weinig-HSK	2	181767 C	181776 C
90	100	Weinig-HSK	2	181768 C	181777 C
90	130	Weinig-HSK	2	181769 C	181778 C
90	150	Weinig-HSK	2	181770 C	181779 C
90	170	Weinig-HSK	2	181771 C	181780 C
90	190	Weinig-HSK	2	182313 C	181781 C
90	210	Weinig-HSK	2	181773 C	181782 C
90	240	Weinig-HSK	2	181774 C	181783 C
90	80	Weinig-HSK	4	181785 C	181794 C
90	100	Weinig-HSK	4	181786 C	181795 C
90	130	Weinig-HSK	4	181787 C	181796 C
90	150	Weinig-HSK	4	181788 C	181797 C
90	170	Weinig-HSK	4	181789 C	181798 C
90	190	Weinig-HSK	4	181790 C	181799 C
90	210	Weinig-HSK	4	181791 C	181800 C
90	40	Weinig-HSK	4	182315 C	182316 C
90	60	Weinig-HSK	4	181784 C	182317 C
90	240	Weinig-HSK	4	181792 C	182318 C
[mm]	[mm]	[mm]			

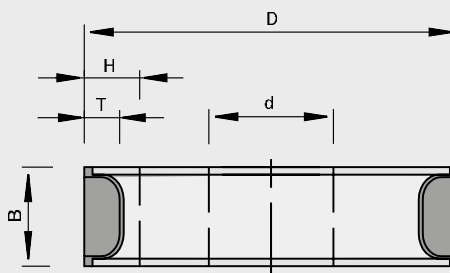
120606

SuperProfiler HW (inside profile) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

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

Design

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

Advantages

cutterhead for mounting of several profile knives

Notes

application against feed
profile knife can be profiled per customer specifications
included in delivery: cutterhead with clamping elements, without profile knives, support plates and deflectors

Ø D	B	Ø d	Ø dmax	Tmax	Z	Drawing	Ident-No. unprofiled
125	40	30	35	13	2	SP 1	167263 L
125	60	30	35	15	2	SP 2	167264 C
[mm]	[mm]	[mm]	[mm]	[mm]		[Foil]	

Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 1	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 1	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 2	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 2	152529	10	177368 L
support plates	40	26.5		SP 1	925402	2	178007 L
support plates	60	28.5		SP 2	925402	2	178008 L
deflector plates	40	28		SP 1	925407	1	167267 L
deflector plates	60	30		SP 2	925407	1	167268 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167263	925300	2	166737 L
Pressure Bars	58x12x8	167264	925300	2	166738 L
Special Set Screws	M8x24	For all	995191	10	167269 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

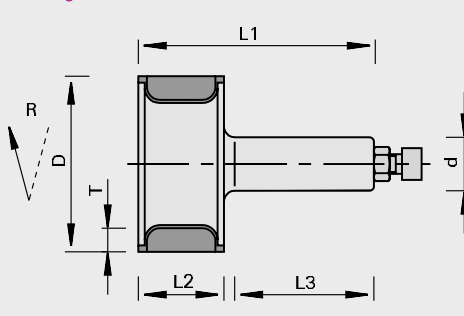
128612

SuperProfiler Shank-Type Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- | CNC routers
- | for profiling of solid woods and wood materials

Design

- | cutting edges parallel to cutter axis
- | cutting material: HW HL Board 06 for hard woods and wood-based panels
- | cutting material: HW HL Solid 60 for soft woods

Advantages

- | cutterhead for mounting of several profile knives

Notes

- | profile knife can be profiled according to customer specifications
- | Clamping elements: ps-System, TRIBOS, draw-in collet chuck
- | included in delivery: cutterhead body with clamping elements without profile knives and support plates

Ø D	L2	Ø d	L3	L1	Tmax	Z	nmax	Drawing	Ident-No. [L] unprofiled	Ident-No. [R] unprofiled
82	40	20	55	110	11	2	12000	SP 19		167479 C
82	40	25	55	110	11	2	18000	SP 19	167835 C	167834 L
82	40	MK 2	55	127	11	2	18000	SP 19		167483 S
86	60	25	55	130	13	2	10000	SP 31		176241 L
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]	[Foil]		

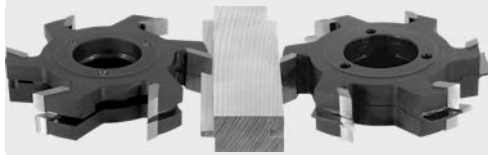
Blanks	B	H	LEUCODUR	Drawing/Foil	Class-No.	PU	Ident-No.
SP blanks	40,6	28.2	HL Board 06	SP 19	152526	10	179112 L
SP blanks	40,6	28.2	HL Solid 60	SP 19	152529	10	177367 L
SP blanks	60,8	30.2	HL Board 06	SP 31	152526	10	179113 L
SP blanks	60,8	30.2	HL Solid 60	SP 31	152529	10	177368 L
support plates	40	26.5		SP 19	925402	2	178007 L
support plates	60	28.5		SP 31	925402	2	178008 L
	[mm]	[mm]				[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	36x12x8	167835	925300	2	166736 L
Pressure Bars	36x12x8	167479, 167483, 167834	925300	2	166737 L
Pressure Bars	58x12x8	176241	925300	2	166738 L
Set Screws	M8x16 DIN EN ISO 4028	For all	995161	10	164422 L
Screwdrivers	SW4x100	For all	985730	1	166091 L
	[mm]			[pc.]	

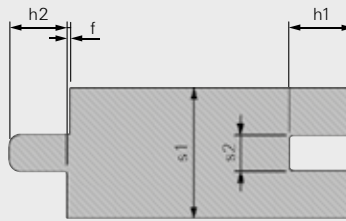
323500

Tongue and Groove Tools HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

| molders
 | double end tenoners
 | for tongue and groove board with or without space allowance in material (=open joint) or chamfer in soft and hard woods

Design

| body made from steel
 | adjustable by means of spacers
 | highest precision thanks to plane parallelism of all parts
 | secured against rotation by means of 3 driving pins on minor diameter 75 mm

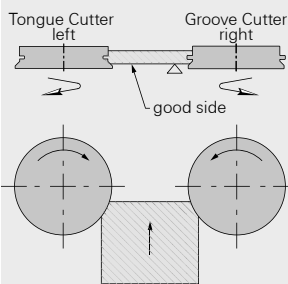
Advantages

Notes

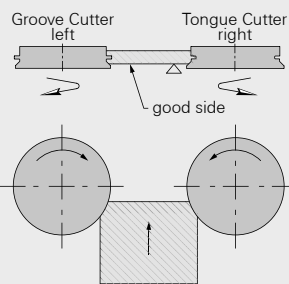
| indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
 | without indications we will deliver according to diagram I
 | delivery with HW-tipping possible with surcharge

Profile	Ø D	B	Ø d	nmax	s1	s2	f	Z	Ident-No.
501/502	180	35	40	8000	12-36	4,5-7,5	0,5	6	58532354 S
505/506	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532358 S
512/513	180	35	40	8000	12-27	4,5-7,5		6+3	58532361 S
503/502	180	35	40	8000	12-36	4,5-7,5		6	58532382 S
529/530	180	35	40	8000	15-27	4,5-7,5	0,5	6	58532384 S
507/508	180	35	40	8000	15-27	4,5-7,5		6	58532387 S
525/526	180	35	40	8000	12-27	4,5-7,5		6+3	58532390 S
541/540	180	35	40	8000	14-19	4,5-7,5		6+3	58532391 S
	[mm]	[mm]	[mm]	[min-1]	[mm]	[mm]	[mm]		

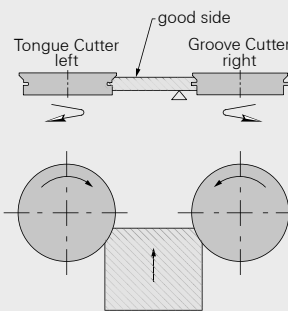
Example I



Example II



Example III



Example IV

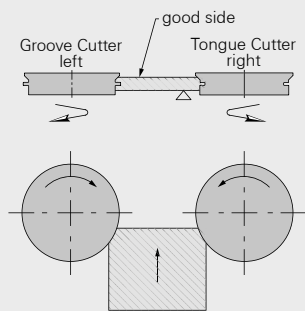
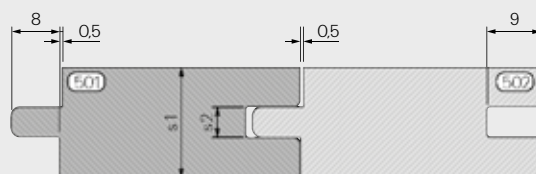


Diagram I

Tongue Cutters

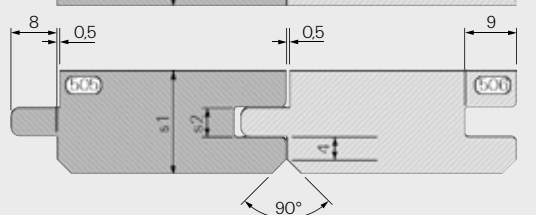
Profile 501



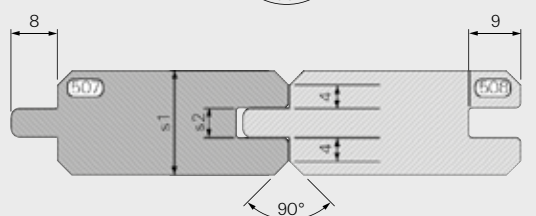
Profile 503



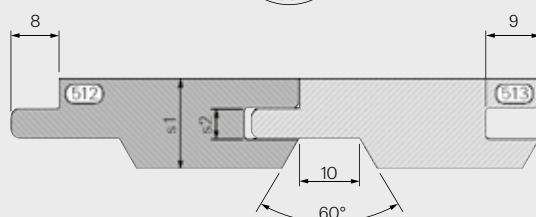
Profile 505



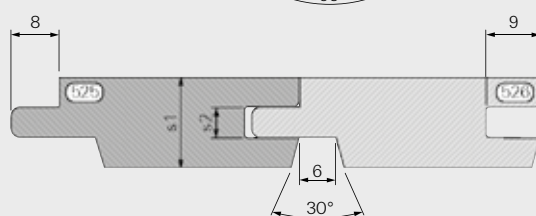
Profile 507



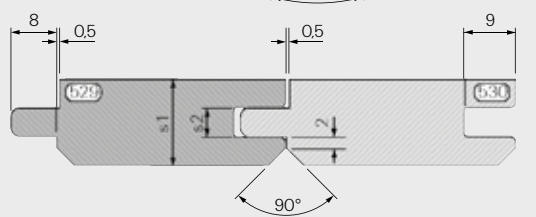
Profile 512



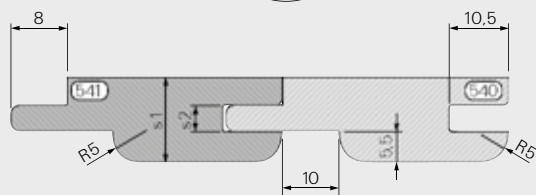
Profile 525



Profile 529



Profile 541



Grooving Cutters

Profile 502

Profile 502

Profile 506

Profile 508

Profile 513

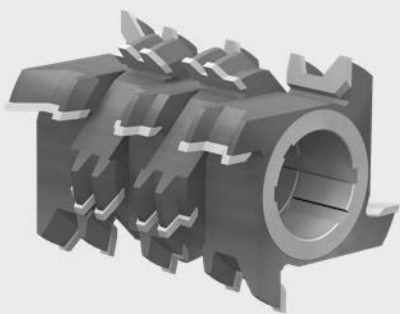
Profile 526

Profile 530

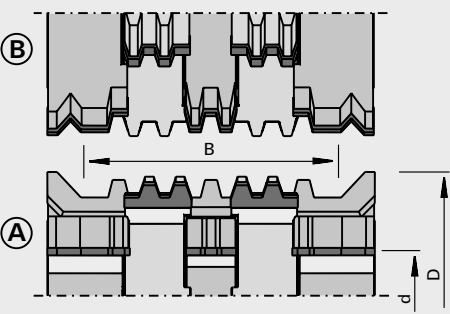
Profile 540

123600
HW Counter Profile Cutter set

Product



Drawing



Tungsten Carbide [HW]

MEC

Machine / Application

- I molders
- I For manufacturing of longitudinal joints on block piles

Design

- I Body made from steel
- I Symmetrical design
- I Double keyway for twist locking

Advantages

- I Maximum possible precision thanks to plane parallelism of all parts

Notes

Ø D	B	Ø d	Z	nmax	Profile	Ident-No.
190	220	80	5x4	8000	A	192657 S
190	220	80	5x4	8000	B	192658 S
[mm]	[mm]	[mm]		[min-1]		

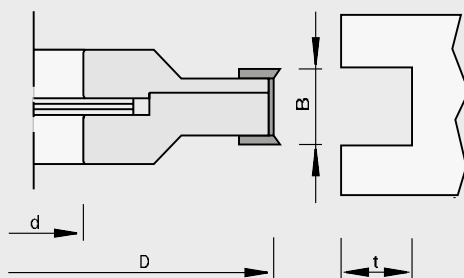
121455

Grooving Cutterheads HW - adjustable 4-15 mm

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

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

Design

Advantages

Notes

| application against feed with and across the grain
 | cutting width 4 - 7.5 mm two-piece
 | cutting width 4 - 15 mm three-piece
 | cutting width adjustable with shims in 0.1 mm increments
 | single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
130	4,0-7,5	30	25	4+4		6000-10000	166509 L
180	4,0-7,5	30	35	8+4		4500-7400	168081 L
180	4,0-7,5	35	35	8+4	10x4	4500-7400	168083 C
180	4,0-7,5	40	35	8+4	12x5	4500-7400	168085 C
180	4,0-7,5	50	30	8+4		4500-7400	168087 C
180	4,0-15	30	35	8+2+4		4500-7400	168080 O
180	4,0-15	35	35	8+2+4	10x4	4500-7400	168082 C
180	4,0-15	40	35	8+2+4	12x5	4500-7400	168084 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Turnover Knives	7,5	12	1.5	168080, 168082, 168084	150515	10	052543 L
Spurs	14	14	1.2	For all	150558	10	163701 L
Turnover Knives	18	18	1.95	For all	150508	10	163699 L
	[mm]	[mm]	[mm]			[pc.]	

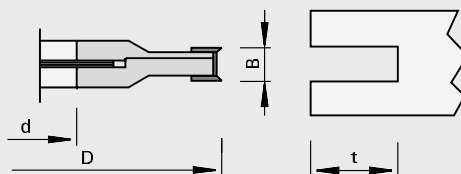
Spare parts		Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars		B=7,2	168080, 168082, 168084	925300	2	168074 L
Set Screws		M5x12 DIN EN ISO 4028	168080, 168082, 168084	995161	10	050565 L
Countersunk Screws		M4x0,5x3,2 T9 D=Ø6	For all	995125	10	163925 L
Spacer Sets		50x3,5x30	166509	955521	1	166367 O
Spacer Sets		65x3,5x30	168080, 168081	955521	1	168075 L
Spacer Sets		70x3,5x35	168083, 168082	955521	1	168076 C
Spacer Sets		70x3,5x40	168084, 168085	955521	1	168077 C
Spacer Sets		90x3,5x50	168087	955521	1	168078 O
Special Nuts	for spurs	M4x0,5x1,6	For all	995290	10	163704 L
Special Nuts	for profile knives	M4x0,5x2,2	For all	995290	10	163703 L
Screwdrivers		SW2,5x100	168080, 168082, 168084	985730	1	168010 L
Screwdrivers		T9	For all	985730	1	164344 L
		[mm]				

121455

Grooving Cutterheads HW - adjustable 8-24 mm

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

Design

Advantages

Notes

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

| application against feed with and across the grain
 | cutting width 8 - 15 mm and 12,6 - 24 mm two-piece
 | cutting width adjustable with shims in 0.1 mm increments
 | single cutterheads and spacers secured against rotation with pins

Ø D	B	Ø d	Tmax	Z	DKN	nmin-nmax	Ident-No.
180	8,0-15	30	35	4+4		4500-7400	178725 L
180	8,0-15	35	35	4+4	10x4	4500-7400	178726 C
180	8,0-15	40	35	4+4	12x5	4500-7400	178727 C
180	12,6-24	30	40	4+4		4500-7400	178729 L
180	12,6-24	35	40	4+4	10x4	4500-7400	178730 C
180	12,6-24	40	40	4+4	12x5	4500-7400	178731 C
[mm]	[mm]	[mm]	[mm]		[mm]	[min-1]	

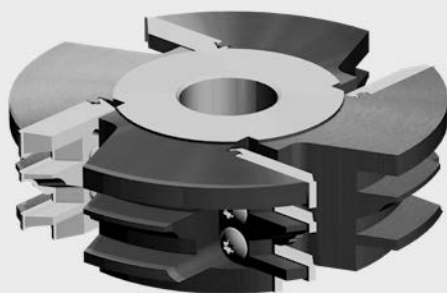
Turnover Knives	B	H	S	For Ident-No.	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	For all	150558	10	003079 L
Turnover Knives	7,5	12	1.5	178725, 178726, 178727	150515	10	052543 L
Turnover Knives	12	12	1.5	178729, 178730, 178731	150515	10	003080 L
	[mm]	[mm]	[mm]			[pc.]	

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=10	178730, 178729, 178731	925300	2	164526 L
Pressure Bars	B=7,2	178727, 178726, 178725	925300	2	168074 L
Countersunk Screws	M5x6 T20 D=Ø9,3	For all	995125	10	176199 L
Set Screws	M5x12 DIN EN ISO 4028	178727, 178726, 178725	995161	10	050565 L
Set Screws	M6x12 DIN EN ISO 4028	178730, 178729, 178731	995161	10	180214 L
Spacer Sets	65x11,5x30	178729	955521	1	167278 O
Spacer Sets	70x11,5x35	178730	955521	1	167279 S
Spacer Sets	70x11,5x40	178731	955521	1	167280 C
Spacer Sets	65x7x30	178725	955521	1	167282 O
Spacer Sets	70x7x35	178726	955521	1	167283 S
Spacer Sets	70x7x40	178727	955521	1	167284 S
Screwdrivers	SW3x100	178730, 178729, 178731	985730	1	166090 L
Screwdrivers	SW2,5x100	178727, 178726, 178725	985730	1	168010 L
Screwdrivers	T20x100	For all	985730	1	166092 L
Adjusting Gauges	0,3	For all	985200	1	055883 L
	[mm]			[pc.]	

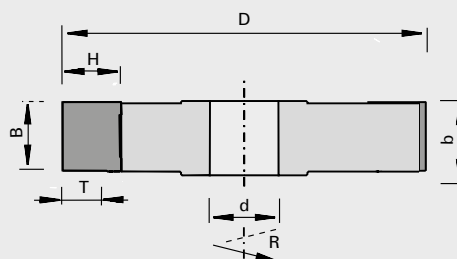
120604/120606

UltraProfiler plus - Cutterheads HW (straight) - MAN

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

| machining centers
 | double end tenoners
 | molders
 | table shapers
 | for profiling of solid woods and wood-based panels

Design

| cutterhead body made from extremely tight aluminum alloy
 | with shear angle
 | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

| large profile depths possible
 | cutterhead body and knives will be profiled according to customer specifications
 | cutting speed up to 80 m/s
 | concentric accuracy 0,03 mm

Notes

| knives available in Topline design (polished face, ultra-fine ground clearance surface)
 | with a larger shear angle, the number of teeth may be lower
 | sense of rotation according to VDMA 8849

Ø D	B	H	Ø d	Ø dmax	Z	nmin-nmax
115	15	30	30	30	2-3	6500-13300
125	15-60	40	30	30	2-4	6500-12300
150	15-60	40	30	50	2-6	5500-10200
180	15-60	40	30	50	2-6	5000-8500
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	T	Class-No.	PU	Ident-No.
	15	30.4	2.0	HL Board 06	11	152516	10	183056 L
	20	40.4	2.0	HL Board 06	21	152516	10	183057 L
	25	40.4	2.0	HL Board 06	21	152516	10	183058 C
	32	40.4	2.0	HL Board 06	26	152516	10	182419 L
	40	40.4	2.0	HL Board 06	26	152516	10	182420 L
	50	40.4	2.0	HL Board 06	26	152516	10	182421 L
	60	40.4	2.0	HL Board 06	26	152516	10	182422 L
	[mm]	[mm]	[mm]		[mm]		[pc.]	

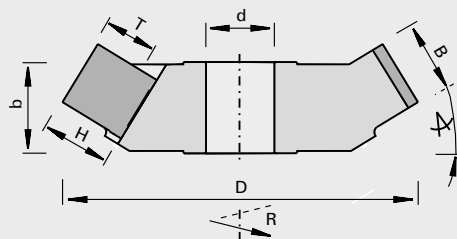
Blanks	B	H	S	LEUCODUR	T	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	15	30.4	2.0	HL Board 06 topline	11	152716	10	183680 S	183680 S
	20	40.4	2.0	HL Board 06 topline	21	152716	10	183681 S	183681 S
	25	40.4	2.0	HL Board 06 topline	21	152716	10	183682 S	183682 S
	32	40.4	2.0	HL Board 06 topline	26	152716	10	182563 C	182562 C
	40	40.4	2.0	HL Board 06 topline	26	152716	10	182565 S	182564 S
	60	40.4	2.0	HL Board 06 topline	26	152716	10	182569 S	182568 S
	[mm]	[mm]	[mm]		[mm]		[pc.]		

120614/120616

UltraProfiler plus - Cutterheads HW (cranked) - MAN

Product

Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

| machining centers
 | double end tenoners
 | molders
 | table shapers
 | for profiling of solid woods and wood-based panels

Design

| cutterhead body made from extremely tight aluminum alloy
 | with shear angle
 | cutting material: HW HL Board 06 for solid woods and wood-based panels

Advantages

| large profile depths possible
 | cutterhead body and knives will be profiled according to customer specifications
 | cutting speed up to 80 m/s
 | concentric accuracy 0,03 mm

Notes

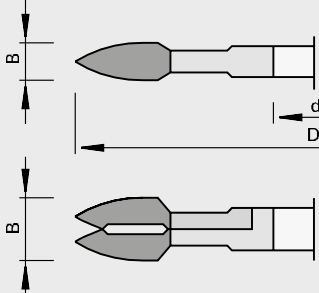
| knives available in Topline design (polished face, ultra-fine ground clearance surface)
 | with a larger shear angle, the number of teeth may be lower
 | sense of rotation according to VDMA 8849

Ø D	B	H	Ø d	Ø dmax	Z	nmin-nmax
150	32-40	40	30	30	2-6	5100-10200
165	32-50	40	30	30	2-6	5100-9200
180	40-60	40	30	50	2-6	5000-8500
195	40-60	40	30	50	2-8	4800-7800
[mm]	[mm]	[mm]	[mm]	[mm]		[min-1]

Blanks	B	H	S	LEUCODUR	T	Class-No.	PU	Ident-No.
	32	40.4	2.0	HL Board 06	26	152516	10	182419 L
	40	40.4	2.0	HL Board 06	26	152516	10	182420 L
	50	40.4	2.0	HL Board 06	26	152516	10	182421 L
	60	40.4	2.0	HL Board 06	26	152516	10	182422 L
	[mm]	[mm]	[mm]		[mm]		[pc.]	

Blanks	B	H	S	LEUCODUR	T	Class-No.	PU	Ident-No. [L]	Ident-No. [R]
	32	40.4	2.0	HL Board 06 topline	26	152716	10	182563 C	182562 C
	40	40.4	2.0	HL Board 06 topline	26	152716	10	182565 S	182564 S
	60	40.4	2.0	HL Board 06 topline	26	152716	10	182569 S	182568 S
	[mm]	[mm]	[mm]		[mm]		[pc.]		

122415
Cutters HW for removing resin pockets

Product		Drawing			
				 Tungsten Carbide [HW] MAN	
Machine / Application		Design		Advantages	
I Mini-Spot machines I for cutting out defects in solid woods		I with alternating shear angle		Notes	
				I for patch sizes 1-4	
Ø D	B	Ø d	Z	NL	Ident-No.
100	8,0	22	4	4/4,3/36	7700-13300 180469 L
100	15	22	4		7700-13300 70176420 S
[mm]	[mm]	[mm]			[min-1]

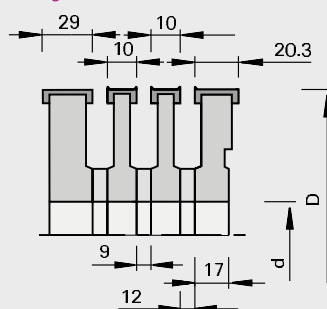
120450

Groove Bed Cutterheads HW

Product



Drawing



Machine / Application

- l molders with groove bed section Weinig
- l for cutting of guide grooves in solid woods

Design

- l n max = 10,700 min-1
- l single tools with spur
- l Ident-No. 180536, 186498 without spur

Advantages

Notes

- l application with the grain
- l attention: replacement parts for old cutterhead sets: cutterhead width = 9 mm can be replaced with new cutterhead width = 10 mm when spacer width = 10 mm is replaced with spacer width = 9 mm cutterhead width = 10.5 mm can be replaced with cutterhead width = 10 mm

Ø D	B	Ø d	Z	Ident-No.
140	10	40	2+2	176066 L
140	20,3	40	2+2	176067 L
140	29	40	2	180536 S
140	39,5	40	2	186498 C
140	10	50	2+2	176069 L
140	20,3	50	2+2	176070 L
[mm]	[mm]	[mm]		

Spare parts	Ø D	B	Ø d	Class-No.	PU	Ident-No.
Spacers	70	9	40	955520	1	177308 C
Spacers	70	10	40	955520	1	185420 L
Spacers	70	12	40	955521	1	162706 O
Spacers	70	9	50	955520	1	177309 C
Spacers	70	10	50	955520	1	163886 C
Spacers	70	12	50	955521	1	163887 C
	[mm]	[mm]	[mm]			

Turnover Knives	B	H	S	Class-No.	PU	Ident-No.
Spurs	14	14	2.0	150558	10	003079 L
Turnover Knives	9,6	12	1.5	150515	10	171163 L
Turnover Knives	20	12	1.5	150516	10	178287 L
Turnover Knives	29,5	12	1.5	150515	10	180825 L
Turnover Knives	39,5	12	1.5	150515	10	171149 L
	[mm]	[mm]	[mm]		[pc.]	

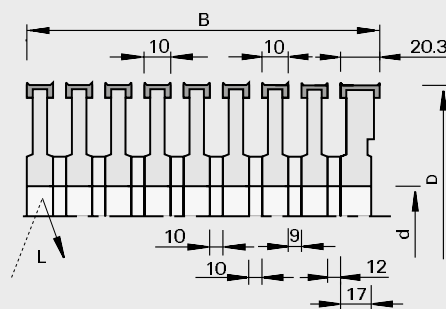
Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=7,2	176066, 176069	925300	2	168074 L
Set Screws	M5x12 DIN EN ISO 4028	176066, 176069	995161	10	050565 L
Countersunk Screws	M5x6 T20 D=Ø9,3	176066, 176069	995125	10	176199 L
Adjusting Gauges	0,7	176066, 176069	985200	1	056096 L
Pressure Bars	B=17	176067, 176070	925300	2	167971 L
Set Screws	M8x16 DIN EN ISO 4028	176067, 176070, 180536	995161	10	164422 L
Countersunk Screws	M5x10,8 T15 D=Ø9,4	176067, 176070	995125	10	180840 L
Adjusting Gauges	1,0	176067, 176070, 180536, 186498	985200	1	011103 L
Pressure Bars	B=30	180536	925300	2	164185 L
	[mm]				[pc.]

Spare parts	Dimension	For Ident-No.	Class-No.	PU	Ident-No.
Pressure Bars	B=38	186498	925300	2	50775234 L
Set Screws	M6x12 T15	186498	995195	10	50930404 L
Screwdrivers	SW2,5x100	176066, 176069	985730	1	168010 L
Screwdrivers	SW4x100	176067, 176070, 180536	985730	1	166091 L
Screwdrivers	T15x80	176067, 176070	985730	1	171188 L
Screwdrivers	T15x140	186498	985730	1	179145 L
Screwdrivers	T20x100	176066, 176067, 176069, 176070, 180536	985730	1	166092 L
	[mm]			[pc.]	

Groove Bed Cutterhead Sets HW



Drawing



LEUCODUR

MEC

Advantages

! n max = 10,000 min⁻¹

- | application with the grain
- | complete tool sets for specific wood widths "B"

Ø D	B	Ø d	Z	Ident-No.
140	80	35	2+2	176071 S
140	100	35	2+2	176072 S
140	120	35	2+2	176073 S
140	140	35	2+2	176074 S
140	170	35	2+2	176075 S
140	80	40	2+2	176076 S
140	100	40	2+2	176077 S
140	120	40	2+2	176078 S
140	140	40	2+2	176079 S
140	170	40	2+2	176080 O
140	80	50	2+2	176081 S
140	100	50	2+2	176082 S
140	120	50	2+2	176083 S
140	140	50	2+2	176084 S
140	170	50	2+2	176085 S
[mm]	[mm]	[mm]		

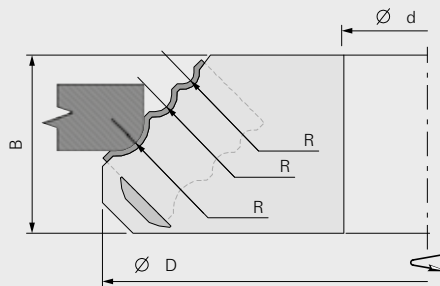
120325

Round Star Cutterheads HW

Product



Drawing



Tungsten Carbide [HW]

MAN

Machine / Application

- spindle moulder
- for profiling of solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW HL Solid 20
- high-tensile aluminum body
- chip limiter design

Advantages

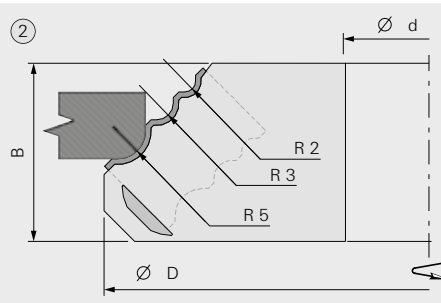
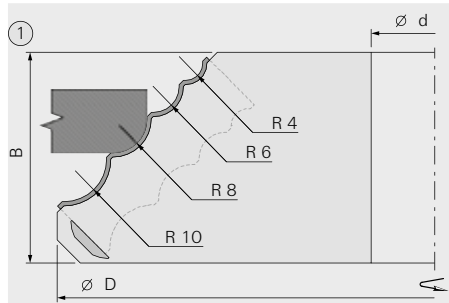
Notes

- application against feed

R	Ø D	B	Ø d	Z	Type	nmin-nmax	Ident-No.
2, 3, 5	140	32	30	2	2	5400-6400	50661673 C
4, 6, 8, 10	180	50	30	2	1	4600-7800	50661672 S
[mm]	[mm]	[mm]	[mm]			[min-1]	

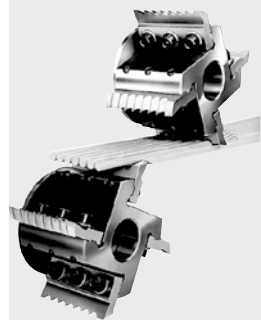
Turnover Knives	Type	R	B	H	S	Class-No.	PU	Ident-No.
Profile Knives KB19	2	2, 3, 5	25	16	2.0	151547	2	50820002 L
Profile Knives KB20	1	4,6,8,10	50	16	2.0	151547	2	50820001 L
		[mm]	[mm]	[mm]	[mm]		[pc.]	

Spare parts	Dimension	Class-No.	PU	Ident-No.
Pressure Bars	48x11x6	925300	2	180346 L
Clamping Pieces	12x8,5/M8L	925100	2	180357 L
Clamping Set Screws	M8x26 SW4	995191	10	180340 L
Screwdrivers	SW4x100	985730	1	166091 L
	[mm]		[pc.]	

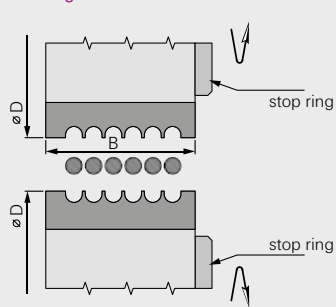


Multi Dowel Cutterheads HS

Product



Drawing



High Speed Steel [HS]

MEC

Machine / Application

| multi spindle milling machines
 | for the production of smooth
 round bars of 2 to 16 mm and
 of corrugated dowels of 6.1 to
 16.1 mm in solid woods

Design

| body made from steel
 | 2 or 4 knife holders

Advantages

| quick knife change
 | self-centering knife seat

Notes

| guide-plate for axial adjust-
 ment of knives
 | further profiles on request

Ø D	B	Ø d	Ø dmax	Z	nmax	Ident-No.
102	50	35	40	2	6000	50389261 C
102	75	35	40	2	6000	50389262 S
102	100	35	40	2	6000	50389263 S
102	50	40	40	2	6000	50389264 C
102	75	40	40	2	6000	50389265 S
102	100	40	40	2	6000	50389266 S
102	125	40	40	2	6000	50389267 S
102	150	40	40	2	6000	50389268 S
102	50	35	40	4	6000	50389269 S
102	75	35	40	4	6000	50389270 C
102	100	35	40	4	6000	50389271 S
102	50	40	40	4	6000	50389272 S
102	75	40	40	4	6000	50389273 S
102	100	40	40	4	6000	50389274 S
102	125	40	40	4	6000	50389275 S
102	150	40	40	4	6000	50389276 S
[mm]	[mm]	[mm]	[mm]		[min-1]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Head Cap Screws

M8x30-8.8 DIN 7984

995111

10

180005 L

Cranked Wrench Keys

SW6x100

985730

1

180383 C

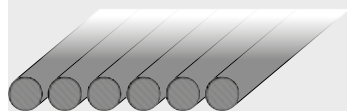
[mm]

[pc.]

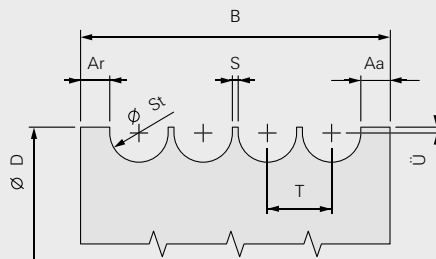
332990

Knives HS - smooth round bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- | small quantities: surcharge of 50%
- | intermediate dimensions: surcharge of 25% on the next lower dimension
- | indicate machine type when placing an order
- | price per piece when ordering 8 identical knives

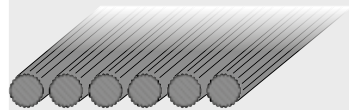
Knives

St= bar Ø	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
S = bridge	1	1	1	1	1	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	3	4	5	6	7	8	9	10	11	12,5	13,5	14,5	15,5	16,5	17,5
D= diameter	127	127	127	127	127	127	135	135	135	135	135	135	135	135	135
B=50 No. of bars	12	9	8	7	6	5	4	4	3	3	3	3	2	2	2
Ident-No. 50...	389200	389201	389202	389203	389204	389205	389206	389207	389208	389209	389210	389211	389212	389213	389214
B=75 No. of bars		16	13	11	9	8	7	6	6	5	5	4	4	4	4
Ident-No. 50...		389215	389216	389217	389218	389219	389220	389221	389222	389223	389224	389225	389226	389227	389228
B=100 No. of bars			18	15	13	11	10	9	8	7	6	6	6	5	5
Ident-No. 50...			389229	389230	389231	389232	389233	389234	389235	389236	389237	389238	389239	389240	389241
B=125 No. of bars				16	14	13	11	10	9	8	8	7	7	7	7
Ident-No. 50...				389242	389243	389244	389245	389246	389247	389248	389249	389250	389251	389252	
B=150 No. of bars							14	13	11	10	9	9	8	8	
Ident-No. 50...							389253	389254	389255	389256	389257	389258	389259	389260	

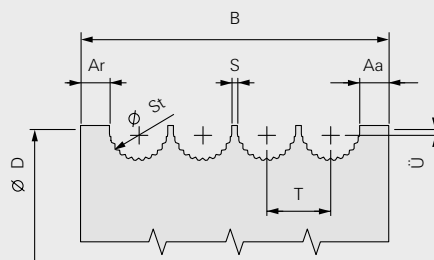
332990

Knives HS - ripple bars

Product



Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

Knives

St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
No. of serrations	16	16	20	22	22	22	22	22	22	22
S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
D= diameter	127	127	135	135	135	135	135	135	135	135
B=50 No. of bars	6	5	4	3	3	3	3	2	2	2
Ident-No. 50...	389300	389301	389302	389303	389304	389305	389306	389307	389308	389309
B=75 No. of bars	9	8	7	6	5	5	4	4	4	3
Ident-No. 50...	389310	389311	389312	389313	389314	389315	389316	389317	389318	389319
B=100 No. of bars	12	11	10	8	7	6	6	5	5	5
Ident-No. 50...	389320	389321	389322	389323	389324	389325	389326	389327	389328	389329
B=125 No. of bars	16	14	13	10	9	8	8	7	7	6
Ident-No. 50...	389330	389331	389332	389333	389334	389335	389336	389337	389338	389339
B=150 No. of bars				12	11	10	9	9	8	8
Ident-No. 50...				389340	389341	389342	389343	389344	389345	389346

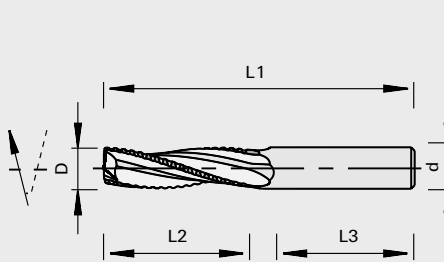
129453

Roughing Cutters VHW - ecoline

Product



Drawing

LEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for rough-cutting in solid woods, plywood and uncoated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | $n_{max} = 30,000 \text{ min}^{-1}$

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | well-priced version

Notes

- | ecoline design = reduced number of traces and less resharpener possibilities
- | slightly rough cutting surface due to fine cut division
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
8.0	32	8,0	35	75	3	positive	183950 L
10	32	10	30	75	3	positive	183951 L
12	42	12	40	90	3	positive	183952 L
16	35	16	38	90	3	positive	183953 L
16	55	16	36	110	3	positive	183954 L
[mm]	[mm]	[mm]	[mm]	[mm]			

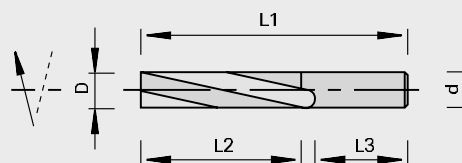
129453

Finishing Cutters VHW - ecoline

Product



Drawing

LEUCO
ecolineLEUCO
DUR

Solid Tungsten Carbide

MEC

Machine / Application

- | CNC routers
- | for finish-cutting in solid woods, plywood and uncoated panels
- | for cutting of cut-outs and contours
- | traveling plunge cut using Z and X or Y axis

Design

- | positive spiral for tightly clamped workpieces face side down
- | negative spiral for smaller workpieces hard to clamp with face side up
- | n max = 30,000 min-1

Advantages

- | high hogging volume
- | optimum upward chip evacuation thanks to positive spiral
- | optimum downward chip evacuation thanks to negative spiral
- | well-priced version

Notes

- | ecoline design = reduced number of traces and less resharping possibilities
- | clamping elements: ps-System with reducing sleeves Class-No. 933280, TRIBOS, draw-in collet chuck

Ø D	L2	Ø d	L3	L1	Z	Helical direction	Ident-No.
3.0	15	3.0	36	60	2	positive	183937 L
3.0	15	6.0	36	60	2	positive	183938 L
4.0	15	4.0	36	60	2	positive	183939 L
4.0	15	4.0	28	60	2	negative	183940 L
4.0	15	6.0	36	60	2	positive	183941 L
5.0	15	6.0	36	60	2	positive	183942 L
6.0	22	6.0	30	60	2	positive	183943 L
6.0	22	6.0	31	65	2	negative	80493083 L
6.0	27	6.0	34	70	2	positive	80106060 L
8.0	30	8.0	36	75	2	positive	183945 L
8.0	30	8.0	36	80	2	negative	80493084 L
10	30	10	35	75	2	positive	183947 L
10	30	10	33	80	2	negative	80493085 L
12	42	12	40	90	3	positive	183949 L
[mm]	[mm]	[mm]	[mm]	[mm]			



CLAMPING SYSTEMS

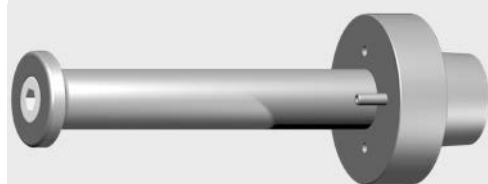
Clamping Systems

Product	Page
Clamping Systems with HSK shank for tools with bore	116

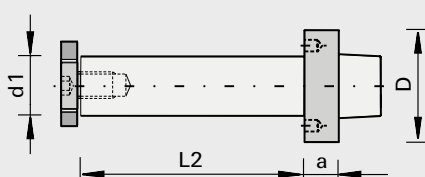
933069

Mounting Arbors Weinig HSK

Product



Drawing



Machine / Application

l profile machines Weinig
Powermat
l for mounting of tools with bore

Design

Advantages

Notes

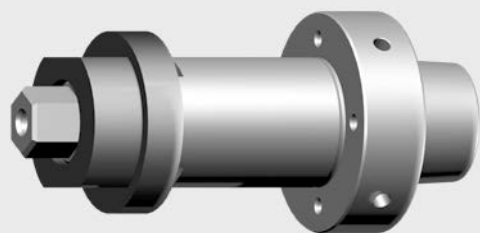
l for right- and lefthand rotation
l other dimensions on request
l for permissible RPM please refer to diagram
l attention: please observe the recommended tightening torque 80 Nm!

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	30	40	26	2/6/48 + 2/M6/48	1.7	182056 L
85	Weinig HSK	30	60	26	2/6/48 + 2/M6/48	1.8	182057 O
85	Weinig HSK	30	80	26	2/6/48 + 2/M6/48	1.9	182058 O
85	Weinig HSK	30	130	26	2/6/48 + 2/M6/48	2.2	182059 C
85	Weinig HSK	30	170	26	2/6/48 + 2/M6/48	2.4	182060 O
85	Weinig HSK	30	240	26	2/6/48 + 2/M6/48	2.8	182061 O
85	Weinig HSK	40	40	26	2/6/54 + 2/M6/54	1.9	182062 L
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.1	182063 L
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.3	182064 L
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	2.8	182065 L
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.2	182066 O
85	Weinig HSK	40	240	26	2/6/54 + 2/M6/54	3.9	182067 O
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

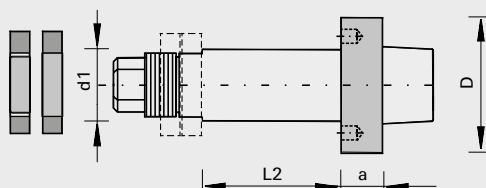
997300

Mounting Arbors Weinig HSK - with spindle nut

Product



Drawing



Machine / Application

l profile machines Weinig
Powermat
l for mounting of tools with bore

Design

l with spindle nut

Advantages

l stable and secure mounting
l twist-lock

Notes

l for right- and lefthand rotation
l other dimensions on request
l for permissible RPM please refer to diagram
l attention: please observe the recommended tightening torque 80 Nm!
l included in delivery: mounting arbor incl. ring and spindle nut

Ø D	Ø d	Ø d1	L2	a	NL	Weight	Ident-No.
85	Weinig HSK	40	40	26	2/6/54 + 2/M6/54	2.48	183281 S
85	Weinig HSK	40	60	26	2/6/54 + 2/M6/54	2.68	183282 S
85	Weinig HSK	40	80	26	2/6/54 + 2/M6/54	2.88	183283 C
85	Weinig HSK	40	100	26	2/6/54 + 2/M6/54	3.08	183284 C
85	Weinig HSK	40	130	26	2/6/54 + 2/M6/54	3.37	183285 C
85	Weinig HSK	40	150	26	2/6/54 + 2/M6/54	3.56	183286 S
85	Weinig HSK	40	170	26	2/6/54 + 2/M6/54	3.76	183287 C
85	Weinig HSK	40	180	26	2/6/54 + 2/M6/54	3.86	183288 C
85	Weinig HSK	40	210	26	2/6/54 + 2/M6/54	4.15	183289 S
85	Weinig HSK	40	230	26	2/6/54 + 2/M6/54	4.35	183290 S
85	Weinig HSK	40	240	26	2/6/54 + 2/M6/54	4.45	183291 C
85	Weinig HSK	40	270	26		4.73	183292 S
85	Weinig HSK	40	310	26		5.12	183293 S
85	Weinig HSK	50	40	26	2/6/74 + 2/M6/64	2.69	183294 S
85	Weinig HSK	50	60	26	2/6/74 + 2/M6/64	3.00	183295 S
85	Weinig HSK	50	80	26	2/6/74 + 2/M6/64	3.31	183296 S
85	Weinig HSK	50	100	26	2/6/74 + 2/M6/64	3.61	183297 C
85	Weinig HSK	50	130	26	2/6/74 + 2/M6/64	4.07	183298 C
85	Weinig HSK	50	150	26	2/6/74 + 2/M6/64	4.38	183299 S
85	Weinig HSK	50	170	26	2/6/74 + 2/M6/64	4.69	183300 S
85	Weinig HSK	50	180	26	2/6/74 + 2/M6/64	4.84	183301 S
85	Weinig HSK	50	210	26	2/6/74 + 2/M6/64	5.30	183302 S
85	Weinig HSK	50	230	26	2/6/74 + 2/M6/64	5.61	183303 S
85	Weinig HSK	50	240	26	2/6/74 + 2/M6/64	5.76	183304 C
85	Weinig HSK	50	270	26		6.20	183305 C
85	Weinig HSK	50	308	26		6.82	183306 S
[mm]	[mm]	[mm]	[mm]	[mm]		[kg]	

Spare parts

Dimension

Class-No.

PU

Ident-No.

Set Screws

M6x16 SW3

995161

10

001617 L

65x15x35

955520

1

80485222 S

Spindle Nuts

M33x1,5

995210

1

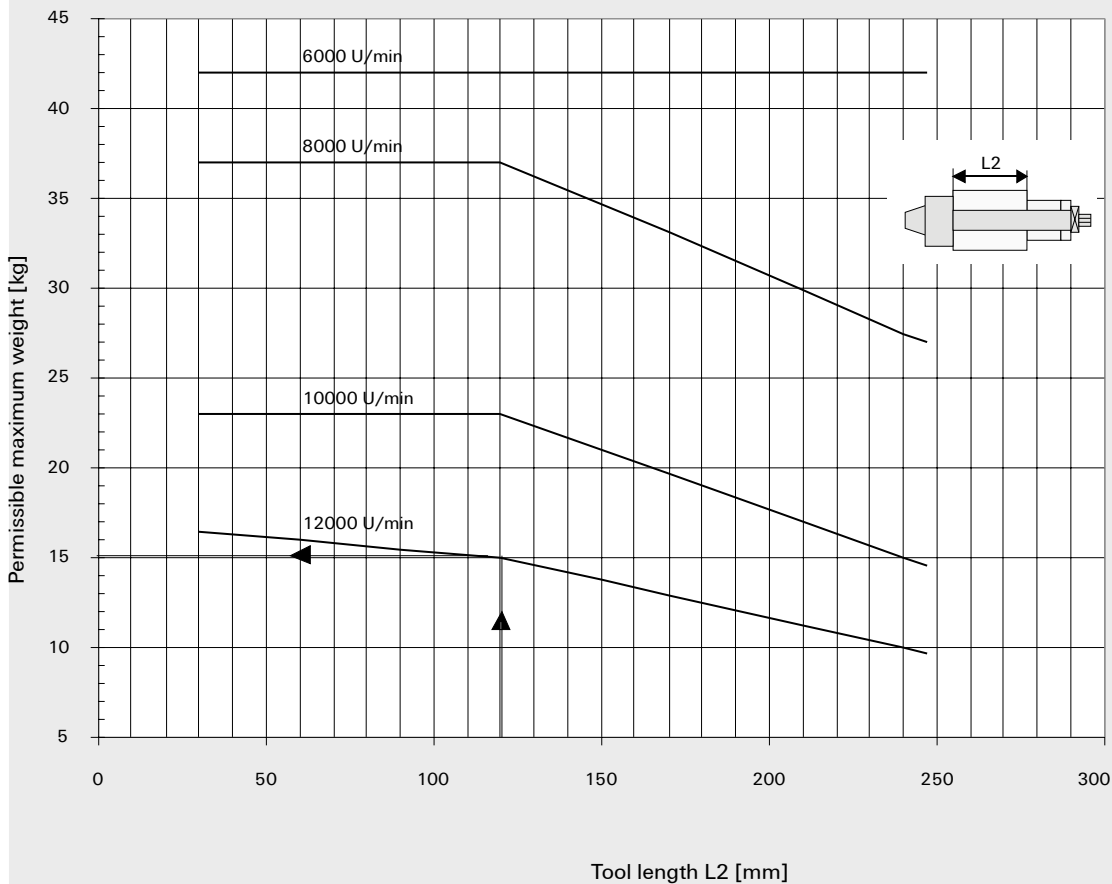
183307 O

[mm]

[pc.]

Adapter Weinig HSK

Diagram for PowerLock-Adapter



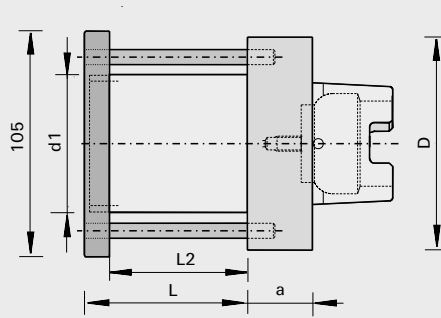
997300

Saw Blade Adapters Weinig HSK

Product



Drawing



Machine / Application

! Weinig Powermat
! for mounting of thin-kerf saw blades

Design

Advantages

Notes

! for clockwise and counter-clockwise rotation
! different diameters upon request

Ø D	Ø d	Ø d1	L2	a	NL	Ident-No.
105	Weinig HSK	60	68	26	3/8/74	182974 C
[mm]	[mm]	[mm]	[mm]	[mm]		

Spare parts

Dimension

Class-No.

PU

Ident-No.

Clamping Nuts	105x15xM58x1,5	995290	1	182993 C
	[mm]		[pc.]	



Spare Parts

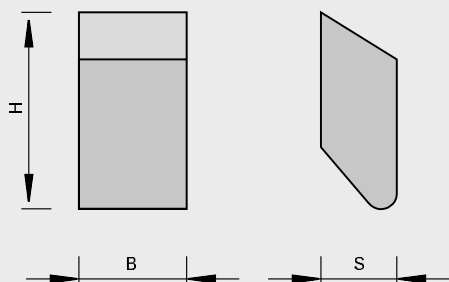
Product	Page
Saw teeth	121
Planing knives	122
Turnover knives/knives	133
Accessory tools	140

153301

Saw Teeth HW for Circular Saw Blades - with solder coating

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

Design

Advantages

Notes

| Solder-coated
 | Cutting material: HW
 | HL Board 06 for wood-based panels, MDF, plastics, particle boards, and exotic wood
 | HL Solid 15 for wood-based panels and hard wood
 | HL Solid 20 for hard wood and soft wood

| easy soldering during tooth installation thanks to solder coating

| packing unit: 500 pieces

B	H	S	LEUCODUR	Ident-No.
2,7	7.1	2.0	HL Board 06	177493 C
2,8	8.0	2.3	HL Solid 15	177500 C
3,6	8.0	2.3	HL Board 06	177494 L
4,3	10.5	3.0	HL Board 06	177496 L
4,5	8.0	2.3	HL Board 06	177495 L
5,0	10.5	3.0	HL Board 06	177497 L
5,0	10.5	3.5	HL Solid 15	80318077 C
5,4	10.5	3.0	HL Board 06	177498 L
5,6	10.5	4.0	HL Solid 20	80369454 C
5,8	10.5	3.5	HL Solid 25	80325122 S
6,0	10.5	3.5	HL Solid 15	80304506 C
6,0	10.5	4.0	HL Solid 15	80352231 S
6,0	12.5	4.0	HL Solid 15	80225542 S
6,0	12.5	4.0	HL Solid 15	177586 L
6,0	12.5	4.0	HL Solid 25	80356362 C
6,0	13	4.0	HL Solid 15	80344985 C
6,5	10.5	3.5	HL Solid 15	80357275 S
6,5	12.5	3.0	HL Solid 15	80373746 O
6,5	13	4.0	HL Solid 15	80344986 C
6,8	12.5	4.0	HL Board 06	177499 L
7,5	10.5	3.5	HL Solid 25	80325124 C
7,5	12.5	3.0	HL Solid 15	80373745 O
7,5	12.5	4.0	HL Solid 15	80282311 S
7,5	13	4.0	HL Board 20	80369455 C
[mm]	[mm]	[mm]		

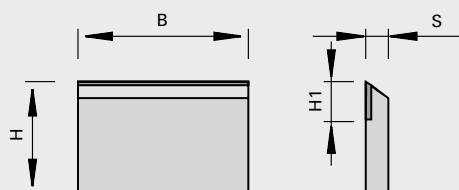
132121

Planing Knives HW

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

I for use in planing cutterheads

Design

I cutting material: HW-tipped for hard woods

Advantages

Notes

I from safety reasons please always mount knives with equal weight (packing unit VE) opposite each other

B	H	S	H1	PU	Ident-No.
60	30	3.0	11	2	160586 L
80	30	3.0	11	2	006204 L
100	30	3.0	11	2	006205 L
110	30	3.0	11	2	165329 O
120	30	3.0	11	2	006206 O
130	30	3.0	11	2	006207 L
150	30	3.0	11	2	006208 L
170	30	3.0	11	2	006209 L
180	30	3.0	11	2	055649 L
210	30	3.0	11	2	006210 O
230	30	3.0	11	2	160588 L
240	30	3.0	11	2	182641 L
260	30	3.0	11	2	160589 O
310	30	3.0	11	2	055648 L
310	35	3.0	11	2	165338 O
320	30	3.0	11	2	165330 C
320	35	3.0	11	2	165339 S
330	30	3.0	11	2	165331 C
330	35	3.0	11	2	165340 S
360	30	3.0	11	2	165332 C
360	35	3.0	11	2	165341 S
400	35	3.0	11	2	165342 C
410	30	3.0	11	2	006211 L
410	35	3.0	11	2	165343 O
450	30	3.0	11	2	165333 S
450	35	3.0	11	2	165344 S
460	30	3.0	11	2	165334 C
460	35	3.0	11	2	165345 O
500	35	3.0	11	2	165346 O
510	30	3.0	11	2	006212 L
510	35	3.0	11	2	165347 O
600	35	3.0	11	2	165348 O
610	30	3.0	11	2	006704 O
610	35	3.0	11	2	165349 O
630	30	3.0	11	2	165335 O
630	35	3.0	11	2	165350 O
635	35	3.0	11	2	165351 C
640	30	3.0	11	2	165336 O
640	35	3.0	11	2	165352 O
700	35	3.0	11	2	165353 C
710	30	3.0	11	2	160590 C
710	35	3.0	11	2	165354 S
740	30	3.0	11	2	165337 C
[mm]	[mm]	[mm]	[mm]	[pc.]	

B	H	S	H1	PU	Ident-No.
740	35	3.0	11	2	165355 S
810	30	3.0	11	2	160592 L
810	35	3.0	11	2	165356 O
[mm]	[mm]	[mm]	[mm]	[pc.]	

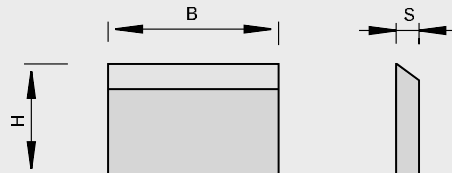
332121/332124

Planing Knives HS

Product



Drawing



High Speed Steel [HS]

Machine / Application

I for use in planing cutterheads

Design

I cutting material: high speed steel (HS 18%) for soft woods
 I wedge angle 40°
 I topcoat coating

Advantages

Notes

I from safety reasons please always mount knives with equal weight (packing unit VE) opposite each other

B	H	S	PU	Ident-No.
60	30	3.0	2	160593 L
80	30	3.0	2	160594 L
100	30	3.0	2	055647 L
110	30	3.0	2	160595 C
120	30	3.0	2	160596 L
130	30	3.0	2	006139 L
150	30	3.0	2	160597 L
170	30	3.0	2	160598 L
180	30	3.0	2	160599 L
210	30	3.0	2	160600 L
230	30	3.0	2	160601 L
260	30	3.0	2	006485 L
310	30	3.0	2	160602 L
310	35	3.0	2	165310 L
320	30	3.0	2	160603 L
320	35	3.0	2	165311 C
330	30	3.0	2	160604 C
330	35	3.0	2	165312 L
360	30	3.0	2	160605 C
360	35	3.0	2	165313 C
400	30	3.0	2	165307 L
400	35	3.0	2	165314 C
410	30	3.0	2	006486 L
410	35	3.0	2	006487 L
450	30	3.0	2	160606 C
450	35	3.0	2	165315 C
460	30	3.0	2	160607 C
460	35	3.0	2	165316 C
500	30	3.0	2	165308 L
500	35	3.0	2	165317 L
510	30	3.0	2	006488 L
510	35	3.0	2	006489 L
600	30	3.0	2	165309 C
600	35	3.0	2	165318 C
610	30	3.0	2	006490 L
610	35	3.0	2	006491 L
[mm]	[mm]	[mm]	[pc.]	

B	H	S		PU	Ident-No.
630	30	3.0		2	160608 L
630	35	3.0		2	165319 L
635	35	3.0		2	165320 C
640	30	3.0		2	160609 L
640	35	3.0		2	165321 L
700	35	3.0		2	165322 C
710	30	3.0		2	160610 C
710	35	3.0		2	165323 C
740	35	3.0		2	165324 C
810	30	3.0		2	160612 L
810	35	3.0		2	165325 L
840	30	3.0		2	160613 C
1050	25	3.0		2	185843 C
1050	30	3.0		2	176331 L
1050	35	3.0		2	176332 L
[mm]	[mm]	[mm]		[pc.]	
B	H	S		PU	Ident-No.
60	30	3.0	topcoat	10	185554 C
80	30	3.0	topcoat	10	185555 C
100	30	3.0	topcoat	10	185556 C
120	30	3.0	topcoat	10	185558 C
130	30	3.0	topcoat	10	185559 C
150	30	3.0	topcoat	10	185560 C
170	30	3.0	topcoat	10	185561 C
180	30	3.0	topcoat	10	185562 C
210	30	3.0	topcoat	10	185563 C
230	30	3.0	topcoat	10	185564 C
260	30	3.0	topcoat	10	185565 C
310	30	3.0	topcoat	10	185566 C
310	35	3.0	topcoat	10	185567 C
320	30	3.0	topcoat	10	185568 C
330	35	3.0	topcoat	10	185571 C
400	30	3.0	topcoat	10	185574 C
410	30	3.0	topcoat	10	185576 C
410	35	3.0	topcoat	10	185577 C
500	30	3.0	topcoat	10	185582 C
500	35	3.0	topcoat	10	185583 C
510	30	3.0	topcoat	10	185584 C
510	35	3.0	topcoat	10	185585 C
610	30	3.0	topcoat	10	185588 C
610	35	3.0	topcoat	10	185589 C
630	30	3.0	topcoat	10	185590 C
630	35	3.0	topcoat	10	185591 C
640	30	3.0	topcoat	10	185593 C
640	35	3.0	topcoat	10	185594 C
[mm]	[mm]	[mm]		[pc.]	

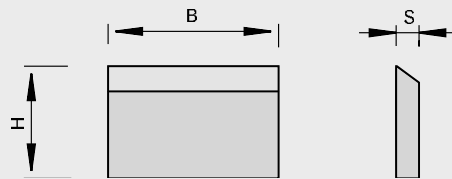
332121/332124

Planing knife HS for hydro and jointing

Product



Drawing



High Speed Steel [HS]

Machine / Application

for use in hydro planing
cutterheads

Design

cutting material: HS for soft
woods
wedge angle 30° for jointing
topcoat coating

Advantages

high run-out accuracy due
to grinding the knives in the
hydro planing cutterhead with
following jointing process in the
machine

Notes

from safety reasons please
always mount knives with
equal weight (packing unit VE)
opposite each other

B	H	S	PU	Ident-No.
130	30	3.0	2	182759 C
150	30	3.0	2	182760 C
170	30	3.0	2	182761 S
180	30	3.0	2	182762 C
190	30	3.0	2	182763 C
210	30	3.0	2	182764 S
230	30	3.0	2	182765 C
240	30	3.0	2	182766 C
270	30	3.0	2	182767 C
310	30	3.0	2	182768 S
[mm]	[mm]	[mm]	[pc.]	

B	H	S	PU	Ident-No.
130	30	3.0	10	186007 S
150	30	3.0	10	186008 S
170	30	3.0	10	186009 S
180	30	3.0	10	186010 S
190	30	3.0	10	186011 S
210	30	3.0	10	186012 S
230	30	3.0	10	186013 C
240	30	3.0	10	186014 S
270	30	3.0	10	186015 S
310	30	3.0	10	186016 S
[mm]	[mm]	[mm]	[pc.]	

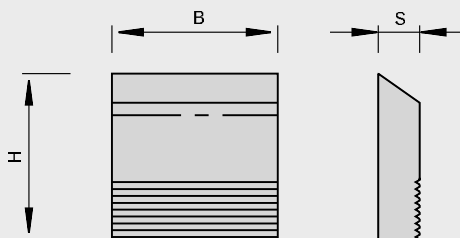
332511

Back-serrated HS blanks for profiling

Product



Drawing



High Speed Steel [HS]

Machine / Application

for use in profile cutterheads with serration

Design

cutting material: HS for soft woods

Advantages

Notes

T = profile depth
from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

B	H	S	Tmax	PU	Ident-No.
40	50	8.0	12	2	163385 L
40	60	8.0	20	2	163386 L
40	70	8.0	30	2	163387 L
50	50	8.0	12	2	180533 C
50	60	8.0	20	2	180534 L
60	50	8.0	12	2	163388 L
60	60	8.0	20	2	163389 L
60	70	8.0	30	2	163390 L
80	50	8.0	12	2	163391 L
80	60	8.0	20	2	163392 L
80	70	8.0	30	2	163393 L
100	50	8.0	12	2	163394 L
100	60	8.0	20	2	163395 L
100	70	8.0	30	2	163396 L
130	50	8.0	12	2	163397 L
130	60	8.0	20	2	163398 L
130	70	8.0	30	2	163399 C
150	50	8.0	12	2	163400 L
150	60	8.0	20	2	163401 L
150	70	8.0	30	2	163402 L
180	50	8.0	12	2	163403 C
180	60	8.0	20	2	163404 C
180	70	8.0	30	2	163405 C
230	50	8.0	12	2	164495 L
230	60	8.0	20	2	164496 C
650	50	8.0	12	1	176318 L
650	60	8.0	20	1	176319 L
650	70	8.0	30	1	176320 L
[mm]	[mm]	[mm]	[mm]	[pc.]	

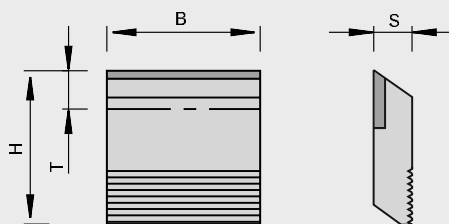
132511

Back-serrated HW blanks for profiling

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in profile cutterheads with serration

Design

HW-tipped for hard and exotic woods
 tipping height 14 mm for blank height 50 mm, tipping height 20 mm for blank height 60 mm

Advantages**Notes**

T = profile depth
 from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other

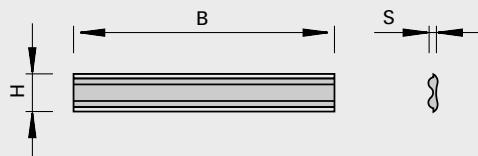
B	H	S	Tmax	PU	Ident-No.
40	50	10	13	2	165357 O
40	60	10	18	2	165365 L
60	50	10	13	2	165358 L
60	60	10	18	2	165366 L
80	50	10	13	2	165359 O
80	60	10	18	2	165367 L
100	50	10	13	2	165360 O
100	60	10	18	2	165368 L
130	50	10	13	2	165361 O
130	60	10	18	2	165369 O
150	50	10	13	2	165362 L
150	60	10	18	2	165370 O
180	50	10	13	2	165363 S
180	60	10	18	2	165371 O
230	50	10	13	2	165364 O
230	60	10	18	2	165372 O
[mm]	[mm]	[mm]	[mm]	[pc.]	

332751

Turnover Knives HS with 2 cutting edges - Torsa

Product

Drawing



High Speed Steel [HS]

Machine / Application

Design

Advantages

Notes

I for use in Torsa planing
cutterheadsI cutting material: HS for soft
woods

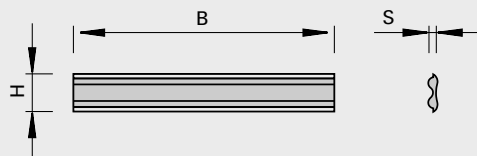
B	H	S	PU	Ident-No.
60	10	2.3	2	175305 S
80	10	2.3	2	175307 C
90	10	2.3	2	175308 S
100	10	2.3	2	175309 C
110	10	2.3	2	175310 C
120	10	2.3	2	175311 C
130	10	2.3	2	175312 C
140	10	2.3	2	175313 S
150	10	2.3	2	175314 C
160	10	2.3	2	175315 S
170	10	2.3	2	175316 C
180	10	2.3	2	175317 C
185	10	2.3	2	175318 C
190	10	2.3	2	175319 C
200	10	2.3	2	175320 C
210	10	2.3	2	175321 S
220	10	2.3	2	175322 C
230	10	2.3	2	175323 C
240	10	2.3	2	175324 S
250	10	2.3	2	175325 C
260	10	2.3	2	175326 S
265	10	2.3	2	175327 C
270	10	2.3	2	175328 S
280	10	2.3	2	175329 C
300	10	2.3	2	175331 C
310	10	2.3	2	175332 L
320	10	2.3	2	175334 S
330	10	2.3	2	175335 C
350	10	2.3	2	175337 C
360	10	2.3	2	175338 S
400	10	2.3	2	175342 C
410	10	2.3	2	175343 L
420	10	2.3	2	175344 S
430	10	2.3	2	175345 C
450	10	2.3	2	175347 S
500	10	2.3	2	175352 C
510	10	2.3	2	175353 L
520	10	2.3	2	175354 L
530	10	2.3	2	175355 C
540	10	2.3	2	175356 C
610	10	2.3	2	175363 C
630	10	2.3	2	175365 L
635	10	2.3	2	175366 S
640	10	2.3	2	175368 L
650	10	2.3	2	175369 S
[mm]	[mm]	[mm]	[pc.]	

132751

Turnover Knives HW with 2 cutting edges - Torsa

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

I for use in Torsa planing
cutterheads

Design

I cutting material: HW for hard
and exotic woods

Advantages

I optimal precision as manu-
factured from one piece up to
B=650 mm

Notes

B	H	S	PU	Ident-No.
60	10	2.3	2	175205 S
80	10	2.3	2	175207 S
90	10	2.3	2	175208 C
100	10	2.3	2	175209 C
110	10	2.3	2	175210 C
120	10	2.3	2	175211 S
130	10	2.3	2	175212 C
140	10	2.3	2	175213 S
150	10	2.3	2	175214 S
160	10	2.3	2	175215 C
170	10	2.3	2	175216 C
180	10	2.3	2	175217 C
185	10	2.3	2	175218 C
190	10	2.3	2	175219 S
200	10	2.3	2	175220 S
210	10	2.3	2	175221 S
220	10	2.3	2	175222 S
230	10	2.3	2	175223 C
240	10	2.3	2	175224 S
250	10	2.3	2	175225 S
260	10	2.3	2	175226 S
265	10	2.3	2	175227 C
270	10	2.3	2	175228 S
280	10	2.3	2	175229 S
300	10	2.3	2	175231 S
310	10	2.3	2	175232 C
320	10	2.3	2	175234 C
330	10	2.3	2	175235 C
350	10	2.3	2	175237 S
360	10	2.3	2	175238 S
400	10	2.3	2	175242 C
410	10	2.3	2	175243 C
420	10	2.3	2	175244 S
430	10	2.3	2	175245 S
450	10	2.3	2	175247 S
500	10	2.3	2	175252 S
510	10	2.3	2	175253 C
520	10	2.3	2	175254 C
530	10	2.3	2	175255 C
540	10	2.3	2	175256 S
600	10	2.3	2	175262 C
610	10	2.3	2	175263 S
630	10	2.3	2	175265 C
635	10	2.3	2	175266 C
[mm]	[mm]	[mm]	[pc.]	

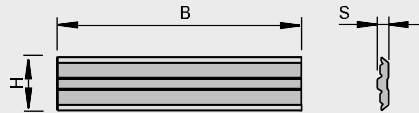
B	H	S	PU	Ident-No.
640	10	2.3	2	175268 C
650	10	2.3	2	175269 S
[mm]	[mm]	[mm]	[pc.]	

332121

Turnover Knives HS with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



High Speed Steel [HS]

Machine / Application

for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of soft woods

Design

cutting material: HS for soft woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

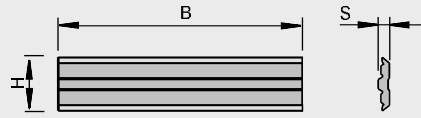
B	H	S	PU	Ident-No.
80	12	2.7	4	182769 C
100	12	2.7	4	182770 C
130	12	2.7	4	182771 C
150	12	2.7	4	182772 S
170	12	2.7	4	182773 C
180	12	2.7	4	182774 C
190	12	2.7	4	182775 C
210	12	2.7	4	182776 C
230	12	2.7	4	182777 C
240	12	2.7	4	182778 C
310	12	2.7	4	182779 C
410	12	2.7	4	182780 C
520	12	2.7	4	182781 C
510	12	2.7	4	182782 C
640	12	2.7	4	182783 C
[mm]	[mm]	[mm]	[pc.]	

150517

Turnover Knives HW with 2 cutting edges - Centrostar, Centrofix, Quickfix

Product

Drawing



Tungsten Carbide [HW]

Machine / Application

for use in planing cutterhead systems Centrostar, Centrofix and Quickfix for planing of hard woods and MDF

Design

cutting material: HW
HL Solid 20 for hard and exotic woods
constant diameter

Advantages

high planing quality and long edge lives

Notes

a cutting length of more than 630 mm is reached by means of several knives

B	H	S	PU	Ident-No.
100	12	2.7	2	182784 C
130	12	2.7	2	182785 C
150	12	2.7	2	182786 C
170	12	2.7	2	182787 S
180	12	2.7	2	182788 C
190	12	2.7	2	182789 S
210	12	2.7	2	182790 C
230	12	2.7	2	182791 C
240	12	2.7	2	182792 C
410	12	2.7	2	182793 S
510	12	2.7	2	182794 C
640	12	2.7	2	182795 S
[mm]	[mm]	[mm]	[pc.]	

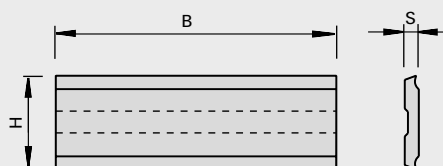
150613 / 150617

Turnover Knives HW with 2 cutting edges - Versofix

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in planing cutterhead systems Versofix for planing of hard woods and MDF

Design

cutting material: HW
HL Board 03 for wood-based
HL Solid 20 for hard and soft
woods
constant diameter

Advantages

high planing quality and long
edge lives

Notes

topcoat coating are possible

B	H	S	LEUCODUR	PU	Ident-No.
20	5.5	1.1	HL Board 03	10	186244 S
20	5.5	1.1	HL Solid 20	10	186245 S
20	10	1.5	HL Board 03	10	186246 C
20	10	1.5	HL Solid 20	10	186247 S
30	6.5	1.1	HL Board 03	10	186248 S
30	6.5	1.1	HL Solid 20	10	186249 S
30	10	1.5	HL Board 03	10	186250 C
30	10	1.5	HL Solid 20	10	186251 C
50	6.5	1.1	HL Board 03	10	186252 S
50	6.5	1.1	HL Solid 20	10	186253 S
50	10	1.5	HL Board 03	10	186254 C
50	10	1.5	HL Solid 20	10	186256 O
[mm]	[mm]	[mm]		[pc.]	

132891

Turnover Knife Holders - Ledinek Rotoles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for planing machines Ledinek Rotoles
for LEUCODUR turnover knives straight and with chamfer

Design

for mounting of LEUCODUR turnover knives 14 x 14 mm and 14.3 x 14.3 mm

Advantages

Notes

minimum order quantity 10 pieces

Ident-No.

for thicknesser (TOK 14x14x2) top

182082 C

for service planing rotor (TOK 14x14x2) bottom

182083 C

for thicknesser segments (TOK 14,3x14,3x2,5) top

182084 C

for service planing rotor segments (TOK 14,3x14,3x2,5) bottom

182085 C

Spare parts

Dimension

Class-No.

PU

Ident-No.

Countersunk Screws

M5x9 T20 D=Ø9,3
[mm]

995125

10

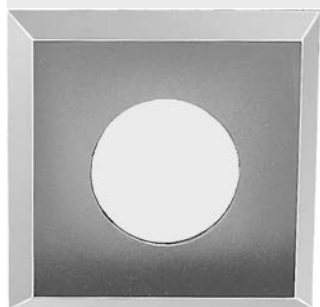
827277 L

[pc.]

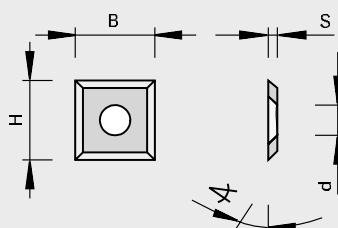
150517 / 150553 / 150555 / 150558

Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for planing machines Ledinek Rotoles
for use in turnover knife holders for plain milling

Design

cutting material: HW
HL Board 03 for wood-based panels and plastics
HL Board 05 for wood-based panels, plastics and hard woods
HL Solid 20 for wood-based panels, hard and soft woods
HL Solid 30 for hard and soft woods

Advantages

Notes

packing unit: 10 pieces

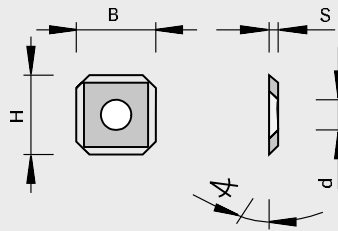
B	H	S	Ø d	Wedge	LEUCODUR	Ident-No.
14	14	2.0	6,3	60	HL Solid 30	003079 L
14	14	2.0	6,3	60	HL Board 05	180954 L
14	14	2.0	6,3	60	HL Board 03	180646 L
14,3	14.3	2.5	6,3	55	HL Solid 20	170248 L
[mm]	[mm]	[mm]	[mm]	[°]		

150557

Profile Turnover Knives HW with 4 cutting edges and chamfer - Ledinek Rotoles

Product

Drawing



LEUCODUR

Tungsten Carbide [HW]

Machine / Application

planing machines Ledinek Rotoles
for use in turnover knife holders for plain milling

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

packing unit: 10 pieces

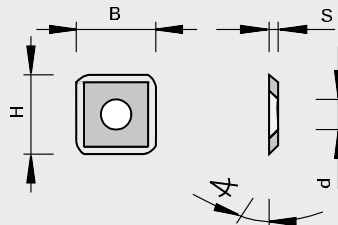
B	H	S	Ø d	Wedge	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	180933 L	180932 L
14,3	14.3	2.5	6,4	55	HL Solid 20	181144 C	181143 C
[mm]	[mm]	[mm]	[mm]	[°]			

150557

Profile Turnover Knives HW with 4 cutting edges and radius - Ledinek Rotoles

Product

Drawing



LEUCODUR

Tungsten Carbide [HW]

Machine / Application

planing machines Ledinek Rotoles
for use in turnover knife holders for plain milling

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

Notes

packing unit: 10 pieces

B	H	S	Ø d	Wedge	LEUCODUR	Ident-No. [L]	Ident-No. [R]
14	14	2.0	6,4	60	HL Solid 20	182442 L	182441 L
14,3	14.3	2.5	6,4	55	HL Solid 20	182444 L	182443 L
[mm]	[mm]	[mm]	[mm]	[°]			

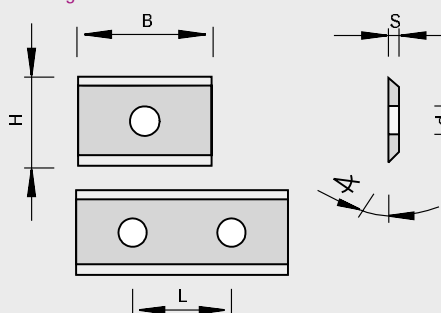
150511 / 150512 / 150515 / 150516 / 150517 / 150717

Turnover Knives HW with 2 cutting edges

Product



Drawing

LEUCO
DUR

Tungsten Carbide [HW]

Machine / Application

Design

- | topline (polished face and micro-ground clearance angle)
- | cutting material: HW
- | HW HL Board 01 for wood-based panels and plastics
- | HW HL Board 02 for wood-based panels and plastics
- | HL Board 06 for wood-based panels, plastics, hard and soft woods
- | HL Board 05 for wood-based panels, plastics and hard woods
- | HL Solid 20 for hard and soft woods
- | HL Solid 20 topline for hard and soft woods

Advantages

- | long edge lives and optimum cutting quality in solid woods
- | EcoKnife: turnover knife with less weight, less unbalance

Notes

- | packing unit: 10 pieces

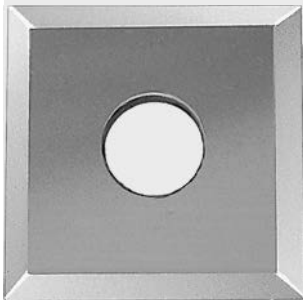
B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
7,5	12	1.5	4,0		55	HL Board 05	052543 L
7,5	12	1.5	4,0		45	HL Solid 20	173473 L
9,6	12	1.5	4,0		55	HL Board 05	171163 L
10,5	12	1.5	4,0		55	HL Board 05	162636 L
11	12	1.5	4,0		55	HL Board 05	162637 L
13	12	1.5	4,0		55	HL Board 05	162638 L
15	12	1.5	4,0		55	HL Board 05	003081 L
15	12	1.5	4,0		45	HL Solid 20	173467 C
15,7	12	1.5	4,0		55	HL Board 05	163846 L
17	12	1.5	4,0		55	HL Board 05	162639 L
18	12	1.5	4,0		55	HL Board 05	162520 L
19	12	1.5	4,0		55	HL Board 05	164242 L
20	12	1.5	4,0		55	HL Board 02	176469 L
20	12	1.5	4,0		55	HL Board 06	178287 L
20	12	1.5	4,0		55	HL Board 05	003082 L
20	12	1.5	4,0		45	HL Solid 20 topline	176265 L
20	14.3	2.5	6,3		55	HL Solid 20	168509 L
30	12	1.5	4,0	14	55	HL Board 02	176470 L
30	12	1.5	4,0	14	55	HL Board 06	178288 L
30	12	1.5	4,0	14	55	HL Board 05	003083 L
30	12	1.5	4,0	14	55	HL Board 05 plus	187325 L
30	12	1.5	4,0	14	45	HL Solid 20 topline	176266 L
40	12	1.5	4,0	26	55	HL Board 02	182191 L
40	12	1.5	4,0	26	55	HL Board 05	164078 L
40	12	1.5	4,0	26	45	HL Solid 20 topline	176267 L
50	12	1.5	4,0	26	55	HL Board 02	176471 L
50	12	1.5	4,0	26	55	HL Board 06	178289 L
50	12	1.5	4,0	26	55	HL Board 05	003085 L
50	12	1.5	4,0	26	55	HL Board 05 plus	187326 L
50	12	1.5	4,0	26	45	HL Solid 20 topline	176268 L
60	12	1.5	4,0	26	55	HL Board 05	003086 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

B	H	S	Ø d	L	Wedge	LEUCODUR	Ident-No.
60	12	1.5	4,0	26	45	HL Solid 20	173472 C
60	12	1.5	4,0	26	45	HL Solid 20 topline	176269 L
80	13	2.2	4,0	59-61	55	HL Board 06	003087 L
80	13	2.2	4,0	59-61	45	HL Solid 20 topline	181677 L
100	13	2.2	4,0	59-61	55	HL Board 06	003088 L
120	13	2.2	4,0	59-61	55	HL Board 06	003089 L
[mm]	[mm]	[mm]	[mm]	[mm]	[°]		

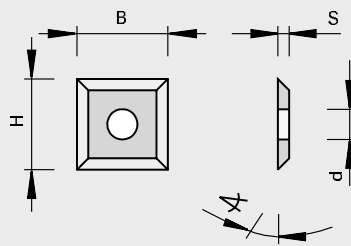
150513 / 150515 / 150516 / 150517 / 150717

Turnover Knives HW with 4 cutting edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

Design

- topline (polished face and micro-ground clearance angle)
- cutting material: HW
- HL Board 03 for wood-based panels and plastics
- HL Board 05 for wood-based panels, plastics and hard woods
- HL Board 06 for wood-based panels, plastics, hard and soft woods
- HL Solid 20 topline for hard and soft woods

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

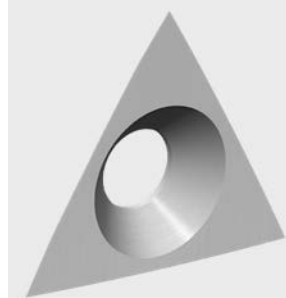
- packing unit: 10 pieces

B	H	S	Ø d	Wedge	LEUCODUR	Ident-No.
10,5	10,5	1.5	4,0	55	HL Board 06	162316 L
12	12	1.5	4,0	55	HL Board 03	* 180820 L
12	12	1.5	4,0	55	HL Board 05	* 003080 L
12	12	1.5	4,0	45	HL Solid 20 topline	* 176340 L
17	17	2.0	4,0	55	HL Board 05	Weinig 162581 L
19	19	2.0	4,0	55	HL Board 05	162582 L
[mm]	[mm]	[mm]	[mm]	[°]		

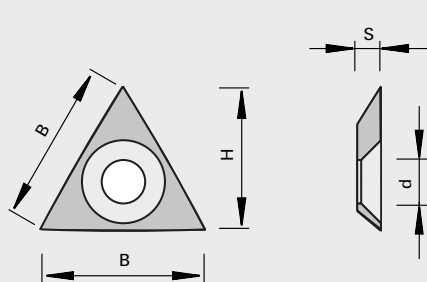
150...

Turnover Knives HW with 3 cutting edges and countersink - with rounded edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in t3-System cutter-heads

Design

Cutting material: HW
 HL Solid 20 for hard wood and soft wood
 HL Board 06 for wood-based materials, plastics and hard woods
 topcoat coating for increased edge lives

Advantages

Notes

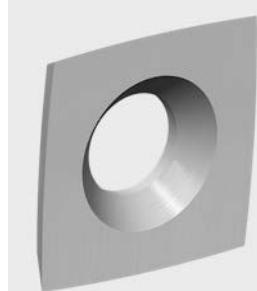
Turnover knife 9209773 scoring without projection, suitable for jointing without groove

B	H	S	Ø d	LEUCODUR	PU	Ident-No.
20,38	17.9	3.0	5,5	HL Solid 20	10	9209773 L
20,88	18.3	3.0	5,5	HL Board 06	10	187692 L
20,88	18.3	3.0	5,5	HL Solid 20	10	187251 L
20,88	18.3	3.0	5,5	HL Solid 20 topcoat	10	187694 L
[mm]	[mm]	[mm]	[mm]		[pc.]	

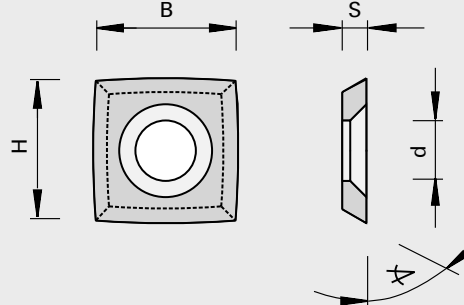
150566 / 150567 / 150568

Turnover Knives HW with 4 cutting edges and countersink - with rounded edges

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

187252 for use on SCM MBM planing shaft
 187253 for use on format 4 Silent-Power® planing shafts with spiral blades
 187254 for use on Martin Xplane planing shafts

Design

cutting material: HW
 HL Board 06 for wood-based panels, plastics and hard woods
 HL Solid 20 for hard and soft woods
 HL Solid 30 for hard and soft woods

Advantages

Notes

B	H	S	Ø d	Wedge		LEUCODUR	PU	Ident-No.
13,81	13.81	2.5	6,2	60	with rounded edges (R=150 mm)	HL Board 06	10	187253 L
15	15	2.5	6,25	60	with rounded edges (R=95 mm)	HL Solid 30	10	187252 L
15	15	2.5	6,7	50	with rounded edges (R=100 mm)	HL Solid 20	10	187254 L
[mm]	[mm]	[mm]	[mm]	[°]			[pc.]	

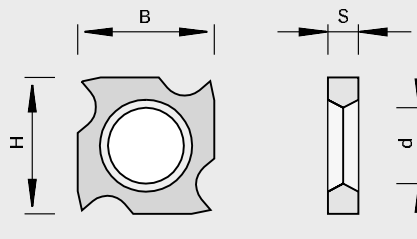
150508

Grooving Turnover Knives HW with 4 cutting edges - grooving cutterheads

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

| for use in grooving cutterheads

Design

| cutting material: HW
| HL Solid 30 for wood-based panels, hard and soft woods

Advantages

Notes

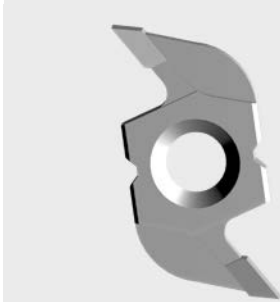
| Ident-No. 163699 for groove width 4 mm
| Ident-No. 165906 for groove width 5 mm
| Ident-No. 169250 for groove width > 7 mm
| packing unit: 10 pieces

B	H	S	Ø d	Ident-No.
18	18	1.95	10	163699 L
18	18	2.45	10	165906 L
18	18	3.7	10	169250 L
[mm]	[mm]	[mm]	[mm]	

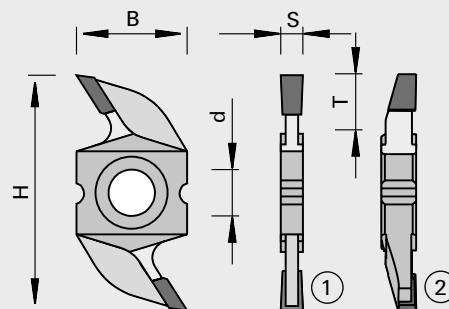
150508/150509

Grooving Turnover Knives HW with 2 cutting edges and positioning groove

Product



Drawing



LEUCODUR

Tungsten Carbide [HW]

Machine / Application

| for use in cutterheads for grooving

Design

| bore countersunk 90 degrees
| cutting material: HW
| HL Solid 30 and HL Solid 40 for hard and soft woods

Advantages

| high accuracy thanks to radial positioning
| more simple handling

Notes

| spacer rings for the adjustment of the rounding knives see chapter replacement parts

B	H	S	Ø d	Tmax	LEUCODUR	PU	Ident-No.
13	36	3.5	7,4	10	HL Solid 30	5	165968 C
16	34	3.2	6,7	8,0	HL Solid 30	5	183663 L
16	34	3.5	6,7	8,0	HL Solid 30	5	183664 C
16	34	4.0	6,7	8,0	HL Solid 30	5	183665 L
16	34	5.0	6,7	8,0	HL Solid 30	5	183666 L
[mm]	[mm]	[mm]	[mm]	[mm]		[pc.]	

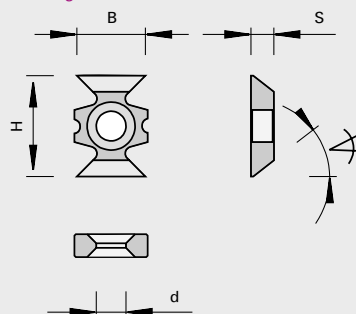
150577

Chamfering Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for chamfering

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
more simple handling

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the chamfer knives see chapter replacement parts
packing unit: 10 pieces

Chamfer $\angle$	B	H	S	Ø d	Ident-No.
45 [°]	16 [mm]	22 [mm]	5.0 [mm]	6,5 [mm]	183668 L

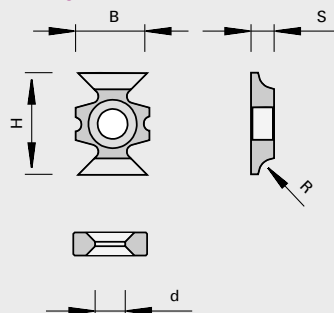
150577

Rounding Turnover Knives HW with 4 cutting edges and positioning groove

Product



Drawing



Tungsten Carbide [HW]

Machine / Application

for use in cutterheads for rounding

Design

cutting material: HW
HL Solid 20 for wood-based panels, hard and soft woods

Advantages

high accuracy thanks to radial positioning
radii are interchangeable
more simple handling

Notes

for clockwise and counter-clockwise rotation
spacer rings for the adjustment of the rounding knives see chapter replacement parts
packing unit: 10 pieces

R	B	H	S	Ø d	Ident-No.
1,5	16	22	5.0	6,5	183669 L
2,0	16	22	5.0	6,5	183670 L
2,5	16	22	5.0	6,5	183671 C
3,0	16	22	5.0	6,5	183672 L
[mm]	[mm]	[mm]	[mm]	[mm]	

985710

Ball hammers one sided

Product	Notes
	I Hand tools for straightening circular saw blades
Weight	Ident-No.
0.5	186268 S
0.75	186269 S
1.0	186270 S
1.25	186271 S
1.5	186272 S
1.75	186273 S
2.0	186274 S
2.25	186275 S
2.5	186276 S
3.0	186277 S
[kg]	

985710

Ball hammers double sided

Product	Notes
	I Hand tools for straightening circular saw blades
Weight	Ident-No.
0.5	186257 S
0.75	186258 S
1.0	186259 S
1.25	186260 S
1.5	186261 S
1.75	186262 S
2.0	186263 S
2.25	186264 S
2.5	186265 S
3.0	186266 S
3.5	186267 S
[kg]	

985710
Cross hammers

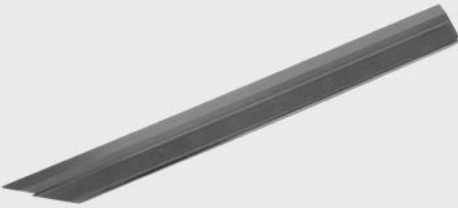
Product	Notes
	I Hand tools for straightening circular saw blades
Weight	Ident-No.
0.5	186278 S
0.75	186279 S
1.0	186280 S
1.25	186281 S
1.5	186282 S
1.75	186283 S
2.0	186284 S
2.25	186285 S
2.5	186286 S
[kg]	

985710
Roughing hammers

Product	Notes
	I Hand tools for straightening circular saw blades
Weight	Ident-No.
0.5	186287 S
0.75	186288 S
1.0	186289 S
1.25	186290 S
1.5	186291 S
1.75	186292 S
2.0	186293 S
2.25	186294 S
2.5	186295 S
[kg]	

985300

Rulers

Product	Notes
	I Hand tools for straightening circular saw blades
Total length	Ident-No.
150	186296 S
200	186297 S
300	186298 S
400	186299 S
500	186300 S
600	186301 S
800	186302 S
[mm]	

985300

Dial gauges

Product	Ident-No.
	
	186304 C

985300

Saw setting dial gauges

Product	Ident-No.
	
	186303 C



AS GOOD AS NEW: EXCELLENT RESHARPENING SERVICE

As a premium manufacturer we know cutting materials and cutting edge geometries very well and have access to the original data. Among others, LEUCO offers carbide-tipped tools with different carbide grades and thus meets the application like no other. As a manufacturer, LEUCO has the know-how for the best service.

In addition, LEUCO's excellent sharpening service is characterized by:

- sharpening know-how of well-trained LEUCO employees
- the most modern high-tech systems in the company service centers
- availability of your tools based on strict sharpening schedules

LEUCO diamond and carbide service: worldwide

As a quality-aware tool manufacturer we repair all of your tools. Whether it's sharpening any conceivable tooth geometry, tooth replacement, adjustment, alignment, eroding and settings – the precision and quality throughout the tool's life and the efficiency of the work are the measure of our LEUCO service team's work.

Contact LEUCO resharpener service worldwide:

www.leuco.com or

<http://bit.ly/LEUCO-Service-Contact>



LEUCO RESHARPENING SERVICE VIDEO

Take a look at the LEUCO sharpening service video in the YouTube channel under

WWW.YOUTUBE.DE/LEUCOTOOLING

or just scan the QR code:



▶ ⏮ ⏪ ⏩ ⏭ 0:03 / 5:26



"GOOD SERVICE IS NOT ABOUT SMILING AT THE CUSTOMER, BUT ABOUT EARNING THE CUSTOMER'S SMILE. THAT IS WHAT WE STRIVE FOR! TO DESERVE YOUR SMILE!"

Short descriptions of the cutting materials

NEW- according to ISO	Meaning	Old designation
SP	Alloyed tool steel (minimum 0.6% C and no more than 5% alloy constituents)	SP
HS	High-alloyed tool steel (more than 12% alloy elements Mo, V, Co in total)	HSS
ST	Casting alloy on cobalt basis e.g. Stellite	Stellite
HW	Uncoated tungsten carbide	HM
VHW	Solid tungsten carbide	VHM
DP	Polycrystalline diamond	DIA

02

Tool attributes

Short form	Meaning
NL	Pin holes
KN	Keyway
DKN	Double keyway
n	permitted range of RPM
n max	maximum RPM
U min-1	rotations per minute
Vc	cutting speed
Vf	feed speed
Z	No. of teeth

03

Types of feed

Short form	Meaning
MEC	mechanical feed
MAN	manual feed

04

Delivery signs

Kurzform	Bedeutung
⊗	Modification and/or mounting of stock parts
o	Available from stock on short notice
s	Production per drawing
#	New type in process
\$	Superstandard

All ID numbers are available from stock unless specifically indicated.

LEUCO Ledermann GmbH & Co. KG fulfills all demands of ISO 9001:2008.
The certificate-no. is 01 100 010679.

**CATALOG
SOLID WOOD PROGRAM
SW 03**



SAWING - PLANING - PROFILING - FINGER JOINTING / JOINTING

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