



▼ NEW: Now at a glance
ALL STEHLE
CIRCULAR
SAW BLADES!

Circular Sawblades

2018

Abrasive

Construction

Wood

Panels

Aluminum

Steel

Plastic

Table of contents

	MACHINE	PROGRAM	PAGE		
ABRASIVE CONSTRUCTION	SAWS	Portable Saws Table Saws	HKS - LR HKS - L HKS - L HKS - solid for cordless portable saws BKS (nail proof)	7 8 9 10 11	
	WOOD	SAWS	Portable Saws Table Saws Optimizing Chop Saws Clipping and Miter Saws Multi Rip Saws Grooving	HKS - Solid HKS - Board Saw Blade - Set HW ZFL ZFZ ZW ZQW ZWS / ZWS-1 OKW K + G - negative Planet LWR 1101 Grooving Cutters / NK /NKP / NK3VS	12 13 15 17 18 18 19 20 - 21 22 23 24 24 25 - 27
PANELS	SAWS	Portable Saws	HKS - nn-System DP FLEX	28	
	CNC-MACHINING	Sawing / Grooving	RNK-Matador 5	29	
	EDGE TRIMMING	Grooving	RNK	30	
	POWERTOOLS	Lamello	1103L Lamello Grooving Cutter/ 3103L Lamello G. C.	31	
	SAWS	Table Saws	Matador 5 TRF TRF - 1 3 pieces saw blade set in wood box HRP - nn-System DP FLEX RSK - nn-System DP FLEX RS2 RSVS RSK - nn-System / RSK (DP) KDF - Industry KDF - Industry Plus / KDF - Industry negative KDF - Industry Professionell TFP RSK - nn-System / RSK (DP) KKO / KKM / KKE	34 35 36 37 38 39 - 40 41 42 - 43 44 - 45 46 47-48 49 50 - 51 52 - 53 54 - 56	
	EDGE TRIMMING	Trimming Through-Feed			
	ALUMINUM	SAWS	Portable Saws Clipping and Miter Saws	Parat - negative (HKS) NF - positive NF - negative NE - Chop - Profiles „G7“	57 58 59 60
	STEEL	SAWS	Clipping and Miter Saws Dry-Cut-Machines	Unisteel (HKS) / HKS Unisteel for cordless portable saws Unisteel Steel Mega-Steel	62 - 63 64 64 65
	PLASTIC	SAWS	Table Saws	KKS - plastic / KKS - hard plastic	66
	TECHNICAL APPENDIX	SAWS / ACCESSORIES	Reducing Rings Product Information Indices	Reducing rings - knurled / reducing rings - smooth Material suitability / Technical information Diameter-Index Order-No.: Index Legend	67 - 68 1 - 6 80 85

Material Suitability

										AbrasivE
										Const- ruction
										Wood
Gypsum fibre board	Gypsum fibre board with MDF	Gipsfaserplatte mit Furnier	Gypsum plaster board	Fibre cement board	Wood fibre	Mineral wool / clay	GFK Gitterrost	Gasbetonstein		
Wood with nails	Mineral wool / clay	Gypsum fibre board	Fibre cement	Polyethylene	Wood fibre	Cement soiled boards	Gasbetonstein	Polyethylene		
Round wood	Board material	Beams	Battens	Planed material	Jointed material	Firewood	Gluelam construction timber	Quality laminated timber		
Veneered laminated wood	Glued laminated timber boards	Oak	Beech	Larch	Bangkirai	Coconut	Spruce	Poplar		
Balsa	Ash	Fir	Cork							
Plywood	Multiplex	Wood core plywood	OSB/ Particle board	Raw particle board	Veneered particle board	Melamine laminated particle board	CPL laminated acoustic particle board	HPL laminated particle board		PANELS
High gloss foiled particle board	(Soft) Fibre board	Raw MDF	Lacquered MDF	Twin-wall panel	Lacquered MDF profile	Hardboard	Flooring panel	Construction profile		
Honeycomb panel	Blockboard	MDF-Polystyrene panel	Holz-PMMA	Wood core plywood						
Block material	Hollow profile	Honeycomb panel	Foam	Zinc	Copper	Alu polyethylene	Ali HPL	Ali sandwich board with PU filling		ALUMI- NIUM
Steel	Steel	Stainless steel wall board	Square tube	Stainless steel sun protection	Steel grid	Iron covered particle board	Steel sandwich board with PU filling	Steel-plastic acoustic element		STEEL
PMMA - block material	PMMA - acrylic glass	PC (polycarbonate)	PE block material	PS (polystyrene)	PVC - vinyl flooring	PET honeycomb core	HPL laminate	Rubber		PLASTIC

Product Information / Technical Information

1 CUTTING MATERIAL

— TUNGSTEN CARBIDE (HW)

- The cutting material tungsten carbide is available in different versions for various applications and workpiece materials. They differ in their mixture including binder type, grain size, density, hardness, toughness and bending strength. The tungsten carbide for Stehle HW Saw Blades is designed and optimized for the processing of the respective material classes.
- HW cutting materials according to the Stehle nomenclature begin with the abbreviation TC. It is followed by a letter and ends with a two-digit number.

- The following basic rules apply:

- The smaller the figure in the denomination, the harder the cutting material (the longer the edge life).
- The higher the figure, the higher the bending strength (the smaller the risk of breaking).
- The smaller the grain size, the harder the cutting material and the higher the bending strength and toughness.

- Material orientation:

- The letter "w" in the denomination (after TC and before the figure) means "wood" and describes cutting materials especially for solid wood.
- The letter "m" stands for metals (aluminium and steel).
- „x“ stands for Cermet, a metallurgical/ceramic composite material with the ceramic advantages of hardness and temperature resistance. Cermet is applied for extremely demanding applications in steel.

— POLYCRYSTALLINE DIAMOND (DP)

- DP cutting edges are produced synthetically and the diamond coating is sintered on a carrying layer of tungsten carbide. Both are soldered on the tool body.
- DP is 2-3 times harder than tungsten carbide and reaches a multiple of edge lives in suitable materials. At the same time, due to its lower bending strength, DP is more susceptible to tooth breakage than HW. Thus it is not suited for all materials.
- During the past decades, DP established itself in chipboard and fibre boards as well as in abrasive materials and thanks to its economic efficiency has become an integral part of the woodworking industry.

— MONOCRYSTALLINE DIAMOND (DM)

- DM has very limited application possibilities for the machining of wood as well as plastics and composite materials.
- Stehle offers DM tools for the postprocessing of PMMA (acrylic glass) on machining center.

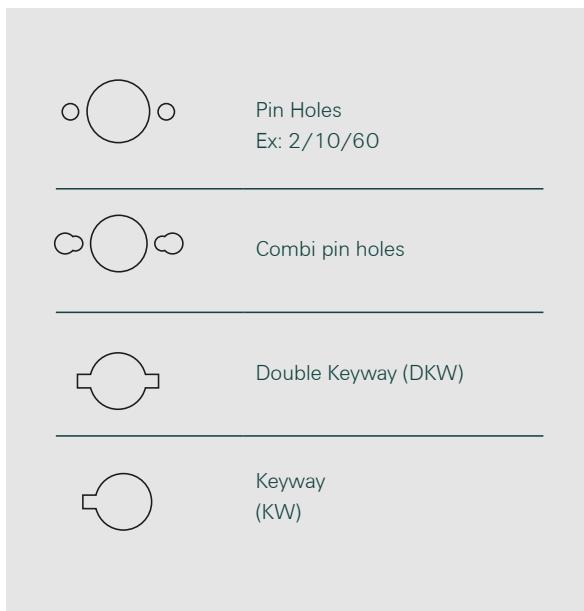
— HIGH-SPEED STEEL (HS)

- This is the traditional cutting material for the machining of solid wood, especially soft wood. Stehle offers HS tools to produce Tongue and Groove profiles, Round Dowels and Serrated Dowels as well as for Planning and Moulding..
- Planning knives with a long life coating can achieve double, or even multiple edge lives in suitable materials.

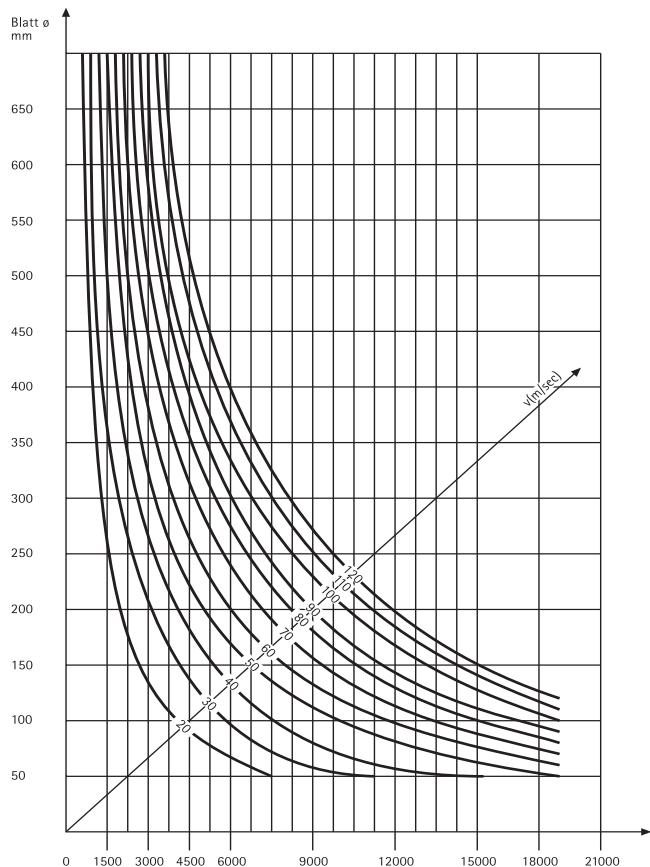
2 SAWS

- DUE TO NARROWER TOLERANCES, DP saw blades can be applied with higher feedrate f_z than HW saw blades.

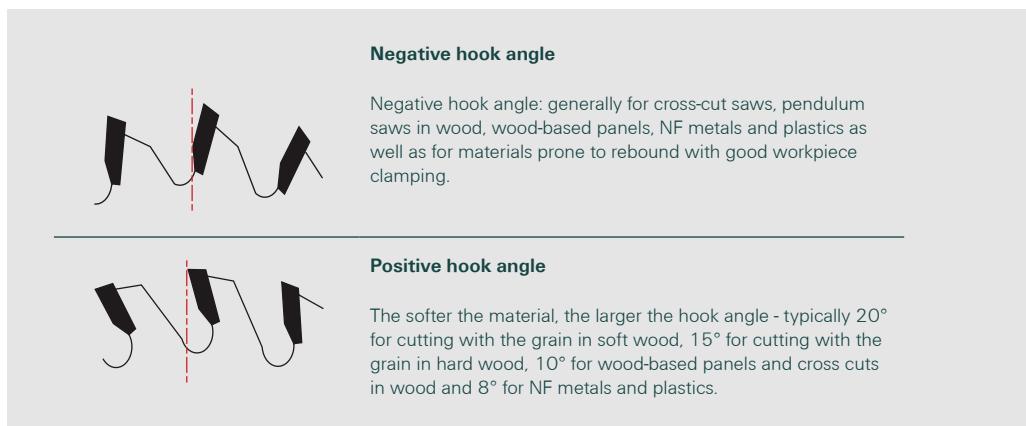
- PIN HOLES and KEYWAY



- Recommended cutting speed in m/sec



- HOOK ANGLE



- CUTTING MATERIAL:

The following cutting materials are used for Stehle HW saw blades:

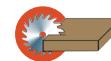
- Cutting materials for wood-based panels, composite materials and universal application:
TC03 TC20
TC03 plus TC25
TC06
TC10
- Cutting materials for solid wood:
TCw15
- Cutting materials for metal working:
TCx04
TCm17

— MATERIAL SUITABILITY SAW BLADES

MATERIAL**ABRASIVE**

ABRASIVE

Mineral wood-based panels (e.g. gypsum fibre boards and fiber cement boards)



Hard and abrasive plastics and composite materials

CONSTRUCTION

CONSTRUCTION

Construction woods



Formwork panels

Wood with nails

Cement soiled boards

WOOD

WOOD

Longitudinal cut in hard and soft woods, wet and dry



Longitudinal cut in woods with long fibers



Cross cut in solid wood and wood-based panels

PANELS

PANELS

Raw particle boards



Solid wood, wood core plywood and plywood



Veneered and paper-laminated panels



Melamine laminated and foil coated panels



HPL / CPL laminated panels



Abrasive composite materials

Solid wood edges, plastic and veneer edges

ALUMINIUM

ALUMINIUM

Profiles, metal sheets and NF composite materials



Aluminum and NF metals

STEEL

STEEL

Dividing cuts in metal sheets, profiles, NF metals and cast iron



Stainless steel sheets, composite material with stainless steel coating / steel reinforcement

PLASTIC

PLASTIC

Dividing and miter cuts in profiles made from thermoset, thermoplastic (e.g. Acrylics, PMMA, PE, PP, ...)



Dividing and sizing cuts in boards made from hard and abrasive plastics and composite materials (e.g. Corian, Trespa, CFK, GFK, AFK, ...)

LEGEND: **SQ** ▲ suitable – **SQ** ▲▲▲ especially suitable | **SW** ▲ short edge life – **SW** ▲▲▲ long edge life | **RS** Scoring saw blade

TOOTH CONFIGURATIONS

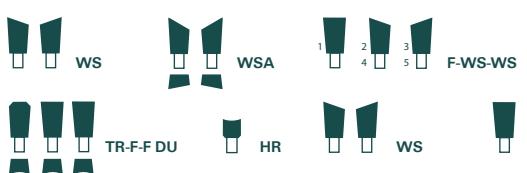
F**F-FA****F****WS**

Main saw blades: **WS** [SQ ▲▲ | SW ▲▲ with RS], **WSA** [SQ ▲▲ | SW ▲▲]

F-WS-WS [SQ ▲▲▲ | SW ▲▲ with / without RS]

TR-F-F DU [SQ ▲▲▲ | SW ▲▲ with / without RS]

HR [SQ ▲▲▲▲ | SW ▲▲▲▲ with / without RS]



Scoring saw blades: **WS** [SQ ▲▲ | SW ▲▲]

Grooving saw blades: **F** [SQ ▲▲ | SW ▲▲▲]

Main saw blades: **TR-F** [SQ ▲▲ | SW ▲▲ with RS]

DA-F DU [SQ ▲▲▲ | SW ▲▲ with / without RS]

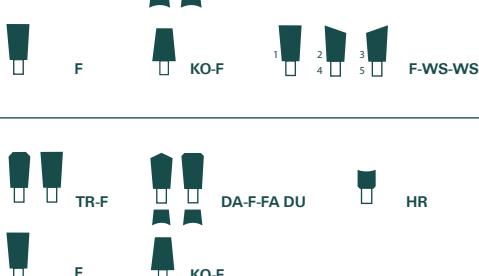
HR [SQ ▲▲▲▲ | SW ▲▲▲▲ with/ without RS]



Scoring saw blades: **F** [SQ ▲▲ | SW ▲▲], **KO-F** [SQ ▲▲ | SW ▲▲▲]

Grooving saw blades: **F** [SQ ▲▲ | SW ▲▲]

F-WS-WS [SQ ▲▲▲ | SW ▲▲]



Main saw blades: **TR-FA** [SQ ▲▲ | SW ▲▲▲ with RS]

DA-F-FA DU [SQ ▲▲▲ | SW ▲▲▲ with / without RS]

HR [SQ ▲▲▲▲ | SW ▲▲▲▲with/ without RS]

Scoring saw blades: **F** [SQ ▲▲ | SW ▲▲], **KO-F** [SQ ▲▲▲ | SW ▲▲]

Grooving saw blades: **F** [SQ ▲▲ | SW ▲▲]

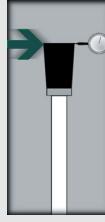


Clipping saws: **WS** [SQ ▲▲ | SW ▲▲▲], **ES** [SQ ▲▲▲ | SW ▲▲]

DA-F [SQ ▲▲ | SW ▲▲▲]

**TR-F****TR-F****F-WFA****WS-FA****TR-F-FA**

— QUALITY LEVEL OF SAW BLADES

						
HW Grade, Grain size	Runout Tolerance	Concentricity Tolerance	Symmetry	Bore Tolerance	Machine - Controlled Adjustment and Alignment	Hand- and Machine- Controlled Adjustment and Alignment

• **Quality level 1-0-1**

The standard quality especially for portable saws

- ▶ Laser cut body
- ▶ Optimal cutting material for the respective application
- ▶ Precise production tolerances
- ▶ Large tungsten carbide tips for maximum regrinds
- ▶ Machine-controlled adjustment and alignment

• **Quality level 2-0-6**

The standard quality for table machines, clipping and miter saws with excellent price-performance-ratio

- ▶ Laser cut body
- ▶ Application-specific tungsten carbide
- ▶ Tight production tolerances
- ▶ High concentric and runout precision
- ▶ Application-specific noise reduced design
- ▶ Machine-controlled adjustment and alignment

• **Quality level 3-0-1**

The highest quality level especially for industrial application on stationary machines.

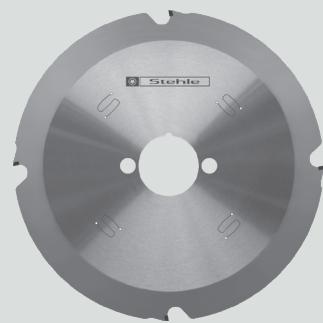
- ▶ Laser cut body
- ▶ Application-specific micrograin carbide
- ▶ Extremely tight production tolerances
- ▶ Highest concentric and runout precision
- ▶ Noise reduced design
- ▶ Hand- and machine-controlled adjustment and alignment

DP

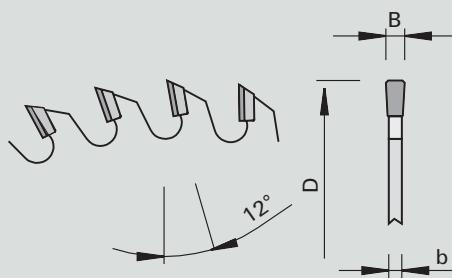
HKS - LR

Portable Saw Blades DP - flat tooth

Product



Drawing



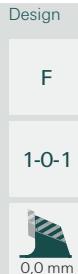
Machine



Application



Design



F

1-0-1

0,0 mm

Machine / Application

- portable saws
- for sizing cuts in cement-bound boards
- not for stone, glass and nails

Design

- tooth configuration: flat "F"
- cutting material: DP

Advantages

- excellent chip removal thanks to large chip evacuation gap
- easy cutting thanks to large hook angle

Notes

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
160	2,2	1.6	20	4	▲	12	1	50457997	
190	2,2	1.6	30	4	▲	2/7/42	1	50457994	
230	2,2	1.6	30	4	▲	Combi3	1	50457992	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP

HKS - L

Portable Saw Blades DP - flat tooth

Product	Drawing	Machine	Application	Design
				1,0 mm

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable saws for trimming and finish cuts in laminate, MDF, particle boards, cement-bound boards, Corian, thermosetting plastics, gypsum boards and melamine not for stone, glass and nails 	<ul style="list-style-type: none"> tooth configuration: flat "F" cutting material: DP resharpening area 1.0 mm 	<ul style="list-style-type: none"> excellent chip removal thanks to large chip evacuation gap easy cutting thanks to large hook angle 	<ul style="list-style-type: none"> lower numbers of teeth for trimming cuts higher numbers of teeth for sizing cuts

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order information	
										Order-No.	NEW
120	2,2	1.6	20	6	▲	2/7/42	12	1	o	50457378	
160	2,2	1.6	20	8	▲	2/6/32,5	12	1		50457379	
160	2,2	1.6	20	30	▲▲▲	2/6/32,5	8	1		50458171	
160	2,2	1.6	30	8	▲	2/7/42	12	1	o	50457377	
190	2,2	1.6	30	30	▲▲▲	2/7/42	12	1		58457361	NEW
180	2,2	1.6	30	8	▲	2/7/42	12	1	o	50457356	
190	2,2	1.6	30	8	▲	2/7/42	12	1		50457357	
210	2,2	1.6	30	12	▲	Combi3	12	1		50457358	
216	2,2	1.6	30	12	▲	Combi3	12	1		50458137	
230	2,2	1.6	30	15	▲	Combi3	12	1		50457359	
230	2,2	1.6	30	30	▲▲	Combi3	12	1		50457362	
250	2,2	1.6	30	16	▲	Combi3	12	1		50457360	
250	2,2	1.6	30	40	▲▲▲	Combi3	8	1	o	50458000	
300	2,2	1.6	30	36	▲	Combi3	12	1		50457557	
300	2,2	1.6	30	48	▲▲	Combi3	8	1	o	50457545	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

DP

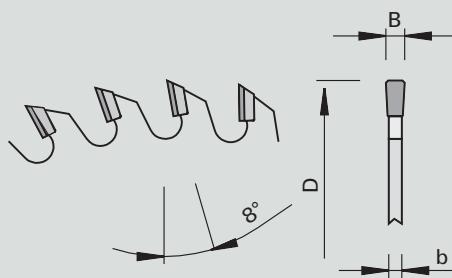
HKS - L

Portable Saw Blades DP - flat tooth with chamfer

Product



Drawing



Machine



Application



Design



Machine / Application

- portable saws
- for trimming cuts in laminate, MDF, particle boards, cement-bound boards, Corian, thermosetting plastics, gypsum boards and melamine
- not for stone, glass and nails

Design

- tooth configuration: flat with chamfer "F-FA"
- cutting material: DP
- resharpening area 2.5 mm

Advantages

- excellent chip removal thanks to large chip evacuation gap
- robust design

Notes

- lower numbers of teeth for trimming cuts
- higher numbers of teeth for sizing cuts

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
160	3,0	2,2	20	4	▲	2/6/32,5	8		1	o	58458790
180	3,0	2,2	30	4	▲	2/6/32,5	8		1	o	58458799
190	3,0	2,2	20	4	▲	Fast-Fix	8		1	o	58458800
190	3,0	2,2	30	4	▲	2/7/42	8		1	o	58458791
216	3,0	2,2	30	4	▲	Combi3	8		1	o	58458792
230	3,0	2,2	30	6	▲▲	Combi3	8		1	o	58458793
250	3,0	2,2	30	6	▲▲	Combi3	8		1	o	58458794
260	2,5	1,8	30	8	▲▲	Combi3	8		1	o	58458797
300	3,0	2,2	30	8	▲▲	Combi3	8		1	o	58458795
400	3,4	2,4	30	18	▲▲▲	Combi2	8		1	o	58458798

Abrasive

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

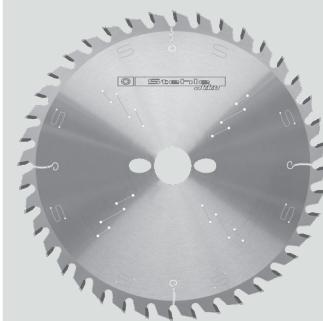
** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

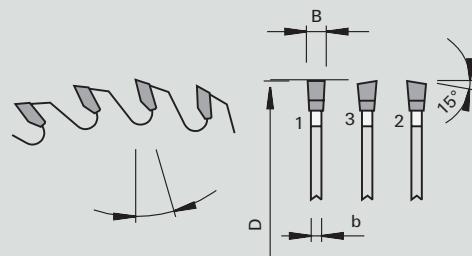
HW**HKS - solid for cordless portable saws**

Portable Saw Blades HW - alternate top bevel

Product



Drawing



Machine



Application



Design

1-0-1
HW TC10
F-WS

Machine / Application

- cordless portable saws
- for ripping and cross cuts in solid woods

Design

- tooth configuration: flat tooth with alternate top bevel "F-WS"
- cutting material: HW TC10

Advantages

- low power consumption thanks to reduced kerf

Notes

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	\varnothing d [inch]	Z	Cutting quality*	Hook angle [°]	PU [pc.]	L	Order-No.
136	1,5	1.0	20		18	▲	Dewalt	20	1	58110400
136	1,5	1.0	20		24	▲▲	Dewalt	20	1	58110401
160	1,6	1.0	20		18	▲	Mafell, Festool	20	1	58110413 NEW
165	1,5	1.0	20		18	▲	Makita, Dewalt	20	1	58110402
165	1,5	1.0	20		24	▲	Makita, Dewalt	20	1	58110403
165	1,5	1.0	20		36	▲▲	Makita, Dewalt	20	1	58110404
165	1,6	1.0		5/8	40	▲▲▲	Milwaukee	15	1	58110405
184	1,6	1.0	16		56	▲▲▲	Dewalt	15	1	58110406
190	1,8	1.0	20		48	▲▲▲	Dewalt	15	1	58110407
210	1,8	1.0	30		60	▲▲▲	Dewalt Extrem	15	1	58110408
216	2,0	1.4	30		24	▲	Dewalt	20	1	58110409
216	2,0	1.4	30		36	▲▲	Dewalt	20	1	58110410
216	2,0	1.0	30		60	▲▲▲	Dewalt	15	1	58110411
250	2,2	1.4	30		24	▲	Dewalt	20	1	58110412

Construction

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

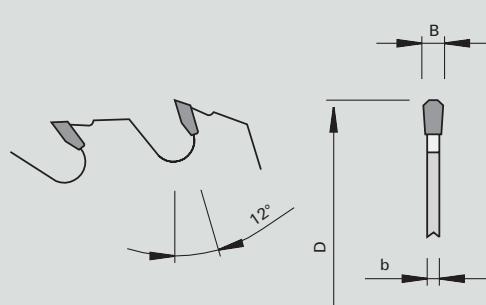
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**BKS (nail proof)****Construction Saw Blades HW - flat with two-sided chamfer**

Product



Drawing



Machine



Application



Design

2-0-6

HW
TC25F-
FA

Machine / Application

- table saws (construction site)
- portable saws
- clipping and miter saws
- for sizing cuts in solid woods and wood-based panels

Design

- tooth configuration: flat with two-sided chamfer "F-FA"
- cutting material: HW TC25

Advantages

- nail-proof

Notes

- larger bore (max. Ø 50 mm) available for a surcharge
- when using the clipping and miter saws, make sure that the workpiece is securely clamped

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
190	3,0	2,0	30	14	▲	2/7/42	12	1		58112011
210	3,2	2,2	30	14	▲	2/7/42	12	1	o	50112013
235	2,8	1,8	30	16	▲	Combi3	12	1		58112015
250	3,2	2,2	30	16	▲	Combi3	12	1		58120220
300	3,2	2,2	30	20	▲	Combi3	12	1		58120041
315	3,2	2,2	30	20	▲	Combi3	12	1		58120046
350	3,5	2,5	30	24	▲	Combi3	12	1		58120042
400	3,5	2,5	30	28	▲	Combi3	12	1		58120043
450	3,8	2,8	30	30	▲	Combi3	12	1		58120044
500	3,8	2,8	30	34	▲	Combi3	12	1		58120045
600	4,4	3,2	30	36	▲	Combi3	12	1		58120227
700	4,6	3,2	30	42	▲	Combi3	12	1		58120228

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**HKS - solid**

Portable Saw Blades HW - alternate top bevel

Product	Drawing	Machine	Application	Design
				WS

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable saws clipping and miter saws for ripping and cross cuts in solid woods 	<ul style="list-style-type: none"> tooth configuration: alternate top bevel "WS" cutting material: HW TC10 		<ul style="list-style-type: none"> for larger dimensions see ZQW

Product features									Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.	
120	1,8	1.3	20	24	▲▲		15	1		50104061	
125	2,4	1.6	20	20	▲▲	2/5,5/30	15	1		50110011	
130	2,4	1.6	20	20	▲▲	2/6/32,5	15	1		50110017	
140	2,4	1.6	20	20	▲▲	2/6/32,5	15	1		50110028	
140	2,4	1.6	20	12	▲	2/6/32,5	20	1		50110242	
150	2,6	1.6	20	24	▲▲	2/6/32,5	15	1		50110039	
150	2,6	1.6	20	12	▲	2/6/32,5	20	1		50110243	
150	2,6	1.6	30	24	▲▲	2/7/42	15	1		50110042	
152	2,6	1.6	20	24	▲▲		15	1		58114125	
160	2,6	1.6	16	24	▲▲	2/6/32,5	15	1		50110051	
160	2,2	1.6	20	24	▲▲	2/6/32,5	15	1		50110054	
160	2,2	1.6	20	12	▲	2/6/32,5	20	1		50110244	
160	2,6	1.6	30	24	▲▲	2/7/42	15	1		50110057	
165	2,6	1.6	20	24	▲	2/6/32,5	15	1		50110060	
165	2,6	1.6	30	24	▲	2/7/42	15	1		50110130	
170	2,6	1.6	30	24	▲▲	2/7/42	20	1		50110069	
180	2,6	1.6	16	24	▲▲	2/6/32,5	15	1		50110081	
180	2,6	1.6	20	24	▲▲	2/6/32,5	20	1		50110075	
180	2,6	1.6	20	14	▲	2/6/32,5	20	1		50110247	
180	2,6	1.6	30	24	▲▲	2/7/42	20	1		50110078	
180	2,6	1.6	30	14	▲	2/7/42	20	1		50110248	
184	2,6	1.6	20	24	▲▲	2/6/32,5	15	1	o	50110082	
184	2,6	1.6	16	40	▲▲▲	2/6/32,5	15	1	o	50110282	
190	2,6	1.6	16	24	▲▲	2/6/32,5	15	1		50110153	
190	2,6	1.6	20	16	▲	2/6/32,5	20	1	o	50110250	
190	2,6	1.6	20	24	▲▲	2/6/32,5	15	1		50110154	
190	2,6	1.6	30	24	▲▲	2/7/42	20	1		50110155	
190	2,6	1.6	30	16	▲	2/7/42	20	1		50110251	
190	2,6	1.6	30	24	▲▲		15	1		58114105	
200	2,8	1.8	30	30	▲▲▲	2/7/42	15	1		50110095	
203	2,7	1.8	30	24	▲▲		15	1		58114132	
200	2,8	1.8	30	18	▲	2/7/42	20	1		50110252	
205	2,6	1.8	18	30	▲▲▲		15	1		50110286	
210	2,8	1.8	30	30	▲▲▲	2/7/42	15	1		50110104	
210	2,8	1.8	30	18	▲	2/7/42	20	1		50110253	
216	2,8	1.8	30	30	▲▲▲	2/7/42	20	1		50110107	
220	2,8	1.8	30	36	▲▲▲	2/7/42	15	1		50110110	
220	2,8	1.8	30	24	▲▲	2/7/42	15	1		50110164	
225	2,8	1.8	30	24	▲▲	2/7/42	15	1		50110165	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
225	2,8	1,8	30	34	▲▲▲	2/7/42	15		1		50110228
230	2,8	1,8	30	36	▲▲▲	2/7/42	15		1		50110113
230	2,8	1,8	30	24	▲▲	2/7/42	15		1		50110168
230	2,8	1,8	30	18	▲	2/7/42	20		1		50110255
240	3,0	2,0	30	64	▲▲▲	2/7/42	20		1	o	50687903

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	HKS - Board	Portable Saw Blades HW - alternate top bevel		
Product	Drawing	Machine	Application	Design
				WS
				1-0-1
				HW TC10

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable saws clipping and miter saws for ripping and cross cuts in wood-based panels 	<ul style="list-style-type: none"> tooth configuration: alternate top bevel "WS" cutting material: HW TC10 design 58110356 vario group Z= 4x12, vario = uneven tooth pitch 		<ul style="list-style-type: none"> for larger dimensions see ZWS

Product features										Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.			
100	2,4	1.4	12	30	▲▲▲	10	1		50110001			
100	2,4	1.4	22	30	▲▲▲	10	1		50110003			
105	2,4	1.4	22	30	▲▲▲	10	1		50110006			
125	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		50110012			
130	2,4	1.6	20	36	▲▲	2/6/32,5	10		50110018			
140	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		50110029			
150	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		50110040			
150	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		50110041			
160	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		50110053			
160	2,2	1.6	20	36	▲▲▲	2/6/32,5	15		50110055			
160	2,2	1.6	20	48	▲▲▲▲	2/6/32,5	10		50110056			
160	2,2	1.6	20	48	▲▲▲▲	2/6/32,5	5		58110356			
160	2,6	1.6	30	36	▲▲▲	2/7/42	15		50110058			
160	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		50110059			
165	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		50110061			
165	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		50110062			
170	2,6	1.6	30	36	▲▲▲	2/7/42	15		50110070			
170	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		50110071			
180	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		50110183			
180	2,6	1.6	20	40	▲▲▲	2/6/32,5	15		50110076			
180	2,6	1.6	30	40	▲▲▲	2/7/42	15		50110079			
180	2,6	1.6	30	54	▲▲▲▲	2/7/42	10		50110080			
180	2,6	1.6	20	54	▲▲▲▲		10		o 50110077			
190	2,6	1.6	16	30	▲▲▲	2/6/32,5	15		50110083			
190	2,6	1.6	16	42	▲▲▲▲	2/6/32,5	10		50110084			
190	2,6	1.6	20	30	▲▲▲	2/6/32,5	15		50110086			
190	2,8	2.0	20FX	32	▲▲▲	Fast-Fix	10		1 o 50110266			
190	2,8	2.0	20FX	48	▲▲▲▲	Fast-Fix	10		1 o 50110267			
190	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		50110087			
190	2,6	1.6	30	30	▲▲▲	2/7/42	15		50110089			
190	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		50110090			
190	2,6	1.6	30	60	▲▲▲▲	2/7/42	10		50110091			
200	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		50110096			
200	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		50110097			
210	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		50110105			
210	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		50110106			
216	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		50110108			

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
216	2,8	1,8	30	60	▲▲▲▲	2/7/42	10	1	50110109	
220	2,8	1,8	30	48	▲▲▲▲	2/7/42	15	1	50110111	
220	2,8	1,8	30	64	▲▲▲▲	2/7/42	10	1	50110112	
225	2,8	1,8	30	48	▲▲▲▲	2/7/42	10	1	50110237	
225	2,6	1,8	30	64	▲▲▲▲	2/7/42	10	1	50687902	
230	2,8	1,8	30	48	▲▲▲▲	2/7/42	15	1	50110114	
230	2,8	1,8	30	64	▲▲▲▲	2/7/42	10	1	50110115	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW Saw Blade Set HW 3 piece set in wood box									
Product	Drawing	Machine	Application	Design					
		  	  	WS TR-F 2-0-6 HW TC10					
Machine / Application	Design	Advantages	Notes						
<ul style="list-style-type: none"> portable saws clipping and miter saws for ripping and cross cuts in solid woods 	<ul style="list-style-type: none"> tooth configuration: alternate top bevel "WS" tooth configuration: triple chip / flat "TR-F" cutting material: HW TC10 								
Product features	Order information								
	Dimension [mm]		PU [pc.]	L Order-No.					
Saw Blades - Set 1	160x20		1	50111160					
Product features	Order information								
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL	PU [pc.]	L	Order-No.
HKS - Massiv	160	2,2	1.6	20	24	WS 2/6/32,5	1		50110054
HKS - Board	160	2,2	1.6	20	48	WS 2/6/32,5	1		50110056
Parat - negative (HKS)	160	2,2	1.6	20	42	TR-F 2/6/32,5	1		58115004
Aluminum case							1		50992828
Product features	Order information								
	Dimension [mm]		PU [pc.]	L Order-No.					
Saw Blades - Set 2	160x20		1	50111163					
Product features	Order information								
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL	PU [pc.]	L	Order-No.
HKS - Massiv	160	2,2	1.6	20	24	WS 2/6/32,5	1		50110054
HKS - Board	160	2,2	1.6	20	36	WS 2/6/32,5	1		50110055
HKS - Board	160	2,2	1.6	20	48	WS 2/6/32,5	1		50110056
Aluminum case							1		50992828
Product features	Order information								
	Dimension [mm]		PU [pc.]	L Order-No.					
Saw Blades - Set 3	190x30		1	50111193					
Product features	Order information								
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL	PU [pc.]	L	Order-No.
HKS - Massiv	190	2,6	1.6	30	24	WS 2/7/42	1		50110155
HKS - Board	190	2,6	1.6	30	30	WS 2/7/42	1		50110089
HKS - Board	190	2,6	1.6	30	48	WS 2/7/42	1		50110090
Aluminum case							1		50992828

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

Product features							Order information			
		Dimension [mm]						PU [pc.]	L	Order-No.
Saw Blades - Set 4		190x30						1	501111190	
Product features										
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL		PU [pc.]	L	Order-No.
HKS - Massiv	190	2,6	1,6	30	24	WS	2/7/42	1	50110155	
HKS - Board	190	2,6	1,6	30	48	WS	2/7/42	1	50110090	
Parat - negative (HKS)	190	2,8	2,2	30	54	TR-F	2/7/42	1	58115010	
Aluminum case								1	50992828	
Product features										
		Dimension [mm]						PU [pc.]	L	Order-No.
Saw Blades - Set 5		216x30						1	50111216	
Product features										
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL		PU [pc.]	L	Order-No.
Parat - negative (HKS)	216	2,8	2,2	30	60	TR-F	2/7/42	1	58115024	
K + G - negative	216	2,8	1,8	30	48	WS	2/7/42	1	58110181	
K + G - negative	216	2,8	1,8	30	24	WS	2/7/42	1	58110180	
Aluminum case								1	50992828	
Product features										
		Dimension [mm]						PU [pc.]	L	Order-No.
Saw Blades - Set 6		235x30						1	50111235	
Product features										
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL		PU [pc.]	L	Order-No.
ZQW	235	2,8	1,8	30	24	WS	2/7/42	1	50110170	
ZWS	235	2,8	1,8	30	48	WS	2/7/42	1	58110121	
NF - negative	235	2,8	2,2	30	64	TR-F	2/7/42	1	58115018	
Aluminum case								1	50992828	
Product features										
		Dimension [mm]						PU [pc.]	L	Order-No.
Saw Blades - Set 7		250x30						1	50111250	
Product features										
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry NL		PU [pc.]	L	Order-No.
ZQW	250	3,2	2,2	30	24	WS	2/7/42 + 2/9,5/46,5 + 2/10/60	1	58120060	
ZWS	250	3,2	2,2	30	40	WS	2/7/42 + 2/9,5/46,5 + 2/10/60	1	58100018	
NF - negative	250	3,2	2,5	30	80	TR-F	2/7/42 + 2/9,5/46,5 + 2/10/60	1	58808203	
Aluminum case								1	50992828	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	ZFL	Trimming Saw Blades HW - flat tooth		
Product	Drawing	Machine	Application	Design
				2-0-6 HW TC10 F

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • special machines • for sizing cuts in solid woods • especially for knotty woods 	<ul style="list-style-type: none"> • tooth configuration: flat "F" • cutting material: HW TC10 	<ul style="list-style-type: none"> • no chipped edges from knots thanks to chip limiter 	<ul style="list-style-type: none"> • larger bore (max. Ø 50 mm) available for a surcharge

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
250	3,2	2.2	30	18	▲	Combi3	20	1		58104050
270	3,0	2.0	30	18	▲	Combi3	20	1	o	58114170
300	3,2	2.2	30	14	▲	Combi3	20	1	#	58104006
315	3,2	2.2	30	14	▲	Combi3	20	1		58104055 NEW
350	3,5	2.5	30	16	▲	Combi3	20	1		58104015
350	3,5	2.5	30	24	▲	Combi3	20	1		58104041
400	3,5	2.5	30	18	▲	Combi3	20	1		58104021
450	3,8	2.8	30	32	▲	Combi3	20	1		58104051
500	3,8	2.8	30	36	▲	Combi3	20	1		58104052
550	4,6	3.2	30	32	▲	Combi3	20	1		58104054
600	4,2	3.2	30	40	▲	Combi3	20	1		58104048
700	4,2	3.2	30	46	▲	Combi3	20	1		58104049
700	6,0	4.5	30	42	▲		20	AMR	1	58104053

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

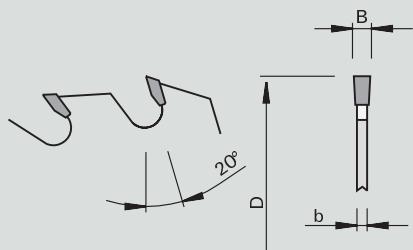
HW**ZFZ**

Trimming Saw Blades HW - flat tooth

Product



Drawing



Machine



Application



Design

F

2-0-6

HW
TC15

Machine / Application

- table saws
- special machines
- for longitudinal cuts in soft woods

Design

- tooth configuration: flat "F"
- cutting material: HW TC15

Advantages

- special HW quality for coniferous wood
- extreme edge projection for efficient cuts

Notes

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

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
400	4,4	2,8	30	28	▲	2/10/60	20	1	50100183

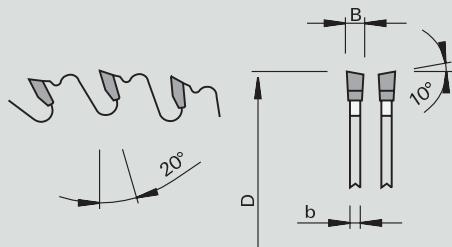
HW**ZW**

Trimming Saw Blades HW - alternate bevel tooth

Product



Drawing



Machine



Application



Design

WS

2-0-6

HW
TC10

Machine / Application

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

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC10

Advantages

- no chipped edges from knots thanks to chip limiter

Notes

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

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
250	3,2	2,2	30	24	▲	Combi3	20	1	58102001
300	3,2	2,2	30	28	▲	Combi3	20	1	58102002
315	3,2	2,2	30	28	▲	Combi3	20	1	58102003
350	3,5	2,5	30	32	▲	Combi3	20	1	58101004
400	3,5	2,5	30	36	▲	Combi3	20	1	58101005
450	4,2	2,8	30	20	▲	Combi3	25	1	58101020
450	3,8	2,8	30	40	▲	Combi3	20	1	58101006
500	3,8	2,8	30	44	▲	Combi3	20	1	58102007
600	4,2	3,2	30	54	▲	Combi3	20	1	58101018
700	4,2	3,2	30	60	▲	Combi3	20	1	58101019

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

Wood

HW ZQW Trimming Saw Blades HW - alternate bevel tooth																							
Product	Drawing						Machine	Application	Design														
									WS														
									2-0-6	HW TC06	HW TC10												
Machine / Application	Design			Advantages			Notes																
• table saws • special machines • for sizing cuts in solid woods	• tooth configuration: alternate top bevel "WS" • cutting material: HW TC10/HW TC06			• optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth			• larger bore (max. Ø 50 mm) available for a surcharge																
Product features																							
Order information																							
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.													
150	3,2	2.2	30	24	▲	2/7/42	15	1		58100096													
180	3,2	2.2	30	30	▲▲	2/7/42	15	1		58100016													
200	3,2	2.2	30	34	▲▲	2/7/42	15	1		58100017													
235	2,8	1.8	30	18	▲	2/7/42	20	1		50110256													
235	2,8	1.8	30	24	▲▲	2/7/42	15	1		50110170													
235	3,2	2.2	30	24	▲	Combi3	10	1		58100191													
240	2,8	1.8	30	24	▲▲	2/7/42	20	1		50110174													
250	2,8	1.8	30	40	▲▲	Combi3	15	1	#	58120020													
250	3,2	2.2	30	24	▲▲	Combi3	20	1		58120060													
250	3,2	2.2	30	30	▲▲	Combi3	20	1		58120061													
260	3,2	2.2	30	32	▲▲	Combi3	20	1		58110185													
270	3,2	2.2	30	24	▲▲	Combi3	20	1		58110176													
300	3,2	2.2	30	24	▲	Combi3	20	1		58120002													
300	3,2	2.2	30	36	▲	Combi3	20	1		58120013													
315	3,2	2.2	30	28	▲	Combi3	20	1		58120062													
315	3,2	2.2	30	36	▲	Combi3	20	1		58100255													
330	3,2	2.2	30	24	▲	Combi3	25	1		58120018													
335	3,2	2.2	30	36	▲	Combi3	20	1		58120063													
350	3,5	2.5	30	24	▲	Combi3	20	1		58120005													
350	3,5	2.5	30	32	▲▲	Combi3	20	1		58100011													
350	3,5	2.5	30	36	▲	Combi3	20	1		58120014													
350	3,5	2.5	30	42	▲	Combi3	20	1		58120015													
400	3,5	2.5	30	28	▲	Combi3	20	1		58100005													
400	3,5	2.5	30	32	▲	Combi3	20	1		58120008													
400	3,5	2.5	30	36	▲▲	Combi3	20	1		58100012													
400	3,5	2.5	30	48	▲▲	Combi3	20	1		58120017													
410	3,8	2.8	30	28	▲	Combi3	20	1		58120019													
450	3,8	2.8	30	40	▲▲	Combi3	20	1		58100013													
500	3,8	2.8	30	44	▲▲	Combi3	20	1		58100014													

Wood

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

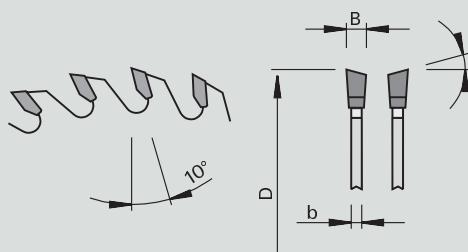
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**ZWS****Trimming and Finish Cut Saw Blades HW - alternate bevel**

Product



Drawing



Machine



Application



Design



WS

2-0-6

HW

TC06

Machine / Application

- table saws
 - special machines
 - for sizing cuts in wood-based panels
- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC06

Design

Advantages

- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth

Notes

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

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
150	3,2	2.2	30	36	▲▲	2/7/42	10		1	58100099
150	3,2	2.2	30	48	▲▲▲	2/7/42	10		1	58100101
180	3,2	2.2	30	54	▲▲▲	2/7/42	10		1	58100015
200	3,2	2.2	30	48	▲▲▲	2/7/42	10		1	58100091
200	3,2	2.2	30	64	▲▲▲	2/7/42	10		1	58100025
235	2,8	1.8	30	36	▲▲▲	2/7/42	15		1	50110117
235	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	58110121
235	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	58110118
235	3,2	2.2	30	34	▲▲		10		1	o 50100193
240	2,8	1.8	30	36	▲▲▲	2/7/42	15		1	50110123
240	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110124
250	3,2	2.2	30	40	▲▲▲	Combi3	10		1	58100018
250	3,2	2.2	30	48	▲▲▲▲	Combi3	10		1	58100026
250	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1	58100031
250	3,2	2.2	30	80	▲▲▲▲	Combi3	10		1	58100038
254	3,1	2.2	30	40	▲▲▲		10		1	58114108
254	3,2	2.2	30	40	▲▲▲	Combi3	10		1	58120067
254	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1	58120068
260	3,2	2.2	30	40	▲▲▲	Combi3	10		1	58110175
260	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1	58100254
270	3,2	2.2	30	42	▲▲▲		10		1	o 50110064
270	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1	58110182
280	3,2	2.2	30	48	▲▲▲▲	Combi3	10		1	58110136
300	3,2	2.2	30	48	▲	Combi3	10		1	58100250
300	3,2	2.2	30	60	▲▲	Combi3	10		1	58100027
300	3,2	2.2	30	72	▲▲	Combi3	10		1	58100032
300	3,2	2.2	30	96	▲▲▲	Combi3	10		1	58100251
305	3,2	2.2	30	48	▲	Combi3	10		1	58120065
305	3,2	2.2	30	60	▲▲	Combi3	10		1	58120066
315	3,2	2.2	30	48	▲	Combi3	10		1	58100252
315	3,2	2.2	30	60	▲▲	Combi3	10		1	58100253
350	3,5	2.5	30	54	▲▲	Combi3	10		1	58100021
350	3,5	2.5	30	72	▲▲	Combi3	10		1	58100028
350	3,5	2.5	30	84	▲▲	Combi3	10		1	58100033
350	3,5	2.5	30	108	▲▲▲	Combi3	10		1	58100040
400	3,5	2.5	30	60	▲▲	Combi3	10		1	58100022
400	3,5	2.5	30	84	▲▲▲	Combi3	10		1	58100029
400	3,5	2.5	30	96	▲▲▲	Combi3	10		1	58100034
400	3,5	2.5	30	120	▲▲▲	Combi3	10		1	58100041

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

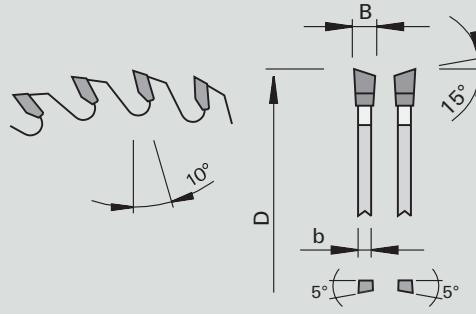
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

Wood

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
450	3,8	2,8	30	66	▲▲	Combi3	10	1	58100023	
450	3,8	2,8	30	108	▲▲▲	Combi3	10	1	58100060	
500	3,8	2,8	30	72	▲▲	Combi3	10	1	58100024	
550	4,0	3,0	30	64	▲	Combi3	10	1	58120070	

HW ZWS-1

Trimming and finish cut saw blades HW - alternate top bevel with shear angle

Product	Drawing	Machine	Application
			
			WSA
			3-0-1
			HW TC06
			
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • special machines • for sizing cuts in wood-based panels 	<ul style="list-style-type: none"> • tooth configuration: alternate top bevel with shear angle "WSA" • cutting material: HW TC06 	<ul style="list-style-type: none"> • optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth • reduced cutting pressure thanks to alternating shear angle • long edge lives provide for the necessary productivity and economic efficiency 	<ul style="list-style-type: none"> • larger bore (max. Ø 50 mm) available for a surcharge

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
250	3,2	2,2	30	40	▲▲	Combi3	10	1	58100700	
250	3,2	2,2	30	60	▲▲▲	Combi3	10	1	58100701	
300	3,2	2,2	30	48	▲▲	Combi3	10	1	58100702	
300	3,2	2,2	30	96	▲▲▲▲	Combi3	10	1	58100703	
350	3,5	2,5	30	54	▲▲	Combi3	10	1	58100704	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

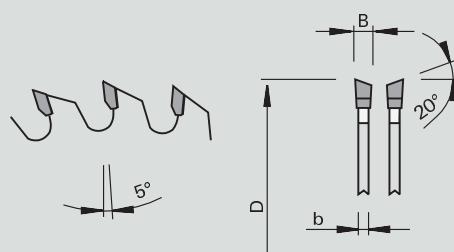
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**OKW****Optimizing Chop Saw Blades HW - alternate top bevel**

Product



Drawing



Machine



Application



Design

WS

3-0-1

HW
TCw15

Machine / Application

- optimizing chop saws
- for cross cuts in solid woods

Design

- positive hook angle
- tooth configuration: alternate top bevel "WS"
- cutting material: HW TCw15

Advantages

Notes

- other dimensions on request

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
500	4,6	3,5	30	144	▲▲▲	2/15/63 + 2/10/60	5	1		50807842

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

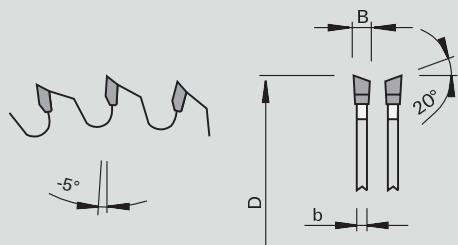
HW**K + G - negative**

Clipping and Miter Saw Blades HW - alternate bevel

Product



Drawing



Machine



Application



Design



WS

2-0-6

HW

TC06

Machine / Application

- clipping and miter saws
- for cross cuts in solid woods and wood-based panels

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC06

Advantages

- high cutting quality and safe handling thanks to negative hook angle

Notes

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
210	2,8	1.8	30	48	▲▲	2/7/42	-5	1		58110194
216	2,8	1.8	30	24	▲	2/7/42	-5	1		58110180
216	2,8	1.8	30	48	▲▲	2/7/42	-5	1		58110181
216	2,8	1.8	30	60	▲▲▲	2/7/42	-5	1		58110192
254	3,2	2.2	30	24	▲▲	Combi3	-5	1		58118119
254	3,2	2.2	30	40	▲▲	Combi3	-5	1		58100218
254	3,2	2.2	30	60	▲▲▲	Combi3	-5	1		58100231
254	3,2	2.2	30	80	▲▲▲	Combi3	-5	1		58110139
260	2,5	1.8	30	60	▲▲	Combi3	-5	1		58100233
260	2,5	1.8	30	80	▲▲▲	Combi3	-5	1		58100234
300	3,2	2.2	40	72	▲▲▲	4/12/64 + 2/9/55	-5	1		58100237
305	3,2	2.2	30	60	▲▲	Combi3	-5	1		58110281
305	3,2	2.2	30	32	▲	Combi3	-5	1		58110270
305	3,2	2.2	30	96	▲▲▲	Combi3	-5	1		58110272
315	3,2	2.2	30	84	▲▲▲▲	Combi3	-5	1	o	58110274
350	3,2	2.2	40	72	▲▲	4/12/64 + 2/9/55	-5	1		58110273
355	3,5	2.5	30	96	▲▲▲	Combi3	-5	1		58110143
420	3,5	2.5	40	84	▲▲	4/12/64 + 2/9/55	-5	1		58110144
420	4,4	2.8	40	54	▲▲	4/12/64 + 2/9/55	-5	1		58110145

Wood

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

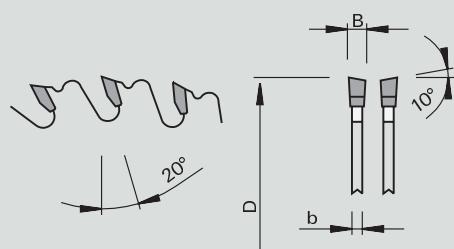
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**Planet****Gang-Rip Saw Blades HW with internal HW-rakers - alternate bevel tooth**

Product



Drawing



Machine



Application



Design



WS

3-0-1

HW

TC20

Machine / Application

- table saws
- length cutting saws
- for ripping and cross cuts in wet and dry solid woods

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC20
- 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

- suitable for manual feed
- from now on with reinforced tool body and larger cutting width

Product features

Order information

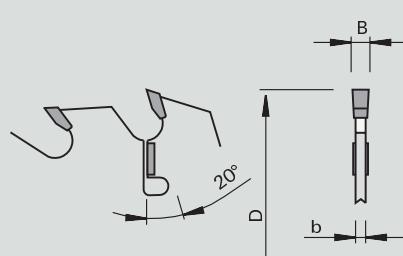
\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality* NL**	Number of rakers [pc.]	PU [pc.]	L	Order-No.
350	3,8	2,5	30	24	▲	Combi2	2+2	1	50804422
400	4,2	2,5	30	28	▲	Combi2	2+2	1	50804423
450	4,2	3,0	30	36	▲	Combi2	2+2	1	50804425

HW**LWR****Gang-Rip Saw Blades HW with HW-rakers - flat tooth**

Product



Drawing



Machine



Application



Design



F

3-0-1

HW

TC25

Machine / Application

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

Design

- tooth configuration: flat "F"
- cutting material: HW TC25

Advantages

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

Notes

- for cutting height > 50 mm

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality* DKN [mm]	Number of rakers [pc.]	PU [pc.]	L	Order-No.
250	3,2	2,2	70	20	▲	2 x 20x5	2+2	1	50457841
300	3,4	2,2	70	22	▲	2 x 20x5	2+2	1	50100525
350	3,6	2,5	70	20	▲	2 x 20x5	2+2	1	50100528
350	3,6	2,4	70	28	▲	2 x 20x5	2+2	1	50457843

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

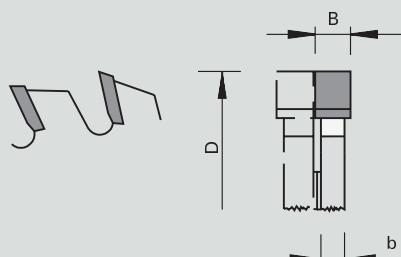
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**1101 Grooving Cutters**

Product



Drawing



Machine



Application



Design

F**MAN**

Machine / Application

- table shapers
- tooth configuration: flat "F"
- for chip-free grooving in solid woods and in wood-based panels
- cutting material: HW

Design

Advantages

Notes

- application against feed with the grain (solid wood)
- application with feed only with MEC (wood-based panels)
- other grooving widths possible by set-combinations
- groove width calculation for tool sets: sum of all "b" + HW overlap left and right + shim thickness

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z		nmin-nmax [min-1]		PU [pc.]	L	Order-No.
125	1,5	0.8	30	12	MAN	6100-10500		1		50188359
125	1,8	1.0	30	12	MAN	6100-10500		1		50188360
125	2,0	1.2	30	12	MAN	6100-10500		1		50188361
125	2,2	1.2	30	12	MAN	6100-10500		1		50188362
125	2,5	1.4	30	12	MAN	6100-10500		1		50188363
125	3,0	2.0	30	12	MAN	6100-10500		1		50188364
125	3,5	2.5	30	12	MAN	6100-10500		1		50188365
125	4,0	2.5	30	12	MAN	6100-10500		1		50188366
125	4,5	3.0	30	12	MAN	6100-10500		1		50188367
125	5,0	4.0	30	12	MAN	6100-10500		1		50188368
125	6,0	4.0	30	12	MAN	6100-10500		1		50188369
125	7,0	5.0	30	12	MAN	6100-10500		1		50188370
125	8,0	5.0	30	12	MAN	6100-10500		1		50188371
125	10	6.0	30	12	MAN	6100-10500		1		50188372
150	1,5	0.8	30	12	MAN	5200-8800		1		50188373
150	2,0	1.2	30	12	MAN	5200-8800		1		50188375
150	2,2	1.2	30	12	MAN	5200-8800		1		50188376
150	2,5	1.5	30	12	MAN	5200-8800		1		50188377
150	3,0	2.0	30	12	MAN	5200-8800		1		50188378
150	3,5	2.5	30	12	MAN	5200-8800		1		50188379
150	4,0	3.0	30	12	MAN	5200-8800		1		50188380
150	4,5	3.5	30	12	MAN	5200-8800		1		50188381
150	5,0	4.0	30	12	MAN	5200-8800		1		50188382
150	6,0	4.0	30	12	MAN	5200-8800		1		50188383
150	7,0	5.0	30	12	MAN	5200-8800		1		50188384
150	8,0	5.0	30	12	MAN	5200-8800		1		50188385
150	9,0	6.0	30	12	MAN	5200-8800		1		50188386
150	10	6.0	30	12	MAN	5200-8800		1		50188387

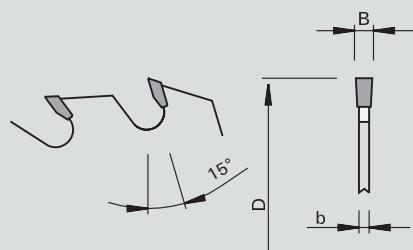
Wood

HW**NK****Grooving Saw Blades HW - flat tooth**

Product



Drawing



Machine



Application



Design

F
HW TC06
MEC

Machine / Application

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

Design

- tooth configuration: flat "F"
- cutting material: HW TC06

Advantages

Notes

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

Product features

Order information

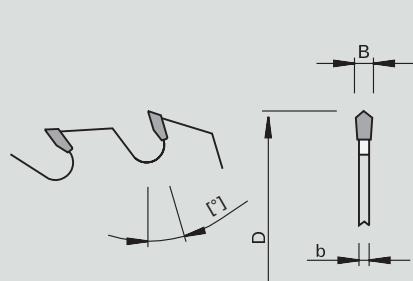
$\varnothing D$ [mm]	B [mm]	b [mm]	$\varnothing d$ [mm]	Z	Cutting quality*	Hook angle [°]	PU [pc.]	L	Order-No.
180	4,0	3,0	30	18	▲▲▲	MEC	15		1 50169685
180	5,0	4,0	30	18	▲▲▲	MEC	15		1 50169684
180	8,0	5,0	30	18	▲▲▲	MEC	15		1 50169683
180	10	6,0	30	18	▲▲▲	MEC	15		1 50169682

HW**NKP****Grooving Saw Blades - prism HW - V-tooth**

Product



Drawing



Machine



Application



Design

Wood

Machine / Application

- machines Lamello®, portable saws
- for V grooving in solid woods and wood-based panels, longitudinal cuts

Design

- tooth configuration: prism "V"
- cutting material: HW TC10

Advantages

Notes

- application against feed with the grain (solid wood)

Product features

Order information

$\varnothing D$ [mm]	B [mm]	b [mm]	$\varnothing d$ [mm]	Z	nmin-nmax [min-1]	PU [pc.]	L	Order-No.
100	7,0	5,0	22	6	MAN	7600-13000	1	o 50660303
160	6,0	3,0	20	12	MAN	7600-13000	1	o 50660304

HW	NK3VS	Grooving Saw Blades HW - adjustable - top bevel-flat + flat + top bevel-flat		
Product	Drawing	Machine	Application	Design
				ES-F F ES-F
				3-0-1
				HW TC06

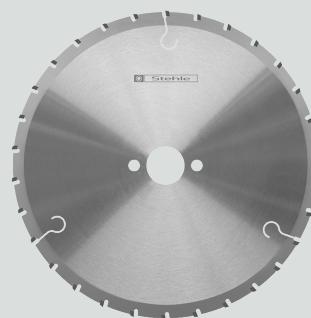
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • clipping saws • for precise grooving in solid wood along and accross the grain as well as in wood-based panels such as particle boards, MDF, etc. 	<ul style="list-style-type: none"> • 3 parts, adjustable by means of spacers • additional expansion slots • tooth configuration: scoring saw blade top bevel-flat "ES-F", main saw blade flat "F" • cutting material: HW TC06 	<ul style="list-style-type: none"> • precise grooving thanks to special tooth geometry 	<ul style="list-style-type: none"> • adjustable in steps of 0.1 mm

Product features						Order information		
Ø D [mm]	B [mm]	Ø d [mm]	Z	Cutting quality*		PU [pc.]	L	Order-No.
250	5,0-13	30	30	▲▲▲		1		50459024

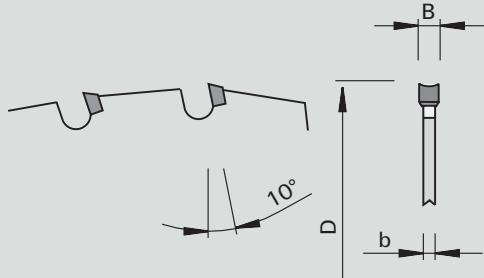
DP**HKS - nn-System DP flex**

Portable Saw Blades DP hollow back tooth

Product



Drawing



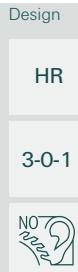
Machine



Application



Design



Notes

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> portable saws clipping saws for precise cutting in all common wood-based panels and ledges for ripping and cross cuts in solid woods suitable for many materials including façade boards 	<ul style="list-style-type: none"> tooth configuration: hollow back tooth "HR" cutting material: DP special cutting edge geometry smallest gullets coated saw blade body 	<ul style="list-style-type: none"> highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping reduced cutting pressure thanks to hollow back tooth geometry the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body 	<ul style="list-style-type: none"> clean your "nn-System DP flex" circular saw blades on a regular basis. you will profit from a long-lasting and precise cutting quality and maximize the edge lives of your innovative saw blades many times over.

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
160	2,2	1.6	20	20	▲▲▲	10	1		58459771
160	2,2	1.8	20	30	▲▲▲	10	1		58459767
190	2,5	2.0	30	36	▲▲▲	10	1	s	58459768
216	2,5	2.0	30	40	▲▲▲	10	1		58459769
230	2,5	2.0	30	60	▲▲▲	10	1	s	58459770

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW	RNK-Matador 5			
Product	Drawing	Machine	Application	Design
				F-WS-WS 3-0-1 HW TC03 LOW
Machine / Application	Design	Advantages	Notes	
<ul style="list-style-type: none"> • Weeke BHX series • CNC machining centers and aggregates • for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics 	<ul style="list-style-type: none"> • tooth configuration: flat - ATB - ATB "F-WS-WS" • cutting material: HW TC03 	<ul style="list-style-type: none"> • excellent cutting quality • especially low noise level • long edge lives also thanks to highly wear-resistant cutting material 		

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
100	4,0	2,8	30	35	▲▲▲		15		1	50806250
100	5,0	4,0	30	35	▲▲▲		15		1	50806252
120	4,0	2,8	20	35	▲▲▲		15		1	50806258
120	5,0	4,0	20	35	▲▲▲		15		1	50806259
120	4,0	2,8	20	35	▲▲▲	3/4,5/35	15		1	50806254
120	5,0	4,0	20	35	▲▲▲	3/4,5/35	15		1	50806255
120	4,0	2,8	35	35	▲▲▲	4/6,3/50	15		1	50806256
120	5,0	4,0	35	35	▲▲▲	4/6,3/50	15		1	50806257
125	4,0	2,8	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	15		1	50806251
125	5,0	4,0	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	15		1	50806253

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

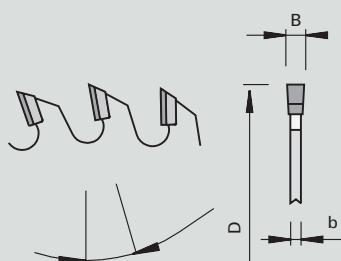
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing RingsFor suitable **clamping elements** for CNC machining see chapter WOOD-BASED PANELS/CNC edge trimming/clamping elements

DP**RNK****Rear Board Grooving Cutter DP**

Product



Drawing



Machine



Application



Design

F

3-0-1



4,0 mm

Notes

Machine / Application

- table shapers
- for grooving of wood-based panels, square particle and MDF boards, raw or laminated, multiplex and plywood boards
- tooth configuration: flat "F"
- cutting material: DP
- resharpening area 4,0 mm

Design

Advantages

Order information

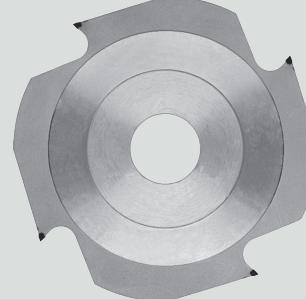
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	DKN [mm]	PU [pc.]	L	Order-No.
100	4,0	2,5	30	12	▲▲	4/5,5/48R + 4/5,5/48L	8		1	s	50750144
125	4,0	2,5	30	12	▲▲	4/5,5/48R + 4/5,5/48L	8		1	s	50750145
160	5,0	4,0	30	8	▲		8	6x3	1	s	50750148
160	8,0	7,0	30	8	▲		8	6x3	1	s	50750149

HW | 1103L Grooving Cutters - for Lamello®

Product	Drawing	Machine	Application	Design
				WS HW TC10
Machine / Application		Notes		
<ul style="list-style-type: none"> machines Lamello®, ELU for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels 		<ul style="list-style-type: none"> tooth configuration: alternate top bevel "WS" cutting material: HW TC10 		<ul style="list-style-type: none"> application against feed with and across the grain

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	NL**	nmin-nmax [min-1]		PU [pc.]	L	Order-No.
100	4,0	3.45	22	6	4/4.5/36	7600-13000	Lamello®	1		50660300
100	3,97	2.8	22	12		7500-13100	Lamello®	1		50110178
102	3,85	3.0	22	12		7500-13100	ELU DS 140	1		50660301

DP | 3013L Grooving Cutters - for Lamello®

Product	Drawing	Machine	Application	Design
				
Machine / Application		Notes		
<ul style="list-style-type: none"> machines Lamello® for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels 		<ul style="list-style-type: none"> reduced resharpening area tooth configuration: concave $n = 7,700 - 13,300 \text{ min}^{-1}$ 		<ul style="list-style-type: none"> application against feed with and across the grain can be used on CNC machines as a grooving cutter

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z				PU [pc.]	L	Order-No.
100	3,95	4.0	22	4				1		50660302

DP

3104L Grooving Cutters DP - for Lamello Clamex P®

Product



Drawing



Machine



Application



Design



0,0 mm

MAN

MEC

Machine / Application

- CNC machining centers
- for chip-free grooving for Lamello Clamex P® joints in solid woods and wood-based panels

Design

- not resharpenable
- tooth configuration: specific
- n max = 15,200 min⁻¹

Advantages

Notes

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

Product features

Order information

$\varnothing D$ [mm]	B [mm]	b [mm]	$\varnothing d$ [mm]	Z			PU [pc.]	L	Order-No.
100.4	7,0	4	30	3		for Lamello Clamex P®	1		50660346 NEW
100.4	7,0	4	22	3		for Lamello Clamex P®	1		50660347 NEW

HW	Matador 5	Sizing Saw Blades HW - flat-ATB-ATB			
Product	Drawing		Machine	Application	Design
					F-WS-WS
					3-0-1
					LOW

Machine / Application

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

Design

- tooth configuration: flat - ATB - ATB "F-WS-WS"
- cutting material: HW TC03

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!!!

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
180	3,0	2.2	30	60	▲▲▲▲	4/6/52	15	1		58808701
200	3,0	2.2	30	65	▲▲▲▲	2/6,2/42 + 4/6/52 + 4/6,6/60	15	1	&	58808702
220	3,0	2.2	30	70	▲▲▲▲	8/6/52	15	1	&	58808712
220	3,0	2.2	40	70	▲▲▲▲	8/6/52	15	1	&	58808703
240	3,0	2.2	30	75	▲▲▲▲	8/6/52	15	1	&	58808704
250	3,0	2.2	30	80	▲▲▲▲	Combi3	15	1		58808706
280	3,0	2.2	30	85	▲▲▲▲	2/6,2/42 + 4/6/52 + 4/6,6/60	15	1	&	58808705
300	3,0	2.2	30	100	▲▲▲▲	Combi3	15	1		58808708
303	3,2	2.2	30	100	▲▲▲▲	Combi3	15	1		58808707
350	3,0	2.2	30	100	▲▲▲▲	Combi3	15	1		58808709
500	3,6	2.8	30	145	▲▲▲▲	Combi3	15	1		58808710
550	4,0	3.2	30	160	▲▲▲▲	Combi3	15	1		58808711

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

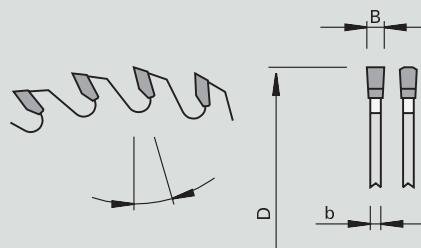
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**TRF****Sizing Saw Blades HW - triple chip / flat**

Product



Drawing



Machine



Application



Design

TR-F
2-0-6
HW TC06

Machine / Application

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

Design

- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW TC06

Advantages

Notes

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

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
120	1,8	1.2	20	40	▲▲	5	1		58104063
160	2,2	1.6	20	48	▲▲	2/7/32	5	1	58110161
160	2,2	1.6	20	56	▲▲▲	2/7/32	5	1	58110142
190	2,2	1.6	30	56	▲▲▲	5	1		58458779
216	3,2	2.2	30	60	▲▲▲	5	1		58458780
220	3,2	2.2	30	64	▲▲▲	2/7/42	5	1	58100399
232	3,2	2.2	30	64	▲▲▲	5	1		58458781
250	3,2	2.2	30	60	▲▲	Combi3	5	1	58100385
250	3,2	2.2	30	80	▲▲▲	Combi3	5	1	58100386
300	3,2	2.2	30	72	▲▲	Combi3	5	1	58100387
300	3,2	2.2	30	96	▲▲▲	Combi3	5	1	58100388
350	3,5	2.5	30	72	▲▲	Combi3	10	1	58100300
350	3,5	2.5	30	108	▲▲▲	Combi3	10	1	58100389

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW	TRF - 1	Sizing Saw Blades HW - triple chip / flat		
Product	Drawing	Machine	Application	Design
				TR-F 3-0-1

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • vertical panel sizing saws • for sizing cuts in plastic-laminated panels 	<ul style="list-style-type: none"> • tooth configuration: triple chip / flat "TR-F" • cutting material: HW TC03 	<ul style="list-style-type: none"> • improved cutting quality thanks to optimized cutting geometry • noise-reduction thanks to laser ornaments 	<ul style="list-style-type: none"> • especially for plastic-laminated wood-based panels and high-pressure laminated boards

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
315	3,2	2.2	30	96	▲▲▲	Combi3	5	1		58803823
300	3,2	2.2	30	96	▲▲▲	Combi3	5	1		58458788
350	3,5	2.5	30	72	▲▲	Combi3	10	1		58807830
350	3,5	2.5	30	108	▲▲▲	Combi3	10	1		58807831

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**3 piece saw blade set in wood box**

Set = main and scoring saw blade HW

Product



Drawing

Machine



Application



Design

TR-F
2-0-6
HW TC06

Machine / Application

- table saws with scoring device
- panel sizing saw blades with scoring device
- for finish cuts in plastic-laminated wood-based panels

Design

- saw blade set consisting of main saw blade and scoring saw blade plus reducing ring
- cutting material: HW TC06

Advantages

- set tools are perfectly matched and guarantee excellent cutting quality for finish cuts
- quick and simple adjustment of scoring saw blade and main saw blade
- long edge lives thanks to special tungsten carbide
- noise-reduction thanks to laser ornaments

Notes

Product features

Order information

									PU [pc.]	L	Order-No.
Circular Saw Blade Set									1		50804303
Accessories	Dimension [mm]								PU [pc.]	L	Order-No.
main saw blade	300x3,2x2,2x30 Z=72 TR-F								1		58100387
scoring saw blade	125x3,35x2,4x22 Z=24 WS								1		50806200
Reducing Rings	22x2,0x20								1		161887

Panels

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP

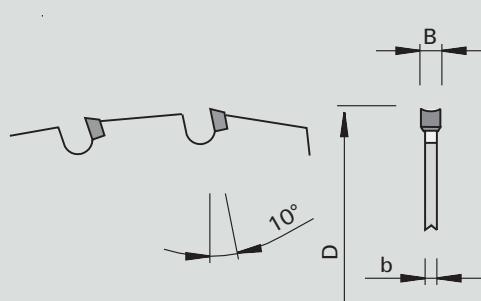
HRP - nn-System DP flex

Sizing Saw Blades DP hollow back tooth

Product



Drawing



Machine

Application

Design



3-0-1



NO noise

Machine / Application

- sizing saws and table saws
- Vertical panel sizing saws
- clipping saws
- for precise cutting in all common wood-based panels
- for ripping and cross cuts in solid woods

Design

- tooth configuration: hollow back tooth "HR"
- cutting material: DP
- resharpenable 2 times
- special cutting edge geometry
- smallest gullets
- coated saw blade body

Advantages

- very agreeable working conditions thanks to hardly perceptible noise
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- reduced cutting pressure thanks to hollow back tooth geometry
- the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body

- Notes
- it is not recommended to use the saw blades for longitudinal cuts in soft wood and material thicknesses of more than 40 mm
 - chip-free cuts can only be guaranteed in combination with a suitable scoring saw blade
 - Attention! for these saw blades the thickness of the splitting wedge must range between 2.0 and 2.4 mm
 - included in delivery: splitting wedge must be ordered separately

Product features

Order information

$\varnothing D$ [mm]	B [mm]	b [mm]	$\varnothing d$ [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
250	2,5	2.0	30	50	▲▲▲	Combi2	10	1	58459455
303	2,5	2.0	30	60	▲▲▲	Combi2	10	1	58459439
350	2,5	2.0	30	72	▲▲▲	Combi2	10	1	58459446

Accessories	Dimension [mm]		PU [pc.]	L	Order-No.
Splitting wedge	2,25	Altendorf F45	1		192425
Splitting wedge	2,25	HOLZ-HER Vertikal	1		192429
Splitting wedge	2,25	Striebig Standard III Control Evolution	1		192430
Splitting wedge	2,25	Striebig Standard Eco	1		192431
Splitting wedge	2,25	Putsch	1		192457
Splitting wedge	2,25	Martin T60A	1		192535
Splitting wedge	2,2	Elcon	1	s	80384841

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

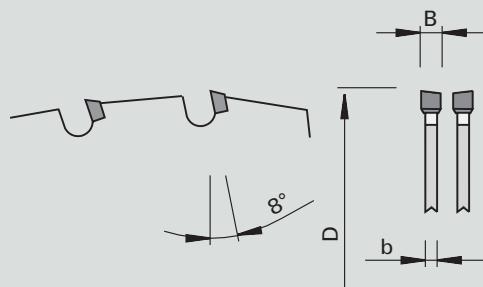
DP**RSK - nn-System DP flex**

Scoring Saw Blades DP - alternate top bevel

Product



Drawing



Machine

Application

Design



WS

3-0-1



Machine / Application

- sizing saws and table saws
- for precise cutting in all common wood-based panels
- for ripping and cross cuts in solid woods

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: DP
- resharpenable 2 times
- special cutting edge geometry
- smallest gullets
- coated saw blade body

Advantages

- very agreeable working conditions thanks to hardly perceptible noise
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body

Notes

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting qual- ity*	Hook angle [°]		PU [pc.]	L	Order-No.
120	2,6	2,0	20	24	▲▲▲▲	8		1		58459419
120	2,6	2,0	22	24	▲▲▲▲	8		1		58459365
125	2,6	2,0	20	24	▲▲▲▲	8		1		58459436

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

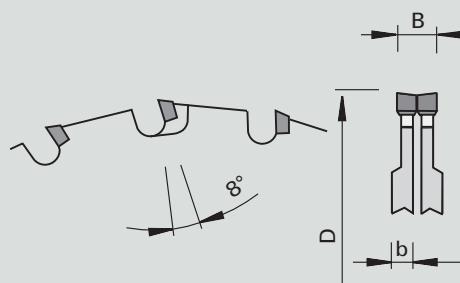
DP

RSK - nn-System DP flex - adjustable

Scoring Saw Blades DP „ES“ - adjustable

Product

Drawing



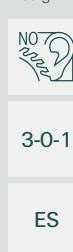
Machine



Application



Design



3-0-1

ES

Machine / Application

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

Design

- tooth configuration: top bevel "ES"
- cutting material: DP
- resharpenable 2 times
- smallest gullets
- coated saw blade body

Advantages

- hardly perceivable noise level
- highest productivity and economic efficiency thanks to extremely long edge lives due to DP-tipping
- the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body

Notes

- Altendorf Rapido / adjustable

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting qual- ity*	Hook angle [°]			PU [pc.]	L	Order-No.
120	2,4-3,2	2,2	50	12+12	▲▲▲	8			1		58459461

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW **RS2**
Scoring Saw Blades HW - adjustable flat tooth

Product	Drawing	Machine	Application	Design
				F 3-0-1 HW TC03

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • panel sizing saws • panel sizing saw blades with controllable scoring device • for scoring of plastic-laminated panels 	<ul style="list-style-type: none"> • tooth configuration: flat "F" • cutting material: HW TC03 	<ul style="list-style-type: none"> • universally applicable 	<ul style="list-style-type: none"> • split version - cutting width adjustable with spacers

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting qual- ity*	Hook angle [°]		PU [pc.]	L	Order-No.
70	2,8-3,6	2.2	20	2x8	▲▲▲▲	12		1	o	50445100
80	2,8-3,6	2.2	20	2x10	▲▲▲▲	12		1		58802435
100	2,8-3,6	2.2	20	2x10	▲▲▲▲	12		1		58110190
100	2,8-3,6	2.2	22	2x10	▲▲▲▲	12		1		58110188
105	2,8-3,6	2.2	20	2x10	▲▲▲▲	12		1		58110171
120	2,8-3,6	2.2	20	2x12	▲▲▲▲	12		1		58110186
120	2,8-3,6	2.2	22	2x12	▲▲▲▲	12		1		58110187
125	2,8-3,6	2.2	20	2x12	▲▲▲▲	12		1		58110206
125	2,8-3,6	2.2	22	2x12	▲▲▲▲	12		1		58110204

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut
** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW	RSVS	Scoring Saw Blades HW - adjustable alternate bevel tooth								
Product	Drawing		Machine	Application	Design					
						WS	ES	3-0-1		
						HW	TC03			
Machine / Application	Design	Advantages		Notes						
<ul style="list-style-type: none"> • table saws • panel sizing saws • panel sizing saw blades with controllable scoring device • for scoring of plastic-laminated panels 	<ul style="list-style-type: none"> • tooth configuration: up to Ø 140 mm alternate top bevel "WS" • tooth configuration: up to Ø 160 mm top bevel "ES" • cutting material: HW TC03 	<ul style="list-style-type: none"> • low motor output thanks to tooth configuration "WS" 		<ul style="list-style-type: none"> • split version - cutting width adjustable with spacers 						
Product features			Order information							
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting qual- ity*	Hook angle [°]		PU [pc.]	L	Order-No.
120	2,8-3,8	2.2	50	2x12	▲▲▲▲	12	Altendorf, Martin	1		50807902
120	2,8-3,8	2.2	22	2x12	▲▲▲▲	12	Martin NC adjustment unit	1		50807854
140	2,8-3,8	2.0	36	2x12	▲▲▲▲	12	Martin T75 PreX	1		50807909
160	2,8-3,6	2.2	20	2x16	▲▲▲▲	12	CSM	1	o	58807910
Spare parts	Dimension [mm]						PU [pc.]	L	Order-No.	
Countersunk Screws - with Torx	M5x6,8 T15				mounting screw for interior flange		10			180839
Countersunk Screws - with Torx	M5x10,8 T15				mounting screw for exterior flange		10			180840

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP

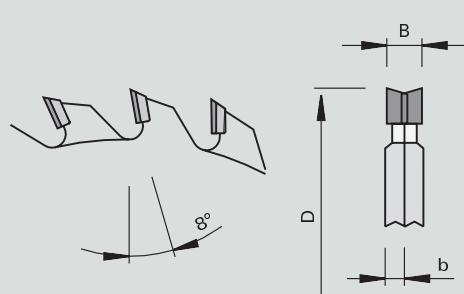
RSVS

Scoring Saw Blades DP - adjustable alternate bevel

Product



Drawing



Machine



Application



Design

WS

3-0-1

4,5 mm

Notes

- split version - cutting width adjustable with spacers application with feed

Machine / Application

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

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: DP
- resharpening area 4,5 mm

Advantages

Notes

- split version - cutting width adjustable with spacers application with feed

Product features

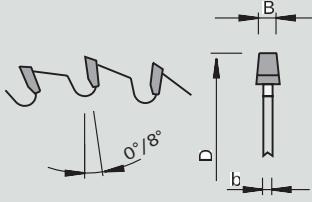
Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]					PU [pcc.]	L	Order-No.
120	2,8- 3,8	2,2	22	2x12	▲▲▲▲	2/3,8/42	8	Altendorf, Martin				1		50750102
120	2,8- 3,8	2,2	50	2x12	▲▲▲▲	4/6,2/62	8	Altendorf adjustment unit				1	o	50750105

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	RSK - nn-System	Scoring Saw Blades HW - conical-flat - nn-System	Machine	Application	Design
Product	Drawing				
					
KO-F	3-0-1	HW TC03			
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> • table saws • for scoring of plastic-laminated panels 	<ul style="list-style-type: none"> • special NoNoise gullet geometry • tooth configuration: conical-flat "KO-F" • cutting material: HW TC03 	<ul style="list-style-type: none"> • quick adjustment • universally applicable • optimum cutting quality thanks to improved runout accuracy • reduction of the scoring depth • especially low noise level • noise reduction by approx. 6 dB(A) when idling • excellent cutting quality in all common coatings • long edge lives provide for the necessary productivity and economic efficiency 	<ul style="list-style-type: none"> • height adjustable to kerf of main saw blade • 1 mm scoring depth = .0.21 mm wider than main saw kerf • optimum scoring depth 1.0 - 2.0 mm 		

Product features										Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]				PU [pc.]	L	Order-No.
100	3,2- 4,0	2,5	20	20	▲▲▲▲	8	Schelling			1		58807950
120	3,2- 4,0	2,5	20	24	▲▲▲▲	8	Altendorf, SCM			1		58807951
120	3,2- 4,0	2,5	22	24	▲▲▲▲	8	Altendorf, Martin			1		58807952
125	3,1- 4,0	2,5	20	24	▲▲▲▲	8	Panhans, Paolini			1		58807953
125	4,45- 5,25	3,2	45	24	▲▲▲▲	0	Martin, Homag, Giben, Mayer			1	s	58803761

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP

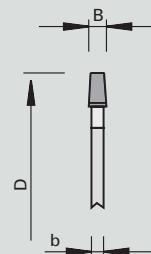
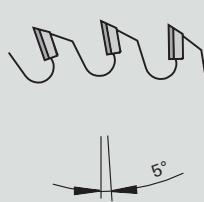
RSK

Scoring Saw Blades DP - conical-flat

Product



Drawing



Machine



Application



Design

KO-F

3-0-1

4,5 mm

Machine / Application

- table saws
- for scoring of laminated panels

Design

- diamond cutting edges with polished design
- tooth configuration: conical-flat "KO-F"
- cutting material: DP
- resharpening area 4,5 mm

Advantages

- short delivery times

Notes

- application with feed

Product features

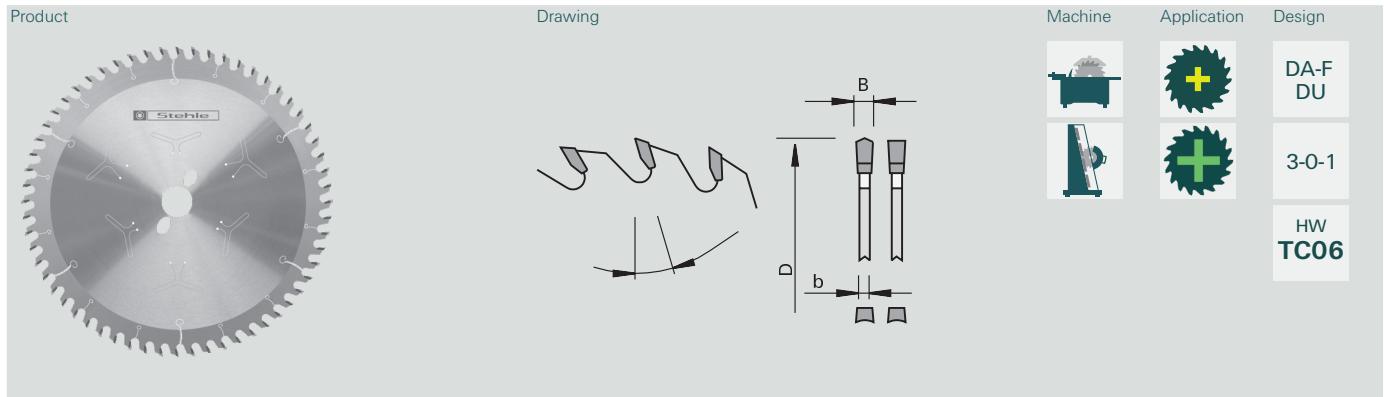
Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]				PU [pc.]	L o	Order-No.
120	3,1- 3,9	2,5	22	16	▲▲▲▲	5	Altendorf, Martin			1	o	58750101

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**KDF - Industry****Sizing Saw Blades HW - inverted-v / flat tooth / hollow-ground tooth**

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • vertical panel sizing saws • for sizing cuts in raw and laminated panels 	<ul style="list-style-type: none"> • vibration and noise damping ornaments • additional expansion slots • tooth configuration: inverted-v / flat tooth / hollow-ground tooth "DA-F DU" • cutting material: HW TC06 	<ul style="list-style-type: none"> • extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations • good quality of bottom edge even without scoring saw blade • excellent cutting quality 	

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
220	3,2	2.2	30	42	▲▲	2/7/42	10	1		58804281
250	3,2	2.2	30	48	▲▲	Combi3	10	1		58804351
303	3,2	2.2	30	60	▲▲▲▲	Combi3	10	1		58804353
350	3,5	2.5	30	72	▲▲▲▲	Combi3	10	1		58804280

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

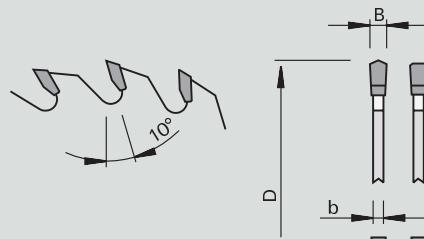
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**KDF - Industry Plus****Sizing Saw Blades HW - inverted-v / flat tooth with chamfer / hollow-ground tooth**

Product



Drawing



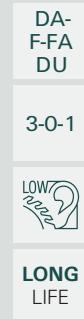
Machine



Application



Design



Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in raw and laminated panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: inverted-v / flat tooth with chamfer / hollow-ground tooth "DA-F-FA DU"
- cutting material: HW TC06

Advantages

- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- good quality of bottom edge even without scoring saw blade
- reduced cutting pressure
- increased edge life
- improved cutting quality

Notes

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
303	3,2	2.2	30	60	▲▲▲▲	Combi3	10	1		58804301

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**KDF - Industry - negative**

Sizing Saw Blades HW - inverted-v / flat tooth / hollow-ground tooth

Product	Drawing	Machine	Application	Design

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> clipping and miter saws table saws vertical panel sizing saws for sizing cuts in plastic and solid wood profile ledges 	<ul style="list-style-type: none"> vibration and noise damping ornaments additional expansion slots tooth configuration: inverted-v / flat tooth / hollow-ground tooth "DA-F DU" cutting material: HW TC06 	<ul style="list-style-type: none"> extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations good quality of bottom edge even without scoring saw blade excellent cutting quality 	

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
250	3,2	2.2	30	48	▲▲▲	Combi3	-5	1		58804352
303	3,2	2.2	30	60	▲▲▲▲	Combi3	-5	1		58804279

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

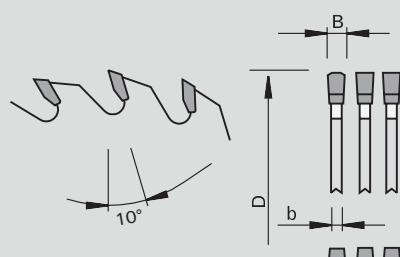
HW**KDF - Industry Professionell**

Sizing Saw Blades HW -triple chip / flat - flat / hollow-ground tooth

Product



Drawing



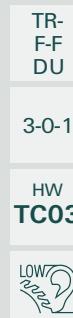
Machine



Application



Design



Machine / Application

- table saws
- vertical panel sizing saws
- for sizing cuts in raw and laminated panels

Design

- vibration and noise damping ornaments
- additional expansion slots
- tooth configuration: triple chip / flat - flat / hollow-ground tooth "TR-F-F DU"
- cutting material: HW TC03

Advantages

- extremely low-noise and smooth running thanks to vibration and noise damping ornaments as well as special expansion slot combinations
- good quality of bottom edge even without scoring saw blade
- optimum cutting quality thanks to innovative tooth group configuration

Notes

Product features

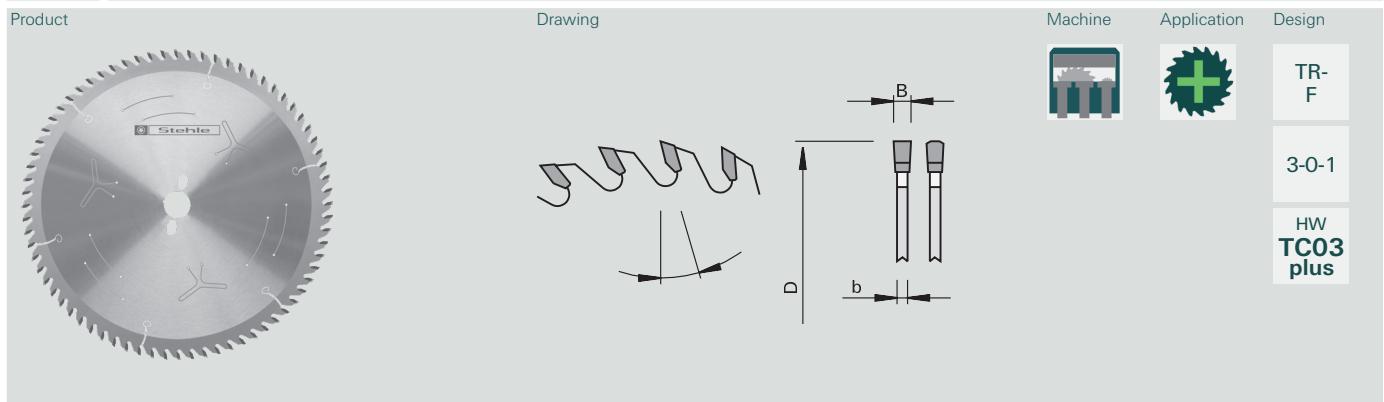
Order information

$\varnothing D$ [mm]	B [mm]	b [mm]	$\varnothing d$ [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
303	3,2	2.2	30	60	▲▲▲▲	Combi3	10	1	#	58804356
303	3,5	2.5	30	60	▲▲▲▲	Combi3	10	1		58804282

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**TFP****Panel Sizing Saw Blades HW - triple-chip - flat**

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • panel sizing saws • for sizing cuts in plastic-laminated panels 	<ul style="list-style-type: none"> • tooth configuration: triple chip / flat "TR-F" • cutting material: HW TC03Plus 	<ul style="list-style-type: none"> • improved cutting quality thanks to optimized cutting geometry • noise-reduction thanks to laser ornaments 	<ul style="list-style-type: none"> • specifically for plastic-laminated panels and plywood in single sheets and stacks

Product features											Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]				PU [pc.]	L	Order-No.
300	4,4	3.0	30	60	▲▲▲	Combi3	10		Panhans		1		58806053
350	4,4	3.0	30	72	▲▲▲	Combi3	10		SCM, Panhans, Mayer, Schelling, HOLZ-HER		1		58807803
350	4,4	3.2	60	72	▲▲▲	2/ 14/ 100	10		Holzma 72 HPP 350		1		58807955
355	4,4	3.0	75	72	▲▲▲	4/15/105	10		Gibben		1		58807888
380	4,8	3.5	60	72	▲▲▲	2/14/100 + 15 2/14/125			Holzma		1		58806065
400	4,4	3.2	30	72	▲▲▲	Combi3	15		Schelling, Mayer, Irion, Scheer, HOLZ-HER		1		58806069
400	4,4	3.2	75	72	▲▲▲	4/15/105	15		Giben, Homag		1		58806071
400	4,4	3.2	80	72	▲▲▲	4/8,5/100 + 15 2/14/110 + 2/7/110			Selco, Irion		1		58807809
420	4,8	3.5	60	72	▲▲▲	2/14/125 + 15 2/19/120			Holzma		1		58807956
430	4,4	3.2	80	72	▲▲▲	4/19/120 + 15 2/8,4/130			Selco		1		58806479
450	4,4	3.2	30	72	▲▲	Combi3	15		Irion, Schelling		1		58458789
450	4,8	3.5	60	72	▲▲▲	2/14/125 + 15 2/19/120			Holzma		1		58807817

Panels

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

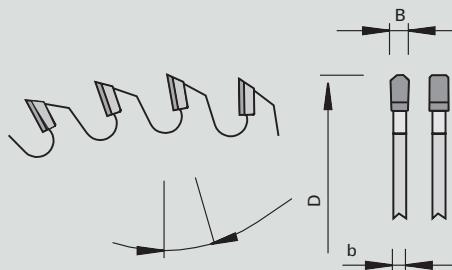
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP**TFP****Panel Sizing Saw Blades DP - triple chip / flat with two-sided chamfer**

Product



Drawing



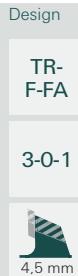
Machine



Application



Design



Notes

Machine / Application

- panel sizing saws
- for stack and finish cuts in raw and plastic-laminated panels
- focus on universal application

Design

- vibration and noise damping ornaments
- diamond cutting edges with polished design
- optimized cutting geometry depending on the respective tooth form for main and scoring saw blades
- tooth configuration: triple chip / flat with two-sided chamfer "TR-F-FA"
- cutting material: DP
- resharpening area 4,5 mm

Advantages

- short delivery times

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]				PU [pc.]	L	Order-No.
320	4,4	3.2	65	60	▲▲▲	2/9/110	10				1	o	50750120
350	4,4	3.2	30	72	▲▲▲	2/10/60	10		SCM, Panhans, Mayer, Schelling, Scheer		1	o	50750128
350	4,4	3.0	30	72	▲▲▲	Combi2	10		SCM, Panhans, Mayer, Schelling, Scheer		1	o	50750129
380	4,4	3.2	60	72	▲▲▲	2/14/100 + 2/14/125	10		Holzma		1	o	50750130
380	4,8	3.5	60	72	▲▲▲	2/14/100 + 2/14/125	10		Holzma		1	o	50750131
400	4,4	3.2	30	72	▲▲▲		15		Schelling, Mayer, Scheer, Irion		1	o	50750132
400	4,4	3.2	75	72	▲▲▲	4/15/105 + 2/7/110	15		Giben, Homag		1	o	50750133
400	4,4	3.2	80	72	▲▲▲	2/7/110 + 4/19/120 + 2/8,4/130	15		Schelling, Mayer, Scheer, Irion		1	o	50750134
420	4,8	3.5	60	60	▲▲	2/10/80 + 2/14/125	15		Holzma		1	o	50750135
450	4,8	3.5	60	72	▲▲▲	2/19/120 + 2/14/125	15		Holzma		1	o	50750136
450	4,8	3.5	80	72	▲▲▲	4/19/120 + 2/8,4/130	15		Selco		1	o	50750137
450	4,4	3.2	30	72	▲▲▲		15		Selco		1	o	50750138
460	4,4	3.2	30	72	▲▲▲	3/13/94	15		Schelling		1	o	50750146
480	4,8	3.5	30	72	▲▲▲		15		Schelling		1	o	50750139
480	4,8	3.5	60	72	▲▲▲	2/19/120	15		Holzma		1	o	50750140

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW RSK - nn-System**Scoring Saw Blades HW - conical-flat - nn-System**

Product	Drawing	Machine	Application	Design
				KO-F 3-0-1

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> Panel Sizing Saw Blades with scoring device for scoring of plastic-laminated panels 	<ul style="list-style-type: none"> special NoNoise gullet geometry tooth configuration: conical-flat "KO-F" cutting material: HW TCO3 	<ul style="list-style-type: none"> quick adjustment universally applicable optimum cutting quality thanks to improved runout accuracy reduction of the scoring depth especially low noise level noise reduction by approx. 6 dB(A) when idling excellent cutting quality in all common coatings long edge lives provide for the necessary productivity and economic efficiency 	<ul style="list-style-type: none"> height adjustable to kerf of main saw blade 1 mm scoring depth = 0.21 mm wider than main saw kerf optimum scoring depth 1.0 - 2.0 mm

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]				PU [pc.]	Order-No.
160	4,4- 5,2	3.2	55	36	▲▲▲▲	3/7/66	8		Gabbiani		1	58803072
180	4,4- 5,2	3.2	30	30	▲▲▲▲	2/10/60	8		Panhans		1	58807858
180	4,4- 5,2	3.2	45	36	▲▲▲▲		8		Holzma		1	58803104
180	4,85- 5,65	3.5	45	36	▲▲▲▲		8		Holzma		1	58807862
200	4,4- 5,2	3.5	20	36	▲▲▲▲		8		Schelling		1	58803073
200	4,4- 5,2	3.5	45	36	▲▲▲▲		8		Homag		1	58803074
200	4,85- 5,65	3.5	45	36	▲▲▲▲		8		Homag		1	58806134
200	4,45- 5,25	3.2	65	36	▲▲▲▲	2/9/100 + 2/9/110	8		Selco		1	58806130

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

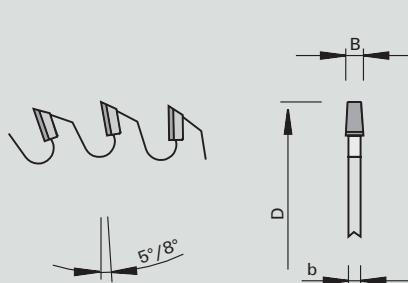
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

DP**RSK****Scoring Saw Blades DP - conical-flat**

Product



Drawing



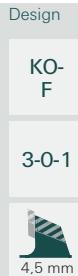
Machine



Application



Design



Machine / Application

- panel sizing saw blades with scoring device
- for scoring of laminated panels

Design

- diamond cutting edges with polished design
- tooth configuration: conical-flat "KO-F"
- cutting material: DP
- resharpening area 4.5 mm

Advantages

- short delivery times

Notes

- application with feed

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]					PU [pc.]	L	Order-No.
160	4,4- 5,2	3.2	45	30	▲▲▲▲	3/11/70	5			Giben		1	o	50750121
180	4,4- 5,2	3.2	30	30	▲▲▲▲	2/10/60	5			Panhans		1	o	50750122
180	4,4- 5,2	3.2	45	30	▲▲▲▲		5			Holzma		1	o	50750123
180	4,8- 5,6	3.5	45	30	▲▲▲▲		5			Holzma		1	o	50750124
200	4,4- 5,2	3.2	20	30	▲▲▲▲		5			Schelling		1	o	50750125
200	4,4- 5,2	3.2	20	36	▲▲▲▲		8			Schelling		1	o	50750147
200	4,8- 5,6	3.5	65	30	▲▲▲▲	2/8,4/110	5			Selco		1	o	50750126
200	4,8- 5,6	3.5	45	30	▲▲▲▲		5			Holzma		1	o	50750127

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW	KKO	Chop Saw Blades HW for edge trimming without countersink - alternate top bevel										
Product	Drawing	Machine	Application	Design								
				WS								
				3-0-1								
				HW TC06								
				No noise								
Machine / Application		Design	Advantages				Notes					
<ul style="list-style-type: none"> edge banders edge trimming machines for trimming of plastic-, veneer- and solid wood edges 		<ul style="list-style-type: none"> special NoNoise gullet geometry positive or negative hook angle with or without shear angle tooth configuration: alternate top bevel "WS" cutting material: HW TC06 	<ul style="list-style-type: none"> especially low noise level noise reduction by approx. 6 dB(A) when idling 									
Product features												
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner [°]	Shear [°]	PU [pc.]	L	Order-No.
90	3,0	2,0	30	20	▲▲		8	10	0	Reich		58808800
100	2,4	1,6	22	12	▲		15	10	5	HOLZ-HER		58808801
100	2,4	1,6	22	20	▲▲	2/4/30	-8	10	5	EBM		58808802
100	3,2	2,2	22	20	▲▲▲		8	15	0	Felder, Lohmeyer		58808836
100	2,6	1,6	32	30	▲▲		10	15	5	Brandt		58808804
110	3,6	2,5	22	20	▲▲		8	30	5	Reich		58808805
110	3,6	2,5	32	20	▲▲		8	30	5	Homag		58808806
120	3,2	2,2	32	20	▲▲		10	10	5	Homag		58808808
125	2,4	1,6	32	24	▲▲		15	30	0	Brandt		58808835
140	3,2	2,2	16	36	▲▲▲		10	15	5	Ott		58808809
140	3,2	2,2	22	36	▲▲▲		10	15	5	HOLZ-HER		58808810
150	3,2	2,2	22	48	▲▲▲		10	10	5	IMA		58808811
160	3,0	2,5	22	36	▲▲▲		-5	15	5	IMA		58808843
160	3,5	2,5	22	36	▲▲▲		-5	15	5	IMA		58808813 NEW
160	3,2	2,2	20	48	▲▲▲	2/5/32	10	10	5	HOLZ-HER		58808812
160	3,2	2,2	22	48	▲▲▲		-8	10	5	IMA		58808814
160	3,2	2,2	30	24	▲▲	2/7/42	15	10	5	HOLZ-HER		58808815
160	3,2	2,2	40	30	▲▲	4/5,5/52	-8	20	10	HOLZ-HER		58808816
170	3,2	2,2	30	36	▲▲▲	4/5,5/52	10	20	0	Homag		58808817
200	3,2	2,2	30	64	▲▲▲	4/6,6/60 + 2/6,2/42	10	15	0	IMA		58808818

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

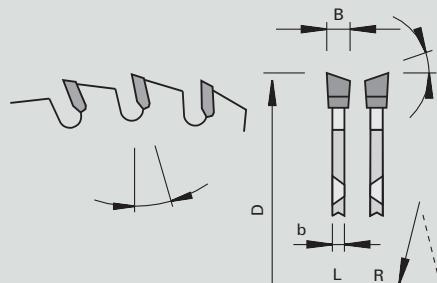
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**KKM****Chop Saw Blades HW for edge trimming with countersink - alternate top bevel**

Product



Drawing



Machine



Application



Design



WS

3-0-1

HW
TC06

Notes

- Δ = no countersink
- sense of rotation according to DIN-EN 50144

Machine / Application

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

Design

- special NoNoise gullet geometry
- positive hook angle
- with or without shear angle
- pin holes with countersink
- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC06

Advantages

- especially low noise level
- noise reduction by approx. 6 dB(A) when idling

Product features

Order information

\varnothing D [mm]	B [mm]	b [mm]	\varnothing d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner [°]	Shear [°]	L/R	PU [pc.]	L	Order-No.
110	3,2	2,5	40	20	▲▲▲	4/5,5/52	10	45	5	Homag	N	1	58808837
110	3,2	2,5	40	20	▲▲▲	4/5,5/52	10	30	5	Homag	R	1	58808838
120	3,2	2,5	40	36	▲▲▲	2x4/5,5/52	10	45	5	Homag	N	1	58808839
120	3,6	2,8	40	24	▲▲	2x4/6/52	8	30	0	Homag	N	1	58808819
125	2,4	1,6	30	36	▲▲▲	2x4/6,5/48	10	30	0	Homag BAZ	N	1	58808820
140	3,2	2,2	30	36	▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800	L	1	58808821
140	3,2	2,2	30	36	▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800	R	1	58808822
150	3,2	2,2	30	48	▲▲▲	4/6/48 + Δ 4/5,5/52	10	15	0	Homag BAZ	R	1	58808823
180	3,2	2,2	30	54	▲▲▲	4/6/52	10	30	5	Homag BAZ	L	1	58808824
150	3,6	2,8	40	30	▲▲▲	4/6/52	8	30	0	Biesse Akron 600/800	N	1	58808840
240	3,5	2,2	40	54	▲▲▲▲	8/6,1/52	10	20	0	Homag BAZ Flex 5, Weeke	L	1	s 58808826

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	KKE	Chop Saw Blades HW for edge trimming without countersink - top bevel		
Product	Drawing	Machine	Application	Design
				ES
				3-0-1
				HW TC06
				NO noise

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> edge banders edge trimming machines for trimming of thin plastic-, veneer- and solid wood edges 	<ul style="list-style-type: none"> special NoNoise gullet geometry positive or negative hook angle with and without shear angle tooth configuration: top bevel "ES (right + left)" cutting material: HW TC06 	<ul style="list-style-type: none"> especially low noise level noise reduction by approx. 6 dB(A) when idling 	<ul style="list-style-type: none"> sense of rotation see drawing

Product features												Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner [°]	Shear [°]	L/R	PU [pc.]	L	Order-No.	
100	2,6	2.0	32	30	▲▲		-10	15	0	Brandt	L	1	58808829	
100	2,6	2.0	32	30	▲▲		-10	15	0	Brandt	R	1	58808830	
100	2,6	2.0	32	30	▲▲		10	15	0	Homag CN	R	1	58808841	
100	2,6	2.0	32	30	▲▲		10	15	0	Homag CN	L	1	58808842	
100	2,6	1.6	32	30	▲▲		10	10	0	Brandt	L	1	58808831	
100	2,6	1.6	32	30	▲▲		10	10	0	Brandt	R	1	58808832	
150	3,5	2.2	30	44	▲▲▲	4/5,5/52	-12	45	10	Homag Powerline	L	1	58808833	
150	3,5	2.2	30	44	▲▲▲	4/5,5/52	-12	45	10	Homag Powerline	R	1	58808834	

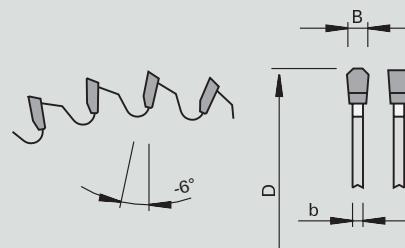
HW**Parat - negative (HKS)**

Universal Saw Blade HW - negative hook angle triple chip / flat

Product



Drawing



Machine



Application



Design

TR-F
1-0-1
HW TC10

Machine / Application

- clipping and miter saws
- portable saws
- for many applications and materials (wood-based panels and NF-materials)

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW TC10

Advantages

- negative hook angle for high cutting quality and safe handling

Notes

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.
100	2,8	2,2	20	30	▲▲	2/6/32,5	-6	1	o 58115037
130	2,8	2,2	20	36	▲▲	2/6/32,5	-6	1	o 58115027
150	2,8	2,2	20	42	▲▲	2/6/32,5	-6	1	58115002
160	2,2	1,6	20	42	▲▲	2/6/32,5	-6	1	58115004
160	2,2	1,6	20	56	▲▲▲	2/6/32,5	-6	1	58115042
160	2,8	2,2	30	42	▲▲	2/7/42	-6	1	58115026
165	2,4	1,6	20	48	▲▲	2/6/32,5	-6	1	o 58115044
180	2,8	2,2	20	48	▲▲	2/6/32,5	-6	1	58115007
180	2,8	2,2	30	48	▲▲	2/7/42	-6	1	58115008
190	2,8	2,2	20	54	▲▲	2/6/32,5	-6	1	58115009
190	2,6	2,0	20FX	58	▲▲	Fast-Fix	-6	1	o 58115033
190	2,8	2,2	30	54	▲▲	2/7/42	-6	1	58115010
200	2,8	2,2	30	54	▲▲	2/7/42	-6	1	58115011
210	2,8	2,2	30	54	▲▲	2/7/42	-6	1	58115012
216	2,8	2,2	30	60	▲▲	2/7/42	-6	1	58115024
216	2,8	2,2	30	80	▲▲▲	2/7/42	-6	1	58115034
220	2,8	2,2	30	54	▲▲	2/7/42	-6	1	58115021
225	2,8	2,2	30	60	▲▲	Combi3	-6	1	58115039
230	2,8	2,2	30	64	▲▲	2/7/42	-6	1	58115014

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**NF - positive****NF-Chop Saw Blades HW - positive hook angle triple chip / flat**

Product	Drawing	Machine	Application	Design
				TR-F 3-0-1 2-0-6

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • clipping and miter saws • for dividing and miter cuts in aluminum and plastic profiles, aluminum sheets on machines with workpiece clamping as well as wood-based panels (Corian, Noblan, Varicor and HPL) 	<ul style="list-style-type: none"> • positive hook angle • tooth configuration: triple chip / flat "TR-F" • quality 3-0-1 from Ø 400 upwards • cutting material: HW TCm10 from Ø 400 TC06 	<ul style="list-style-type: none"> • noise-reduction thanks to laser ornaments 	<ul style="list-style-type: none"> • tight workpiece clamping required

Product features										Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting qual- ity*	NL**	Hook angle [°]	Cutting mate- rial	PU [pc.]	L	Order-No.	
250	3,2	2,5	30	80	▲▲	Combi3	5	TC10	1		58808102	
300	3,2	2,5	30	72	▲▲	Combi3	5	TC10	1		58808104	
300	3,2	2,5	30	96	▲▲▲	Combi3	5	TC10	1		58808107	
300	3,2	2,5	32	96	▲▲▲	4/12/64 + Combi3	5	TC10	1	o	58808125	
350	3,2	2,5	30	108	▲▲▲	Combi3	5	TC10	1		58808111	
400	3,8	3,2	30	96	▲▲	Combi3	5	TC06	1		58808113	
420	3,8	3,2	30	96	▲▲	Combi3	5	TC06	1		58808115	
450	3,8	3,2	40	108	▲▲▲	4/12/64 + 2/10/60	5	TC06	1		58808117	
500	4,0	3,4	30	120	▲▲▲	4/12/64 + 2/10/60	5	TC06	1		58808118	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

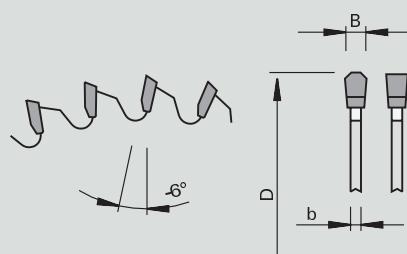
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**NF - negative****NF-Chop Saw Blades HW - negative hook angle triple chip / flat**

Product



Drawing



Machine



Application



Design

TR-F

3-0-1

2-0-6

Machine / Application

- clipping and miter saws
- for clipping and miter cuts in aluminum and plastic profiles

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- quality 3-0-1 from Ø 400 upwards
- cutting material: HW TCm10 from Ø 400 TC06

Advantages

- noise-reduction thanks to laser ornaments

Notes

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
235	2,8	2,2	30	64	▲▲	2/7/42	-6	1		58115018
250	3,2	2,5	30	60	▲▲	Combi3	-6	1		58808201
250	2,8	2,2	30	80	▲▲▲	Combi3	-6	1		58808200
250	3,2	2,5	30	80	▲▲▲	Combi3	-6	1		58808203
250	3,2	2,5	32	60	▲▲	Combi3	-6	1	o	58808202
250	3,2	2,5	32	80	▲▲▲	Combi3	-6	1	o	58808204
250	3,2	2,5	40	80	▲▲▲	4/12/64 + 2/9/55 + Combi3	-6	1	o	58808205
254	3,2	2,5	30	80	▲▲▲	Combi3	-6	1	o	58808246
260	3,2	2,5	30	72	▲▲	Combi3	-6	1		58808206
300	3,2	2,5	30	72	▲▲	Combi3	-6	1		58808209
300	3,2	2,5	30	84	▲▲▲	Combi3	-6	1	o	58808244
300	2,8	2,2	30	96	▲▲▲	Combi3	-6	1		58808213
300	3,2	2,5	30	96	▲▲▲	Combi3	-6	1		58808214
300	3,2	2,5	32	96	▲▲▲	4/12/64	-6	1		58808215
300	3,3	2,5	40	96	▲▲▲	4/12/64 + 2/9/55	-6	1		58808216
305	3,2	2,5	30	96	▲▲▲	Combi3	-6	1		58808245
305	3,2	2,5	30	60	▲▲	Combi3	-6	1		58808241
330	3,2	2,5	30	96	▲▲▲	Combi3	-6	1		58808217
330	3,2	2,5	32	96	▲▲▲	Combi3	-6	1	o	58808218
350	3,2	2,5	30	90	▲▲	Combi3	-6	1		58808222
350	3,2	2,5	30	108	▲▲▲	Combi3	-6	1		58808225
350	3,2	2,5	32	108	▲▲▲	4/12/64	-6	1		58808226
350	3,2	2,5	40	108	▲▲	4/12/64 + 2/9/55	-6	1	o	58808227
380	3,8	3,2	32	110	▲▲▲	4/12/64	-6	1		58808243
400	3,8	3,2	30	96	▲▲	Combi3	-6	1		58808232
420	4,0	3,2	30	96	▲▲	Combi3	-6	1		58808234
420	3,8	3,2	40	100	▲▲▲	4/12/64 + 2/9/55	-6	1		58808236
450	3,8	3,2	30	96	▲▲	4/12/64 + 2/12/80 + Combi3	-6	1		58808235
500	4,0	3,4	30	120	▲▲▲	4/12/64 + 2/10/60	-6	1		58808239

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	NE-Chop - Profiles "G7"			
Product	Drawing	Machine	Application	Design
				G7
				3-0-1
				HW TC06
				LOW NOISE

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> clipping and miter saws table saws clipping and miter cuts in PVC profiles for burr-free and smooth cuts in aluminum window and façade profiles 	<ul style="list-style-type: none"> positive or negative hook angle tooth configuration: "G7" cutting material: HW TC06 	<ul style="list-style-type: none"> reduced cutting pressure thanks to group tooth geometry excellent cuts with low roughness thanks to tooth partition extremely noise-reduced thanks to special laser ornaments increased edge life compared to chop saw blades with tooth configuration "TR-F" increased performance and economic efficiency 	<ul style="list-style-type: none"> secure workpiece clamping required max. wall thickness 5 mm

Product features										Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL	Hook angle [°]			PU [pc.]	L	Order-No.
250	3,2	2.5	30	84	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6			1		192965 NEW
300	3,2	2.5	30	98	▲▲▲▲	2/11/70	-6			1		192568
350	3,2	2.5	30	112	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6			1		192275
350	3,5	2.8	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6		DeWALT, Haffner, Pfeiffer, Rotox	1		192274
350	3,8	3.2	40	84	▲▲▲▲	4/12/64 + 2/9/55	-6		Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann	1		192273
380	3,8	3.2	32	112	▲▲▲▲		-6		Elumatec	1		192567
400	3,8	3.2	30	98	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6		DeWALT, Haffner	1		192276
420	4,0	3.2	30	98	▲▲▲▲	2/10/60 + 2/11/70	-6		Rapid, ELU	1		192277
450	3,8	3.2	30	112	▲▲▲▲	2/12/64 + 4/15/80	-6		DeWALT, Haffner	1		192278
500	4,0	3.4	30	126	▲▲▲▲	2/11/70	-6		Pfeiffer, Rapid	1		192279
550	4,0	3.4	30	133	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6		Pfeiffer, Rapid	1		192392

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

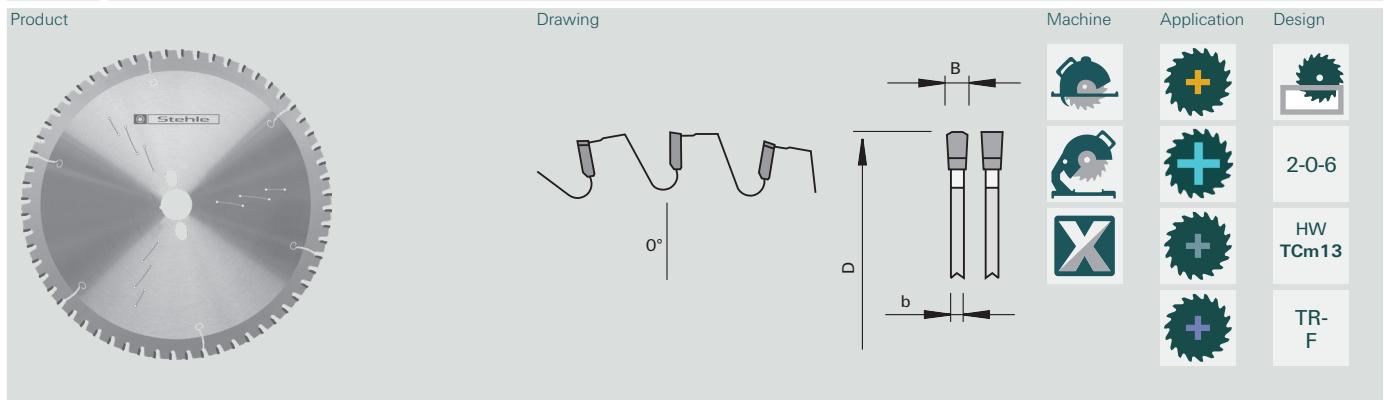
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

Product features											Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL	Hook angle [°]				PU [pc.]	L	Order-No.
300	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70	5				1		192663
350	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60	5				1		192662
400	3,8	3,2	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64	5				1		192659
420	3,8	3,2	30	98	▲▲▲▲		5				1		192660
500	4,0	3,4	30	126	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64	5				1		192661

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW**Unisteel (HKS)****NF-Chop Saw Blades HW - neutral hook angle triple chip / flat**

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> clipping and miter saws for dividing and miter cuts in metals and NF-metals (zinc) plates, cast iron, etc. 	<ul style="list-style-type: none"> tooth configuration: triple chip / flat "TR-F" cutting material: HW TCm13 	<ul style="list-style-type: none"> improved cutting quality thanks to special cutting geometry 	<ul style="list-style-type: none"> for wood-based panels and plastics see ZWS and Parat - negative (HKS) reduced edge lives in the case of stainless steel

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Order information		
								PU [pc.]	L	Order-No.
150	2,2	1.6	20	30	▲▲	2/6/32,5	0	1		58116502
160	2,2	1.6	20	30	▲▲	2/6/32,5	0	1		58116504
180	2,2	1.6	20	36	▲▲	2/6/32,5	0	1		58116507
180	2,2	1.6	30	36	▲▲	2/7/42	0	1		58116508
190	2,4	1.8	20	38	▲▲	2/6/32,5	0	1		58116509
190	2,4	1.8	30	38	▲▲	Combi3	0	1		58116510
200	2,4	1.8	30	40	▲▲	2/7/42	0	1		58116511
210	2,4	1.8	30	40	▲▲	2/7/42	0	1		58116512
216	2,4	1.8	30	40	▲▲	2/7/42	0	1		58116520
230	2,4	1.8	30	44	▲▲	2/7/42	0	1		58116514
235	2,4	1.8	30	44	▲▲	2/7/42	0	1		58116521
240	2,4	1.8	30	44	▲▲	Combi3	0	1		58116515

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW**HKS - Unisteel for cordless machines**

Portable Saw Blades HW - triple chip / flat

Product	Drawing	Machine	Application	Design
				2-0-6

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • cordless portable saws • for dividing cuts in metals and NF-metals (zinc) plates, cast iron, etc. 	<ul style="list-style-type: none"> • tooth configuration: triple chip with flat tooth "TR-F" • cutting material: HW TCm13 	<ul style="list-style-type: none"> • low power consumption thanks to reduced kerf 	

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]	PU [pc.]	L	Order-No.	
136	1,5	1.2	20	36	▲▲	Dewalt	0	1	58116400	
165	1,5	1.2	20	40	▲▲	Makita, Dewalt	0	1	58116401	

HW**Unisteel**

Chop Saw Blades HW for metal - neutral hook angle flat tooth with alternating chamfer

Product	Drawing	Machine	Application	Design
				F-WFA

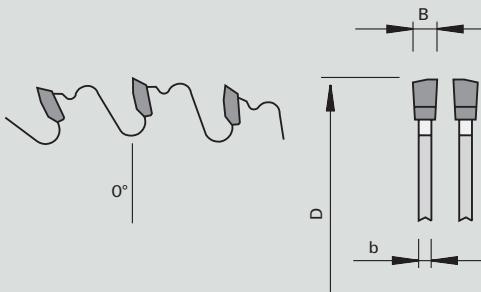
Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> • table saws • clipping and miter saws • for dividing and miter cuts in metals and NF-metals (zinc) plates, cast iron, etc. 	<ul style="list-style-type: none"> • tooth configuration: flat with alternating chamfer "F-WFA" • cutting material: HW TCm13 	<ul style="list-style-type: none"> • improved cutting quality thanks to special cutting geometry 	<ul style="list-style-type: none"> • for wood-based panels and plastics see ZWS and Parat - negative (HSK) • reduced edge lives in the case of stainless steel

Product features							Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality* NL**	Hook angle [°]	PU [pc.]	L	Order-No.	
254	2,4	1.8	30	48	▲	Combi3	0	1	58165001	
260	2,5	1.8	30	60	▲	Combi3	0	1	58165010	
270	2,6	2.2	30	54	▲▲	Combi3	0	1	58116517	
305	2,6	2.2	30	60	▲▲	Combi3	0	1	58165002	
330	2,6	2.2	30	54	▲	Combi3	0	1	58165005	
355	2,6	2.2	30	80	▲▲	Combi3	0	1	58165003	
400	2,6	2.2	30	84	▲▲	Combi3	0	o	58165004	
450	2,6	2.2	30	90	▲▲	Combi3	0	1	58165006	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HW	Steel	Chop Saw Blades HW for metal - neutral hook angle flat tooth with alternating chamfer	Machine	Application	Design
Product	Drawing			 	F-WFA 3-0-1 HW TCm13 
Machine / Application	Design	Advantages	Notes		
<ul style="list-style-type: none"> dry-cut machines universal metal-cut machines for dividing and miter cuts in composite materials, metal sheets, plastics, NF-metals, cable ducts, profiles, SML-tubes, etc. 	<ul style="list-style-type: none"> tooth configuration: flat with alternating chamfer "F-WFA" cutting material: HW TCm13 	<ul style="list-style-type: none"> dry cut excellent cutting quality 	<ul style="list-style-type: none"> recommended RPM: Ø254 = 1750 min-1 Ø305 = 1500 min-1 Ø330 = 1350 min-1 Ø355 = 1250 min-1 		

Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.
254	2,2	1.8	30	60	▲▲	Combi3	0	1		58805861
305	2,2	1.8	25,4	60	▲▲		0	1		58805862
305	2,2	1.8	25,4	80	▲▲		0	1		58805863
305	2,2	1.8	30	80	▲▲▲	Combi3	0	1		58805864
320	2,2	1.8	25,4	84	▲▲▲		0	1		58805859
330	2,2	1.8	30	90	▲▲▲	Combi3	0	1		58805865
355	2,2	1.8	25,4	80	▲▲▲		0	1		58805866
355	2,2	1.8	25,4	90	▲▲▲		0	1		58805868
355	2,2	1.8	30	90	▲▲▲	Combi3	0	1		58805867

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42

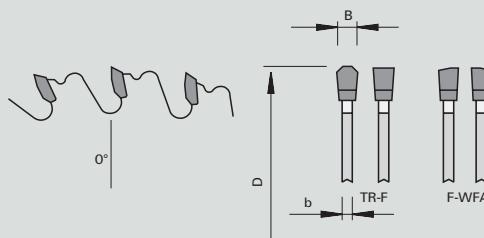
For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

HT**Mega-Steel****Chop Saw Blades HT for metal - neutral hook angle**

Product



Drawing



Machine



Application



Design



3-0-1

HW
TCx03

Machine / Application

- dry-cutting machines
 - universal metal-cutting machines
 - for dividing and miter cuts in composite materials, metal sheets, stainless steel, plastics, NF-metals, cable ducts, profiles, SML-tubes, etc.
- Design
- tooth configuration: up to Ø 250 mm triple-chip - flat "TR-F"
 - tooth configuration: from Ø 250 mm flat with alternating chamfer "F-WFA"
 - cutting material: HT TCx03

Advantages

- dry cut
- excellent cutting quality
- extremely long edge lives

Notes

- for smaller dimensions we recommend our types Parat - negative (HKS) and Unisteel (HKS)
- recommended RPM:
 - Ø160 = 2750 min-1
 - Ø190 = 2350 min-1
 - Ø216 = 2050 min-1
 - Ø230 = 1950 min-1
 - Ø250 = 1750 min-1
 - Ø305 = 1500 min-1
 - Ø355 = 1250 min-1

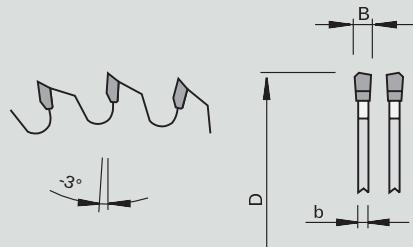
Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting qual- ity*	NL**	Hook angle [°]	Tooth geom- etry	PU [pc.]	L	Order-No.
160	1,8	1,4	20	40	▲▲		0	TR-F	1		58458784
190	1,8	1,4	30	48	▲▲	2/7/42	0	TR-F	1		58458785
216	1,8	1,4	30	56	▲▲	2/7/42	0	TR-F	1		58458786
230	1,8	1,4	30	60	▲▲	2/7/42	0	TR-F	1		58805879
254	2,2	1,8	25,4	72	▲▲		0	F-WFA	1		58805870
254	2,2	1,8	30	72	▲▲	Combi3	0	F-WFA	1		58805871
305	2,2	1,8	25,4	60	▲▲		0	F-WFA	1		50805872
305	2,2	1,8	25,4	80	▲▲▲		0	F-WFA	1		50805873
330	2,2	1,8	30	90	▲▲▲		0	F-WFA	1	o	50805875
305	2,2	1,8	30	80	▲▲▲	Combi3	0	F-WFA	1		50805874
355	2,2	1,8	25,4	80	▲▲▲		0	F-WFA	1		50805876
355	2,2	1,8	25,4	90	▲▲▲		0	F-WFA	1		50805878
355	2,2	1,8	30	90	▲▲▲	Combi3	0	F-WFA	1		50805877

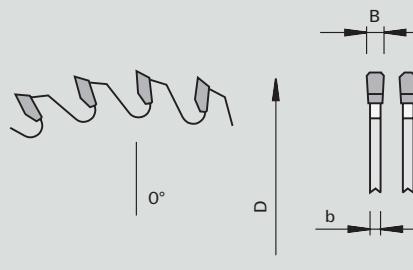
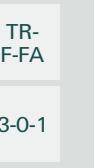
* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

 ** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9,5/46,5 and 2/7/42
 For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW	KKS - plastic	Chop Saw Blades HW for plastic profiles - alternate top bevel with chamfer							
Product	Drawing	Machine	Application	Design	WS-FA	2-0-6			
									

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> clipping and miter saws table saws for dividing and miter cuts in plastic profiles made from PVC, acrylics, plexiglass, thermosetting plastics, PE, PA, PU, etc. 	<ul style="list-style-type: none"> tooth configuration: alternate top bevel - with chamfer "WS-FA" cutting material: HW TC10 from Ø 250 TC06 	<ul style="list-style-type: none"> noise-reduction thanks to laser ornaments 	

Product features									Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Cutting material	PU [pc.]	L	Order-No.
160	2,2	1.6	20	48	▲▲		-3	TC10	1		58116000
190	2,2	1.6	30	54	▲▲		-3	TC10	1		58116001
216	2,8	2.2	30	60	▲▲		-3	TC10	1		58116002
232	2,8	2.2	30	72	▲▲		-3	TC10	1		58116003
250	2,8	2.2	30	80	▲▲▲	Combi3	-3	TC06	1		50808500
300	2,8	2.2	30	96	▲▲▲	Combi3	-3	TC06	1		50808501
350	2,8	2.2	30	100	▲▲▲	Combi3	-3	TC06	1		50808502

HW	KKS - hard plastic	Chop Saw Blades HW for extremely hard plastic profiles - triple chip / flat with two-sided chamfer							
Product	Drawing	Machine	Application	Design	TR-F-FA	3-0-1	HW TC06		
									

Machine / Application	Design	Advantages	Notes
<ul style="list-style-type: none"> table saws for dividing and miter cuts in plastic profiles made from Corian, Varicor, Trespa, laminate, etc. 	<ul style="list-style-type: none"> tooth configuration: triple chip / flat with two-sided chamfer "TR-F-FA" cutting material: HW TC06 	<ul style="list-style-type: none"> noise-reduction thanks to laser ornaments 	

Product features									Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	PU [pc.]	L	Order-No.	
250	3,2	2.5	30	72	▲▲▲	Combi3	0	1		50808600	
300	3,2	2.5	30	84	▲▲▲	Combi3	0	1		50808601	

* cutting quality: ▲ very rough cut ▲▲ rough cut, ▲▲▲ fine cut ▲▲▲▲ very fine cut

** pin holes: Combi1 matches 2/10/60 and 2/7/42 Combi3 matches 2/10/60 and 2/9/46 and 2/9.5/46.5 and 2/7/42

For suitable **reducing rings** see chapter CONSTRUCTION/Saws/Reducing Rings

Reducing Rings - knurled for Circular Saw Blades

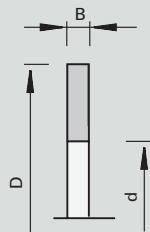
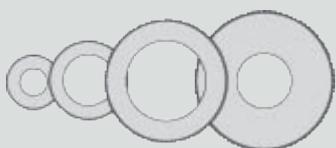
Product

Drawing

Machine

Application

Design



Machine / Application

- portable saws
- for reduction of the saw blade bore
- ground bore
- knurled on the outside

Advantages

Notes

- this bore can only be reduced if the direct clamping of the saw blade via clamping rings or flanges is guaranteed

Product features

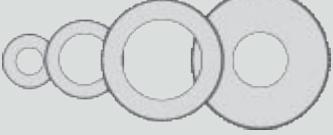
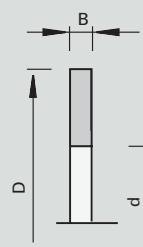
Order information

$\varnothing D$ [mm]	B [mm]	$\varnothing d$ [mm]					PU [pc.]	L	Order-No.
20	1,4	12,7					1		50880032
20	1,4	13					1		50880029
20	1,8	15					1		50880018
20	1,4	16					1		50880027
20	1,6	16					1		50880050
20	1,8	16					1		50880016
22	2,0	20					1		50880036
25	1,4	16					1	#	50880039
25	1,4	20					1		50880038
25	2,2	22					10	s	50880159
25,4	2,0	20					1		50882620
30	2,0	15					1		50880014
30	1,4	16					1		50880031
30	2,0	16					1		50880044
30	2,2	16					1		50880012
30	1,8	18					1		50883018
30	1,4	20					1		50880026
30	2,0	20					1		50880045
30	2,2	20					1		50880010
30	2,0	22					1		50880033
30	2,0	22,2					1		50883022
30	2,0	24					1		50880009
30	1,4	25					1		50880008
30	2,0	25					1		50880042
30	2,2	25					1		50880007
30	2,0	25,4					1		50880006
32	2,0	20					1		50883220
32	2,2	25					1		50880139
32	2,0	30					10	s	50883230
32	2,2	30					1		50880004
35	1,8	25					10	s	50883525
35	2,0	20					1	#	50883520
35	1,8	30					1		50883530
35	2,0	30					1		50880040
40	2,2	30					1		50880001
							1	#	50881001

Description	Composed of			PU [pc.]	L	Order-No.
packing unit (50 pieces)	5 x 20/13,0/1,4	50880029		1	#	50881001
	5 x 20/16,0/1,6	50880050				
	5 x 30/16,0/1,4	50880031				
	5 x 30/16,0/2,0	50880044				
	5 x 30/20,0/1,4	50880026				
	5 x 30/20,0/2,0	50880045				
	5 x 30/25,0/1,4	50880008				
	5 x 30/25,0/2,0	50880042				
	5 x 30/25,4/2,0	50880006				
	5 x 32/30,0/2,2	50880004				

Reducing Rings - smooth

for Circular Saw Blades

Product	Drawing	Machine	Application	Design
				
Machine / Application	Design	Advantages	Notes	
<ul style="list-style-type: none"> • portable saws • for reduction of the saw blade bore 	<ul style="list-style-type: none"> • ground bore • smooth on the outside 		<ul style="list-style-type: none"> • this bore can only be reduced if the direct clamping of the saw blade via clamping rings or flanges is guaranteed 	

Product features					Order information		
Ø D [mm]	B [mm]	Ø d [mm]	Ø d [inch]		PU [pc.]	L	Order-No.
20	1,6	12,7	1/2"		1		161946
20	1,6	16			1		161945
22	2,0	20			1		161887
22	4,0	20			1		161830
25	2,2	20			1		000104
30	1,4	15			1		000107
30	1,4	16			1		000111
30	1,4	20			1		000117
30	1,4	25			1		000125
30	1,8	15,1	19/32"		1	#	161949
30	1,9	16			1		000112
30	1,9	20			1		000118
30	2,0	20			1		016848
30	2,0	25			1		000127
30	2,2	15,88	5/8"		1	s	000110
30	2,2	16			1		000113
30	2,2	18			1		000114
30	2,2	20			1		000119
30	2,2	22			1		000120
30	2,2	25			1		000128
30	2,2	25,4	1"		1		000130
30	2,2	28			1		000132
30	3,0	25			1		000129
32	2,0	16			1		161886
32	2,2	16			1	s	000134
32	2,2	20			1	s	000135
32	2,2	22			1		010571
32	2,2	30			1		000137
35	1,0	30			1		000145
35	1,4	30			1	s	000146
35	1,9	30			1		000147

Product features					Order information		
Ø D [mm]	B [mm]	Ø d [mm]	Ø d [inch]		PU [pc.]	L	Order-No.
35	2,2	20			1		000138
35	2,2	24			1	s	000139
35	2,2	25			1		000142
35	2,2	30			1		000148
40	2,0	32			1		161962
40	2,2	20			1		000151
40	2,2	30			1		000153
40	2,2	35			1		000154
45	2,5	30			1		161831
50	2,2	30			1		000156
55	2,2	30			1		000159
60	2,2	30			1		000161
60	2,2	35			1		000162
60	2,2	40			1	s	000163
60	2,2	50			1		000164
60	2,8	30			1		010577
70	2,2	30			1	s	000166
80	2,2	30			1		000171
80	2,2	35			1	s	000172
80	2,2	50			1	s	000175
80	2,2	60			1		000177
80	2,2	70			1	s	000179
80	2,8	60			1		000178

Portable Saw, Clipping and Mitre Saw



Marke/Model	Ø D [mm]	Ø d [mm]
STARIKO / STARTEK		
SLID 210	210	30
STAYER		
CP 46	140	20
CP 50	150	20
CP 66	190	30
CP 66 E	190	30
CP 76	210	30
CP 86	230	30
CS 250	250	20
HKS 700	140	20
KS 700	205	18
Profiline	140	20
SC 205	205	18
SC 205 W	205	18
SC 250	250	20
SC 250 W	250	20
SC 251	250	20
SC 260 W	250	30
SC 270	250	30
SC 271	250	30
SC 47 C	140	20
SCE 1600	250	30
SCE 205	205	18
SCE 250	250	30
SCU 45	205	18
SCU 45 S	205	18
SCU 75	250	20
SCU 75 W	250	20
SL 251 E	250	30
SLL 250	250	30
SLL 250 E	250	30
SLL 251	250	30
SLL 251 E	250	30
TKS 2000	205	18
TIP		
HKS160	160	20
HKS200	200	16
KGS250	250	30
TGS250	250	25,4
TKS250	250	15,8
ULMIA		
1607	160	16
1607	200	16
1610	160	16
1610	250	30
1622	250	30
1625	250	30
1706	200	30
1708	200	30
1710	250	30
1711	250/300	30
1712	300/350	30
1725	300/350	30
1728	350	30
1729	350	30
1710 R	250	30
1710 SN	250	30
1712 R	350	30
1712 RT	350	30
KS 1	160	30
KS 300	315	30
Universa	125	16
universa 2	200	30
US 1	200	30
UNIROPA		
HKS 6050	160	20
HKS 6055	160	20
VARIOLUX		
OKS 315	315	30

Marke/Model	Ø D [mm]	Ø d [mm]
VIRUTEX		
AL 96	250	20
BL 96	250	20
WEGOMA		
BG 10 D	250	32
DS 130	500	80
F 202	250	20
F 203	320	20
GL 142 M	180	32
GL 142 P	180	32
GL 143 M	300	32
GL 143 P	300	32
GS 126 M	400	30
GS 126 P	400	30
HS 50	150	20
KL 148 M	250	32
KL 148 P	250	32
RS 460	250	30
S 10 D	300	20
S 10 W	300	20
S 11 D	300	20
S 11 W	300	20
S 4 D	350	30
S 4 W	350	30
S 8 D	250	20
S 8 W	250	20
S 80	250	20
S 9 D	250	20
S 9 W	250	20
S 90	250	20
SD 10 D	300	20
SD 15	330	30
SD 16	400	30
SD 17 AE	350	30
SD 17 M	350	30
SD 17 P	350	30
SD 24	420	30
SD 25	500	30
SD 30	500	30
SD 32	420	30
SuperCut 3000	500	80
TB 204	105	22
TS 250	250	30
TS 300	300	32
TS 400	400	30
WIDL		
BK 450	450	30
WK 550	550	30
WOLF		
6070	184	16
6089	235	16

Diameter Index Circular Saw Blades

Ø D [mm]	Ø d [mm]	Z	Tooth geom- etry	Order-No.	Program	Page
420	60	72	TR-F	58807956	HW TFP	50
430	80	72	TR-F	58806479	HW TFP	50
450	30	20	WS	58101020	HW ZW	19
450	30	30	F-FA	58120044	HW BKS (nail proof)	11
450	30	32	F	58104051	HW ZFL	18
450	30	36	WS	50804425	HW Planet	25
450	30	40	WS	58100013	HW ZQW	20
450	30	40	WS	58101006	HW ZW	19
450	30	66	WS	58100023	HW ZWS	22
450	30	72	TR-F-FA	50750138	DP TFP	51
450	30	72	TR-F	58458789	HW TFP	50
450	30	90	F-WFA	58165006	HW Unisteel	63
450	30	96	TR-F	58808235	HW NF - negative	59
450	30	108	WS	58100060	HW ZWS	22
450	30	112	G7	192278	HW NF-Chop Saw Blades HW - profiles "G7"	60
450	40	108	TR-F	58808117	HW NF- positive	58
450	60	72	TR-F-FA	50750136	DP TFP	51
450	60	72	TR-F	58807817	HW TFP	50
450	80	72	TR-F-FA	50750137	DP TFP	51
460	30	72	TR-F-FA	50750146	DP TFP	51
480	30	72	TR-F-FA	50750139	DP TFP	51
480	60	72	TR-F-FA	50750140	DP TFP	51
500	30	34	F-FA	58120045	HW BKS (nail proof)	11
500	30	36	F	58104052	HW ZFL	18
500	30	44	WS	58100014	HW ZQW	20
500	30	44	WS	58102007	HW ZW	19
500	30	72	WS	58100024	HW ZWS	22
500	30	120	TR-F	58808118	HW NF- positive	58
500	30	120	TR-F	58808239	HW NF- negative	59
500	30	126	G7	192279	HW NF-Chop Saw Blades HW - profiles "G7"	60
500	30	126	G7	192661	HW NF-Chop Saw Blades HW - profiles "G7"	61
500	30	144	WS	50807842	HW OKW	23
500	30	145	F-WS-WS	58808710	HW Matador 5	34
550	30	32	F	58104054	HW ZFL	18
550	30	64	WS	58120070	HW ZWS	22
550	30	133	G7	192392	HW NF-Chop Saw Blades HW - profiles "G7"	60
550	30	160	F-WS-WS	58808711	HW Matador 5	34
600	30	36	F-FA	58120227	HW BKS (nail proof)	11
600	30	40	F	58104048	HW ZFL	18
600	30	54	WS	58101018	HW ZW	19
700	30	42	F	58104053	HW ZFL	18
700	30	42	F-FA	58120228	HW BKS (nail proof)	11
700	30	46	F	58104049	HW ZFL	18
700	30	60	WS	58101019	HW ZW	19

Sales Regulations

— REWORK AND ALTERATIONS

- Rework and alterations on new tools are only made in compliance with legal and safety regulations.
- Thus, the delivery of stock tools can be prolonged by a few days. Please check this in advance with the Stehle inside sales department.
- Special bores which deviate from normal bores of the stock tool are offered and charged according to the valid rework price list. In the case of diamond tools please keep in mind that due to the tight tolerances the cutting edge has to be reworked and thus resharpening possibilities are reduced by one cycle

— ORDER INFORMATION

- This catalogue and the related price list (from 2017/05) replace all previous editions and prices granted.
- Indications as to delivery times as made by the delivery signs in the catalogue are subject to change during the period of validity of the catalogue. Current details can be obtained from the Stehle inside sales staff.

— QUANTITIES

- The general sales and packing unit is one piece.
- In the case of small parts (TOK, knives, screws etc.) a packing unit can consist of several pieces. In such cases, delivered quantities have to correspond with the packing units.
- If sets consisting of different tools are offered, they can be purchased only as a complete set.
- If large quantities are ordered special prices can be granted. Please ask the Stehle inside sales staff.

— TERMS OF DELIVERY

- Tool deliveries within Germany are free buyer's address.
- For deliveries abroad generally conditions ex factory apply.
- Additional costs for express shipping such as express, airfreight etc. will be invoiced at our cost price.

— ORDER PROCESSING

- For queries please keep ready the number of our order confirmation, our date and your order data. This speeds up handling time.
- Cancellations are subject to our written approval and confirmation. Costs incurred until then (e.g. for special production and rework) have to be born by the customer.
- Return of goods:
Stock items can only be returned after prior agreement with the Stehle staff in charge within the warranty period in original condition. In this case, a handling fee will be charged. Damaged packages must be compensated.
Special tools and reworked stock tools are excluded from return.

— ORDER PROCESSING VIA NEXMART

- NexMart registered customers can place their order via nexMart portal. They can use the online-catalogue offering product search, inquiry, order history as well as feed-back.
- The Nexmart portal is available for customers in Germany and in Austria at the date of the catalogue printing.

— GENERAL TERMS AND CONDITIONS

- Please pay attention to the complete Stehle General Terms and Condition on the website www.stehle-int.com

Tool Checklist

Imperative features for special tools

Date: _____

sales person	Offer / Order no.
Customer	
Address	
Contact name	Phone: _____
Customer no.	Fax: _____ E-mail: _____

Machine data

Machine	Type		
Flange Ø [mm]	RPM [min-1]:	Clamping system	
Spindle Ø [mm]	Spindle position	<input type="checkbox"/> Horizontal <input type="checkbox"/> Vertical <input type="checkbox"/> Tilted	Degree of tilt [°]
Type of feed	<input type="checkbox"/> MEC <input type="checkbox"/> MAN	Feed rate [m/min]:	

Machining data

Workpiece material	Mode of application:	<input type="checkbox"/> Against feed <input type="checkbox"/> With feed
Cutting quality	<input type="checkbox"/> Trimming cut <input type="checkbox"/> Finish cut	<input type="checkbox"/> Pre-Trimming <input type="checkbox"/> Finish-Trimming
Cutting direction	<input type="checkbox"/> With grain <input type="checkbox"/> Across grain	<input type="checkbox"/> Crosscut wood <input type="checkbox"/> Contour <input type="checkbox"/> Drill
Profile as drawing no.	<input type="checkbox"/> Drawing <input type="checkbox"/> Wood sample	<input type="checkbox"/> Tool sample <input type="checkbox"/> Customer drawing
Version hoggers	<input type="checkbox"/> Folding <input type="checkbox"/> Stepped	<input type="checkbox"/> Circular cut <input type="checkbox"/> Double hogging <input type="checkbox"/> Scoring / Hogging

Tool data

Type of tool	Prod. group	Class-No.
<input type="checkbox"/> Single tool	<input type="checkbox"/> Set tool	<input type="checkbox"/> Pinned
Ø D [mm]	B [mm]	Hub diameter [mm]
Z [St.]	Raker [qty.]	<input type="checkbox"/> Face cutting edge
KN [mm]	DKN [mm]	Minor diameter [mm]
Shear angle	<input type="checkbox"/> Yes <input type="checkbox"/> No	Description of cutterhead
Cutting material	<input type="checkbox"/> HS <input type="checkbox"/> Stellit	Cutting material quality
TOK runout [°]	<input type="checkbox"/> HW <input type="checkbox"/> DP	

Drawing

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For example:
Actual presentation possibilities for
saw blades



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Legend

Machines

	Portable saws		Vertical panel sizing saw		Four-side planing machine		Double end tenoners
	Clipping and Mitre Saws		Multi rip saw		CNC router		Not classified
	Table saw		Portable router		Spindle Moulder		
	Horizontal panel sizing saw		Multi spindle drilling machine		Edges		

Application

	Abrasive		Abrasive	- excellently suited		Abrasive	- well suited
	Construction		Construction	- excellently suited		Construction	- well suited
	Wood		Wood	- excellently suited		Wood	- well suited
	Wood-based materials		Wood-based materials	- excellently suited		Wood-based materials	- well suited
	Aluminum		Aluminum	- excellently suited		Aluminum	- well suited
	Steel		Steel	- excellently suited		Steel	- well suited
	Plastic		Plastic	- excellently suited		Plastic	- well suited

Design / Features

	Aluminum body		High speed steel		HSK adapters		Right hand / Left hand
	Solid tungsten carbide body		Polycrystalline diamond		No. of ground cutting edges		Hard wood
	Resharpening area in mm		Monocrystalline diamond		Recommended feed		Soft woods
	For cross cuts		Solid tungsten carbide		Long edge life		Low noise level
	For profile trimming		SK adapters		Maximum RPM		Manual feed
	Tungsten carbide quality		BT adapters		For Micro chips		Mechanical feed

Tooth Configurations

	F		F-FA		WS		DA-F
	HR		ES		WS-FA		D-F DU
	F-WFA				TR-F		DA-F FA DU
	F-WS-WS				TR-F-FA		KO-F
	WSA				TR-F-F-DU		G7

Miscellaneous

	Suited
	Particularly suited
	Scoring saw

Delivery signs

	Modification and/or mounting of stock parts		Production per drawing
	Available on short notice		Discontinued, subject to availability

All Order-No. are available from stock unless specifically indicated



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