



Stehle



Finger jointing and planing

2018



Stehle

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TREND-SETTING, INNOVATIVE, RELIABLE



Frank Diez:

„Our aim is to develop the company together with the employees. Outstanding features of our company philosophy are innovation and quality. They are our mission and our demand, requested by Management and proven by our staff every day.
















We attach great importance to research and development. Apart from application engineering and construction they are decisive factors to make sure that the company group keeps its leading position in the woodworking industry in spite of hard competition. I am convinced that we will continue to set standards and keep-up our high level.



Frank Diez,
Chairman of the Executive Board of the LEUCO AG

In July 2012, Frank Diez, the chairman of the executive board of many years assumed the chairmanship of the management board. Thus, for more than two decades a member of the member of the owner families has assumed operative responsibility again.

Machines

| | | | |
|--|--|---|--|
|  Portable saws |  Vertical panel sizing saw |  Four-side planing machine |  double end tenoners |
|  Clipping and miter saw |  Multi rip saw |  CNC router |  Finger jointing line |
|  Table saw |  Portable router |  Table shaper |  Not classified |
|  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 |
|  Panels |  Panels – excellently suited |  Panels – well suited |
|  Aluminum |  Aluminum – excellently suited |  Aluminum – well suited |
|  Steel |  Steel – excellently suited |  Steel – well suited |
|  Plast |  Plast – excellently suited |  Plast – well suited |



Design / Features

| | | | |
|--|-----------------------------------|---|---|
|  Aluminum body | HS High speed steel | HSK HSK adapters | R/L Right-/lefthand rotation |
|  Solid tungsten carbide body | DP polycrystalline diamond |  No. of ground cutting edges |  Hard wood |
|  Resharpener area in mm | DM Monocrystalline diamond | v_f 60 m/min Recommended feed |  soft wood |
|  For cross cuts | VHM Solid tungsten carbide | LONG LIFE Long edge life | LOW NOISE Low noise level |
|  For profile trimming | SK SK adapters | max. 20.000 U/min maximum RPM | MAN Manual feed |
| HW TC02 Tungsten carbide quality | BT BT adapters |  For microchips | MEC mechanical feed |

Tooth Configurations

| | | | | | |
|--|----------------|---|------------------|--|-------------------|
|  Flat „F“ | F |  Alternate top bevel „WS“ | WS |  Inverted-v/ Flat „DA-F“ | DA-F |
|  hollow back tooth | HR |  Alternate top bevel with chamfer „WS-FA“ | WS-FA |  inverted-v / flat tooth / hollow-ground tooth | D-F DU |
|  Flat with alternating chamfer „F-WFA“ | F-WFA |  Triple chip - flat „TR-F“ | TR-F |  inverted-v / flat tooth with chamfer / hollow-ground tooth | DA-F-FA DU |
|  Flat ATB ATB „F-WS-WS“ | F-WS-WS |  Triple chip - flat with two-sided chamfer „TR-F-FA“ | TR-F-FA |  Conical-flat „KO-F“ | KO-F |
|  alternate top bevel with shear angle „WSA“ | WSA |  triple chip / flat - flat / hollow-ground tooth „TR-F-F DU“ | TR-F-F DU |  G7 | G7 |
|  V-tooth „V“ | V |  flat with chamfer „F-FA“ | F-FA |  top bevel „ES (right + left)“ | ES |

Miscellaneous

| | |
|--|--|
|  Suited | |
|  Particularly suited | |
| RS Scoring saw | |

Delivery signs

| | |
|---|--|
|  Modification and/or mounting of stock parts | s Production per drawing |
| o available on short notice | # Discontinued, subject to availability |

NEW FINGER JOINT CUTTER TYPES!!!

With immediate effect, new interesting finger joint cutters are available: finger joint cutters for the production of PUR glueings, finger joint cutterheads with HS profile knives and coated HS finger joint cutters.

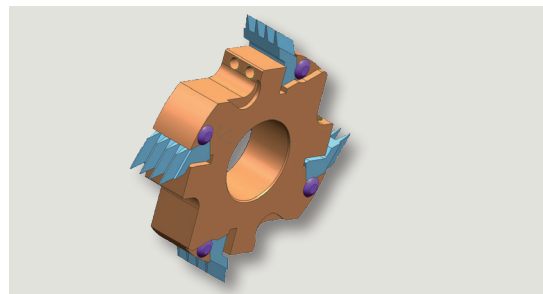
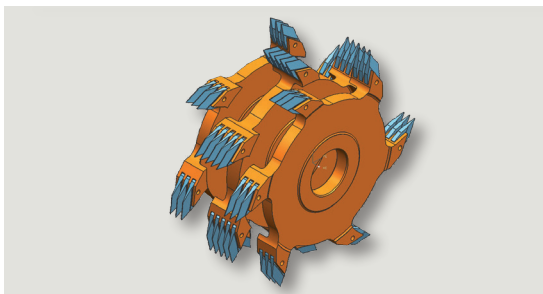
Program for the production of fingers for PUR glueing

The HSS-tipped tools for finger jointing lines without cross-cutting device are applied for the production of longitudinal joints. The advantage of the cutter lies in the cutting angle of the single fingers. This cutting angle is flatter than in the case of conventional finger joint cutters and is excellently suitable for the glueing with PUR glue.

New is the HS-tipped finger joint cutter with LEUCO Topcoat coating which allow multiple edge lives.

Thanks to the coating, both cutting pressure and knife breakage are reduced. The coating is permanent and can be resharpened without problems.

The manufacturing quality of finger joint cutters is one of the most important factors to obtain quality for the production of finger joints. Process-safe solder connections, polished hubs ground in the micrometer range, high balancing quality and sharpening know-how are factors Stehle customers can rely on in the case of the new finger joint cutters, too.



Finger joint cutter for PUR glueing (left) and finger joint cutter with exchangeable HS cutting edges

STEHLE FINGER JOINT CUTTER PROGRAM BY MEANS OF THIS OVERVIEW YOU WILL QUICKLY FIND THE SUITABLE CUTTER

| Application Design | Finger Joint Cutters | | | | | | | | | Disc-Type Finger Joint Cutters | | | | | | cutterhead | | | | | |
|--------------------------|---------------------------|--------------------|---------|-------------------------------|------------------|---------|-------------------------|---|---------|-----------------------------------|------------|-----------------------------------|------------|-------------------------------------|-------|-------------------------|-------------------|-------|-------|-------|---------|
| | Finger Joint Cutters HS | | | Finger Joint Cutters HS 3Plus | | | Finger Joint Cutters HW | | | Finger Joint Cutters HW soft wood | | Finger Joint Cutters HW hard wood | | Finger Joint Cutters HW exotic wood | | Finger Joint Cutterhead | | | | | |
| Glueing | normal | ++ | | | ++ | | | ++ | | | ++ | | ++ | | ++ | | ++ | | | | |
| | fiber free | ++ | | | o | | | o | | | o | | o | | o | | o | | | | |
| Wood types | Coniferous wood | ++ | | | ++ | | | o | | | ++ | | ++ | | o | | ++ | | | | |
| | Deciduous wood | + | | | ++ | | | ++ | | | - | | ++ | | ++ | | o | | | | |
| | Exotic wood | o | | | + | | | + | | | - | | + | | ++ | | o | | | | |
| Dimensions on machine | machines (with hogger) | 10/11 | 15/16,5 | 20/22 | 10/11 | 15/16,5 | 20/22 | 10/11 | 15/16,5 | - | 10/11 | 10/11 | 15/16,5 | - | 10/11 | 15/16,5 | - | - | | | |
| | machines (without hogger) | 10/10 | 15/15 | 20/20 | 10/10 | 15/15 | 20/20 | 10/10 | 15/15 | - | - | - | - | - | - | - | - | 10/10 | 10/11 | 15/15 | 15/16,5 |
| Coating possibilities | Non-stick coating | Triathlon | | | (*) | | | (*) | | | (*) | | (*) | | (*) | | Triathlon | | | | |
| Comparison of edge lives | uncoated | 100% | | | up to 300%-400 % | | | up to 400% (increased risk of breaking) | | | 100% | | 100% | | 100% | | 100% | | | | |
| | Triathlon | up to 200% - -300% | | | > 500 % (*) | | | (*) | | | up to 200% | | up to 200% | | - | | up to 200% - 300% | | | | |

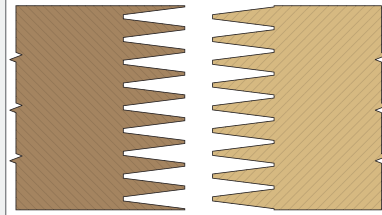
*on request

++ very well suited + well suited o possible - not possible / not suitable

Cutter types

Finger Joint Cutters

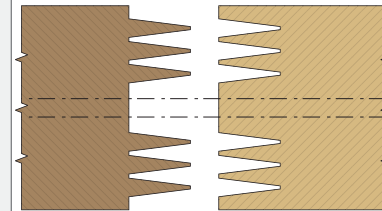
Load bearing longitudinal joints (end-to-end) are produced by finger jointing. The finger length of 30-50 mm which was standard in the past could be reduced thanks to improved tool technology (finger length 10/15/20 mm) with the effect of a significant reduction of wood waste.



Load bearing capacity of the finger joints

The load bearing capacity of the finger joints is strongly correlated with the measurement proportions specified in the DIN norms (e.g. finger length, angle, finger pitch etc).

We distinguish between load bearing capacity I and II. These two groups in turn must comply with particular requirements of finger jointing. The weakening degree, length of finger and angle of flanks are interdependent factors of finger joint profiles. The decisive factor for the load bearing capacity of a finger joint is the weakening degree v . The bigger v is, the lower is the possible load bearing of a finger joint. The following results are valid for each load bearing capacity group:
 load bearing capacity group I: v must be $\leq 0,18$
 load bearing capacity group II: v can be $\leq 0,25$



Overview

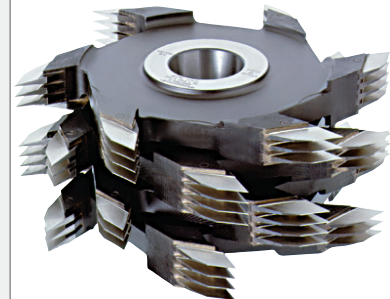
finger joint profiles

| | | | |
|--------------------------------|--------|--------|--------|
| finger length L | 10 | 15 | 20 |
| finger pitch t | 3,8 | 3,8 | 6,2 |
| width of finger joint bottom b | 0,6 | 0,54 | 0,9 |
| weakening degree v | 0,15 | 0,14 | 0,14 |
| load bearing capacity group | I + II | I + II | I + II |

compact cutter

e.g. Cutter No. 198/199

HS, HS-Super or HW-tipped, proven performance and extremely robust tooth design and extended edge life.



single cutter

e.g. Cutter No. 200

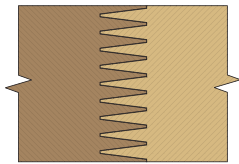
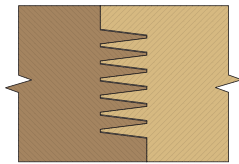
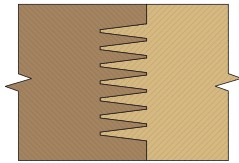
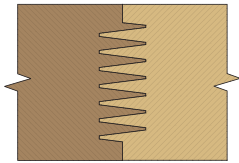
Individual cutting discs with the possibility to add or remove single discs according to the required cutting height. Further advantage: spiral design permits higher feed speeds with either 4 or 6 discs in operation.



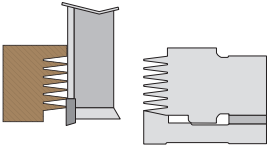
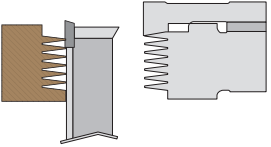
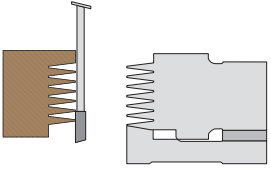
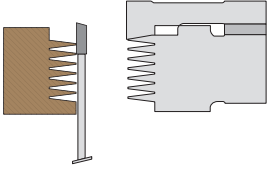
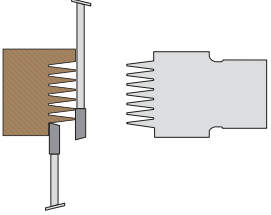
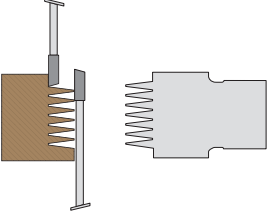
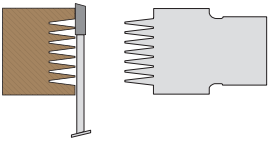
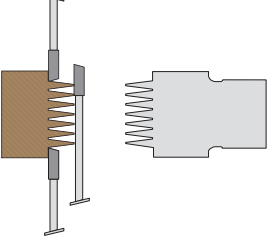
Types of finger joints

Finger Joint Cutters

Depending on the application of the wood joint, profiles can be produced with or without edge fingers. Depending on the machine, the edge joints can be produced with a cross-cutting device or with the respective tools.

| | | | |
|--|---|--|---|
| a) endless galvanizing |  | c) double-sided butt joint edge joints in staggered position |  |
| b) double-sided butt joint one-sided edge joints |  | d) double-sided butt joint centric edge joints |  |

Examples

| | | | |
|---|---|--|---|
| A <ul style="list-style-type: none"> • cross cutting from top with hogger • with edge cutting by means of edge finger joint cutters |  | E <ul style="list-style-type: none"> • cross cutting from below with hogger • with edge cutting by means of edge finger joint cutters |  |
| B <ul style="list-style-type: none"> • cross cutting from above with saw blade • with edge cutting by means of edge finger joint cutters |  | F <ul style="list-style-type: none"> • cross cutting from below with saw blade • with edge cutting by means of edge finger joint cutters |  |
| C <ul style="list-style-type: none"> • cross cutting from above with saw blade • bevelling with scoring saw blade from below |  | G <ul style="list-style-type: none"> • cross cutting from below with saw blade • bevelling with scoring saw blade from top |  |
| D <ul style="list-style-type: none"> • cross cutting from below with saw blade |  | H <ul style="list-style-type: none"> • cross cutting from below with saw blade • bevelling with scoring saw blade from top and from below |  |

cutter insert

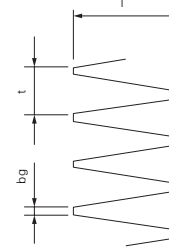
Finger Joint Cutters

Basically, different tools are used depending on the application:

Machines without cross-cutting device

The required finger tools are designed for finger joint profiles 10/10 mm, 15/15 mm and 20/20 mm.

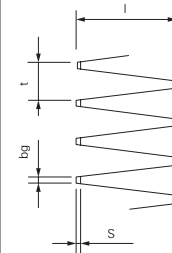
Finger joints with gap "s" can be produced. The gap can vary and depends e.g. on the factors material type, tool and machine.



Machines with cross-cutting device

The required finger tools are designed for the finger joint profiles 10/11 mm, 15/16,5 mm and 20/22 mm.

Thanks to the precise cross cutting of the fingers (adjustment) close fitting finger joints without gap "s" can be produced.

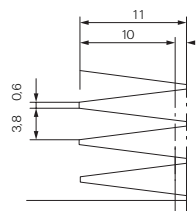


Cross cutting with extended finger joint profile

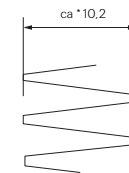
With the cross-cutting device the actual profile depth can vary between 10 and 11 in the case of finger length 10/11 mm (accordingly, the profile depth can vary between 15 and 16.5 in the case of finger length 15/16.5 mm and between 20 and 22 in the case of finger length 20/22 mm).

The variable profile length allows to change the fitting conditions.

profile example 10/11 mm
before cross cutting

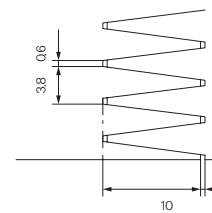


cut to approx. *10.2 mm
close fit profile
= depending on material



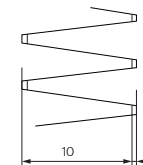
1 mm
variable length

finger joint cut to 10 mm
profile 10/10 with gap



profile example 10/10 mm
without cross cutting

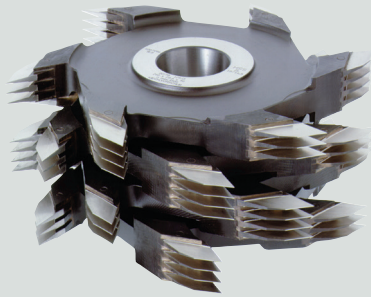
0.32 gap
theoretical value



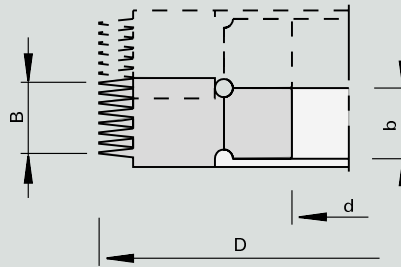
HS 198 Finger Joint Cutters - Z=2+2 and Z=3+3

HS-tipped

Product



Drawing



Machine



Application



Design



Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

Design

- straight tooth front
- secured against twisting
- cutting material: HS-tipped

Advantages

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device

Overview

wood width with finger length of

Number of cutters

| | 10 or 15 mm fingers | 20 mm fingers; pitch 6.2 mm | 20 mm fingers; pitch 5.0 mm | |
|-----|---------------------|-----------------------------|-----------------------------|-------------|
| | with B = 26 | with B = 28.6 | with B = 33 | with B = 37 |
| 25 | 24 | 28 | 32 | 1 |
| 49 | 51 | 59 | 67 | 2 |
| 73 | 77 | 90 | 102 | 3 |
| 97 | 104 | 132 | 137 | 4 |
| 121 | 131 | 152 | 172 | 5 |
| 145 | 157 | 183 | 207 | 6 |
| 169 | 184 | 214 | 242 | 7 |
| 193 | 210 | 245 | 277 | 8 |
| 217 | 237 | 276 | 312 | 9 |
| 241 | 264 | 307 | 347 | 10 |

10 mm fingers

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 160 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 10/10 | 7 | 9000 | 1 | | 50572497 |
| 250 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 10/10 | 7 | 6000 | 1 | s | 50572519 |
| 160 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 10/11 | 7 | 9000 | 1 | | 50572501 |
| 160 | 32,4 | 30,4 | 50 | 2+2 | 3,8 | 10/11 | 8 | 9000 | 1 | s | 50572509 |
| 160 | 32,4 | 30,4 | 50 | 3+3 | 3,8 | 10/11 | 8 | 9000 | 1 | s | 50572508 |
| 250 | 13,4 | 11,4 | 50 | 3+3 | 3,8 | 10/11 | 3 | 6000 | 1 | s | 50572548 |
| 250 | 17,2 | 15,2 | 50 | 3+3 | 3,8 | 10/11 | 4 | 6000 | 1 | s | 50572547 |
| 250 | 21 | 19 | 50 | 3+3 | 3,8 | 10/11 | 5 | 6000 | 1 | s | 50572546 |
| 250 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 10/11 | 7 | 6000 | 1 | | 50572516 |

15 mm fingers

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 170 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 15/15 | 7 | 9000 | 1 | | 50572507 |
| 170 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/15 | 7 | 9000 | 1 | s | 50572503 |
| 260 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/15 | 7 | 6000 | 1 | s | 50572520 |
| 170 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 15/16,5 | 7 | 9000 | 1 | | 50572510 |
| 170 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/16,5 | 7 | 9000 | 1 | s | 50572690 |
| 260 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/16,5 | 7 | 6000 | 1 | | 50572521 |

20 mm fingers with 6.2 mm pitch

| Product features | | | | | | | | | | Order information | | |
|------------------|-----------|-----------|-------------|-----|-------------------|--------------------------------|-------------------------------------|-----------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/20 | 5 | 9000 | | 1 | | 50572512 |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/22 | 5 | 9000 | | 1 | s | 50572514 |
| 260 | 33 | 31 | 50 | 3+3 | 6.2 | 20/20 | 5 | 6000 | | 1 | s | 50572522 |
| 260 | 33 | 31 | 50 | 3+3 | 6.2 | 20/22 | 5 | 6000 | | 1 | | 50572518 |

20 mm fingers with 5.0 mm pitch

| Product features | | | | | | | | | | Order information | | |
|------------------|-----------|-----------|-------------|-----|-------------------|--------------------------------|-------------------------------------|-----------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/20 | 7 | 9000 | | 1 | s | 50572572 |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/22 | 7 | 9000 | | 1 | s | 50572571 |
| 260 | 37 | 35 | 50 | 3+3 | 5.0 | 20/22 | 7 | 6000 | | 1 | s | 50572570 |

15 mm finger joint for PU glue without fiber

| Product features | | | | | | | | | | Order information | | |
|------------------|-----------|-----------|-------------|-----|-------------------|--------------------------------|-------------------------------------|-----------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 170 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 15/15 | 7 | 9000 | | 1 | s | 50577100 |
| 260 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/15 | 7 | 6000 | | 1 | s | 50577101 |

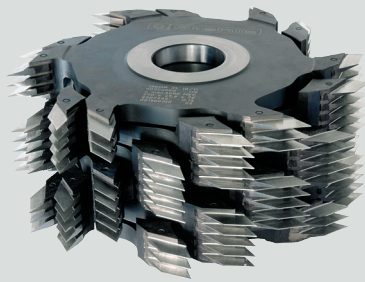
20 mm finger joint for PU glue without fiber

| Product features | | | | | | | | | | Order information | | |
|------------------|-----------|-----------|-------------|-----|-------------------|--------------------------------|-------------------------------------|-----------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/20 | 5 | 9000 | | 1 | s | 50577103 |
| 260 | 33 | 31 | 50 | 3+3 | 6.2 | 20/20 | 5 | 6000 | | 1 | s | 50577104 |

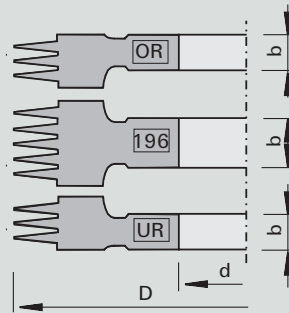
HS 196 Finger Joint Cutters - Real Z=3, Z=4 and Z=6

HS-tipped

Product



Drawing



Machine



Application



Design

HS

MEC



Machine / Application

- high-performance finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in soft woods

Design

- real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min
- cutting material: HS-tipped

Advantages

- constant finger quality even with high feed rates thanks to double number of teeth compared to standard design

Notes

- no. of cutters: see table

10 mm + 15 mm fingers with 3.8 mm pitch

| wood width | No. of cutters |
|------------|----------------|
| 15 | OR + UR |
| 34 | OR + 1 + UR |
| 53 | OR + 2 + UR |
| 72 | OR + 3 + UR |
| 91 | OR + 4 + UR |
| 110 | OR + 5 + UR |
| 129 | OR + 6 + UR |
| 148 | OR + 7 + UR |
| 167 | OR + 8 + UR |
| 186 | OR + 9 + UR |
| 208 | OR + 10 + UR |

20 mm fingers with 6.2 mm pitch

| wood width | No. of cutters |
|------------|----------------|
| 20 | OR + UR |
| 38 | OR + 1 + UR |
| 57 | OR + 2 + UR |
| 76 | OR + 3 + UR |
| 94 | OR + 4 + UR |
| 113 | OR + 5 + UR |
| 132 | OR + 6 + UR |
| 150 | OR + 7 + UR |
| 169 | OR + 8 + UR |
| 187 | OR + 9 + UR |
| 206 | OR + 10 + UR |
| 224 | OR + 11 + UR |
| 243 | OR + 12 + UR |
| 262 | OR + 13 + UR |
| 280 | OR + 14 + UR |

10 mm finger joint / bore 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|----------|--------|--------|----------|---|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| | Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
| OR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | s | 50572675 |
| MI | 250 | 41 | 19 | 50 | 6 | 3,8 | 10/11 | 5 | 6000 | 1 | s | 50572661 |
| UR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | s | 50572676 |

15 mm finger joint / bore 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|----------|--------|--------|----------|---|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| | Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50572666 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/15 | 5 | 9000 | 1 | s | 50572667 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50572668 |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50572669 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/16,5 | 5 | 9000 | 1 | s | 50572670 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50572671 |

15 mm finger joint / bore d= 60 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50572680 NEW |
| MI | 200 | 41 | 19 | 60 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50572681 NEW |
| UR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50572682 NEW |

15 mm finger joint / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50572683 NEW |
| MI | 200 | 41 | 19 | 70 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50572684 NEW |
| UR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50572685 NEW |

20 mm finger joint / bore 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 180 | 27,2 | 16,7 | 50 | 3 | 6,2 | 20/20 | 2 | 9000 | 1 | s | 50572672 |
| MI | 180 | 39,6 | 18,6 | 50 | 3 | 6,2 | 20/20 | 3 | 9000 | 1 | s | 50572673 |
| UR | 180 | 27,2 | 16,7 | 50 | 3 | 6,2 | 20/20 | 2 | 9000 | 1 | s | 50572674 |

20 mm finger joint / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 27,2 | 16,7 | 70 | 4 | 6,2 | 20/20 | 2 | 7000 | 1 | s | 50572686 NEW |
| MI | 200 | 39,6 | 18,6 | 70 | 4 | 5,2 | 20/20 | 3 | 7000 | 1 | s | 50572687 NEW |
| UR | 200 | 27,2 | 16,7 | 70 | 4 | 6,2 | 20/20 | 2 | 7000 | 1 | s | 50572688 NEW |

15 mm finger joint for PU glue without fiber / bore d= 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50577675 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/15 | 5 | 9000 | 1 | s | 50577676 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50577677 |

15 mm finger joint for PU glue without fiber / bore d= 60 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50577684 NEW |
| MI | 200 | 41 | 19 | 60 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50577685 NEW |
| UR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50577686 NEW |

15 mm finger joint for PU glue without fiber / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50577687 NEW |
| MI | 200 | 41 | 19 | 70 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50577688 NEW |
| UR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50577689 NEW |

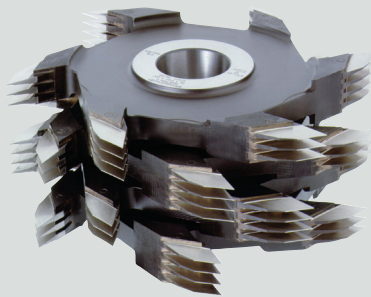
20 mm finger joint for PU glue without fiber / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 27,2 | 16,7 | 70 | 4 | 6,2 | 20/20 | 2 | 7000 | 1 | s | 50577691 NEW |
| MI | 200 | 39,6 | 18,6 | 70 | 4 | 5,2 | 20/20 | 3 | 7000 | 1 | s | 50577692 NEW |
| UR | 200 | 27,2 | 16,7 | 70 | 4 | 6,2 | 20/20 | 2 | 7000 | 1 | s | 50577693 NEW |

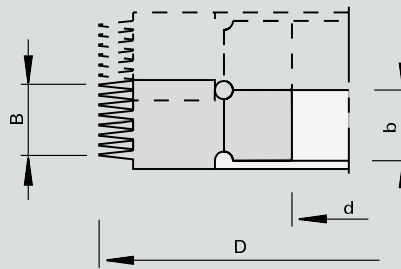
HS 198 Finger Joint Cutters HS-Super - Z=4+4 and Z=6+6

HS -Super

Product



Drawing



Machine



Application



Design



Machine / Application

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

Design

- straight tooth front
- secured against twisting
- cutting material: HS-Super-tipped

Advantages

- 40 % less chips than 10/11
- 2% wood saving compared to 10/11

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of cutters

| 4 mm fingers with B = 26 | 6 mm finger joint with B = 28 | | | |
|-----------------------------|----------------------------------|-----|-----|----|
| 25 | 24 | 28 | 32 | 1 |
| 49 | 51 | 59 | 67 | 2 |
| 73 | 77 | 90 | 102 | 3 |
| 97 | 104 | 132 | 137 | 4 |
| 121 | 131 | 152 | 172 | 5 |
| 145 | 157 | 183 | 207 | 6 |
| 169 | 184 | 214 | 242 | 7 |
| 193 | 210 | 245 | 277 | 8 |
| 217 | 237 | 276 | 312 | 9 |
| 241 | 264 | 307 | 347 | 10 |

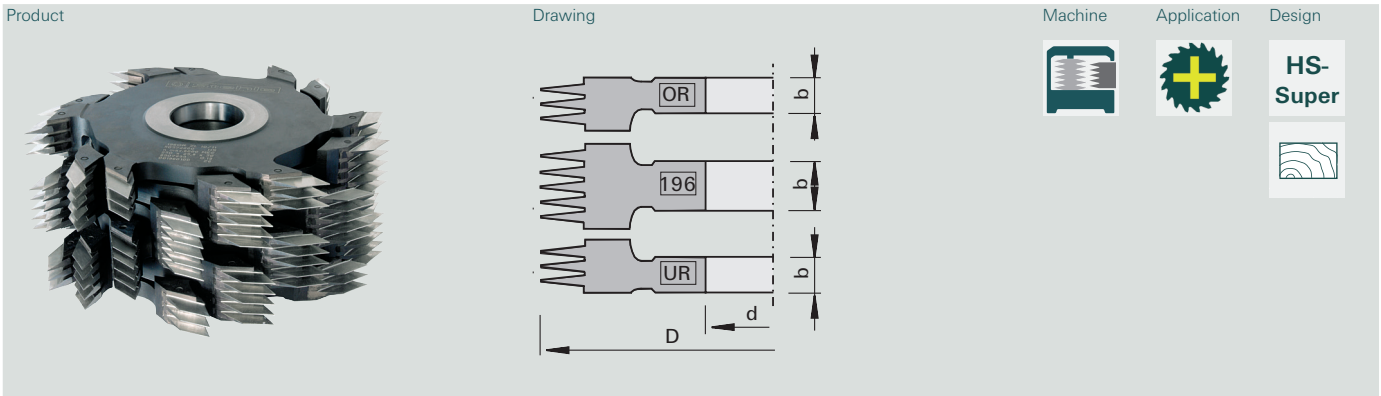
4 mm fingers





| Product features | | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|---------|-------------------|-------|---|-----------|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | | [pc.] | | |
| 160 | 26 | 25.6 | 50 | 2+2 | 1.6 | 4/4 | 16 | 9000 | | 1 | s | 50572490 |

6/7 mm finger joint

| Product features | | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|---------|-------------------|-------|---|---------------------|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | | [pc.] | | |
| 250 | 30 | 28 | 50 | 6+6 | 2.8 | 6/7 | 10 | 6000 | | 1 | s | 50573700 NEW |

HS 196 Finger Joint Cutters - Real Z=8 HS-Super-tipped



Machine  Application  Design 





| Machine / Application | Design | Advantages | Notes |
|---|--|---|---|
| <ul style="list-style-type: none"> high-performance finger joint machines machines with cross-cutting device for longitudinal joints in soft woods | <ul style="list-style-type: none"> real Z=8 for high feed rates up to 72 m/min cutting material: HS-Super tipped | <ul style="list-style-type: none"> up to 33% more output by Z=8 than 6 wings 40% less chips than 10/11 safe 2% wood than 10/11 constant finger quality even with high feed rates thanks | <ul style="list-style-type: none"> no. of cutters: see table |

6 / 7 mm finger joint with pitch 2.8 mm

| wood width | No. of cutters |
|------------|----------------|
| 15 | OR + UR |
| 34 | OR + 1 + UR |
| 53 | OR + 2 + UR |
| 72 | OR + 3 + UR |
| 91 | OR + 4 + UR |
| 110 | OR + 5 + UR |
| 129 | OR + 6 + UR |
| 148 | OR + 7 + UR |
| 167 | OR + 8 + UR |
| 186 | OR + 9 + UR |
| 208 | OR + 10 + UR |

| wood width | No. of cutters |
|------------|----------------|
| 20 | OR + UR |
| 38 | OR + 1 + UR |
| 57 | OR + 2 + UR |
| 76 | OR + 3 + UR |
| 94 | OR + 4 + UR |
| 113 | OR + 5 + UR |
| 132 | OR + 6 + UR |
| 150 | OR + 7 + UR |
| 169 | OR + 8 + UR |
| 187 | OR + 9 + UR |
| 206 | OR + 10 + UR |
| 224 | OR + 11 + UR |
| 243 | OR + 12 + UR |
| 262 | OR + 13 + UR |
| 280 | OR + 14 + UR |

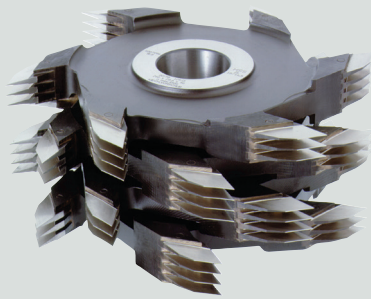
6/7 mm finger joint

| Product features | | | | | | | | | | Order information | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------------------|---|--|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 250 | 21,6 | 12,2 | 50 | 8 | 2,8 | 6/7 | 4 | 6000 | 1 | s | 50573681  |
| MR | 250 | 38,4 | 19,6 | 50 | 8 | 2,8 | 6/7 | 7 | 6000 | 1 | s | 50573682  |
| UR | 250 | 21,6 | 12,2 | 50 | 8 | 2,8 | 6/7 | 4 | 6000 | 1 | s | 50573683  |

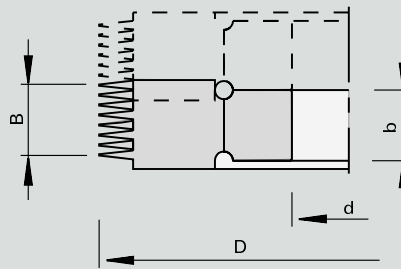
HS 198 Finger Joint Cutters 3 Plus - Z=2+2 and Z=3+3

HS 3-Plus

Product



Drawing



Machine



Application



Design

HS

MEC



Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in knotty soft woods

Design

- cutting material: HS 3-Plus

Advantages

- multiple edge lives compared to traditional HS finger joint cutters
- high bending strength
- reduced risk of tooth breaking

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device
- no. of cutters: see table

Overview

wood width with finger length of

Number of cutters

| | 10 or 15 mm fingers | 20 mm fingers; pitch 6.2 mm | 20 mm fingers; pitch 5.0 mm | |
|--|---------------------|-----------------------------|-----------------------------|----|
| | with B = 28.6 | with B = 33 | with B = 37 | |
| | 24 | 28 | 32 | 1 |
| | 51 | 59 | 67 | 2 |
| | 77 | 90 | 102 | 3 |
| | 104 | 132 | 137 | 4 |
| | 131 | 152 | 172 | 5 |
| | 157 | 183 | 207 | 6 |
| | 184 | 214 | 242 | 7 |
| | 210 | 245 | 277 | 8 |
| | 237 | 276 | 312 | 9 |
| | 264 | 307 | 347 | 10 |

10 mm fingers

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 160 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 10/10 | 7 | 9000 | 1 | s | 50574497 |
| 250 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 10/10 | 7 | 6000 | 1 | s | 50574519 |
| 160 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 10/11 | 7 | 9000 | 1 | s | 50574501 |
| 250 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 10/11 | 7 | 6000 | 1 | s | 50574516 |

15 mm fingers

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 170 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 15/15 | 7 | 9000 | 1 | | 50574507 |
| 260 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 15/15 | 7 | 6000 | 1 | s | 50574520 |
| 170 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 15/16,5 | 7 | 9000 | 1 | s | 50574510 |
| 260 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 15/16,5 | 7 | 6000 | 1 | s | 50574521 |

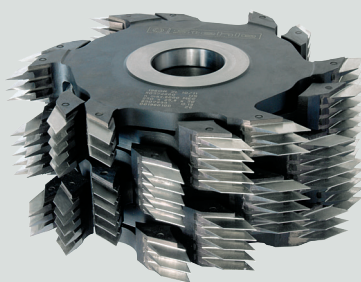
20 mm fingers with 6.2 mm pitch

| Product features | | | | | | | | | | Order information | | |
|------------------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/20 | 5 | 9000 | | 1 | s | 50574512 |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/22 | 5 | 9000 | | 1 | s | 50574514 |

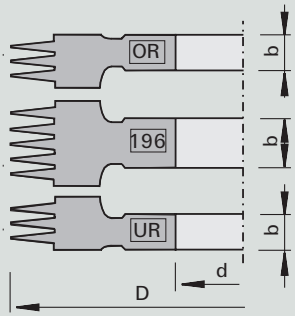
20 mm fingers with 5.0 mm pitch

| Product features | | | | | | | | | | Order information | | |
|------------------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/20 | 7 | 9000 | | 1 | s | 50574572 |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/22 | 7 | 9000 | | 1 | s | 50574571 |



HS 196 High Performance Finger Joint Cutters 3 Plus- Real Z=3, Z=4 and Z=6
HS 3-Plus



Drawing




Machine Application Design

HS

MEC



| Machine / Application | Design | Advantages | Notes |
|--|--|--|---|
| <ul style="list-style-type: none"> • high-performance finger joint machines • machines with and without cross-cutting device • for longitudinal joints in knotty soft woods | <ul style="list-style-type: none"> • real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min • cutting material: HS 3-Plus | <ul style="list-style-type: none"> • multiple edge lives compared to traditional HS finger joint cutters • high bending strength • reduced risk of tooth breaking • constant finger quality even with high feed rates thanks to double number of teeth compared to standard design | <ul style="list-style-type: none"> • extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device |

10 mm + 15 mm fingers with 3.8 mm pitch

| wood width | No. of cutters |
|------------|----------------|
| 15 | OR + UR |
| 34 | OR + 1 + UR |
| 53 | OR + 2 + UR |
| 72 | OR + 3 + UR |
| 91 | OR + 4 + UR |
| 110 | OR + 5 + UR |
| 129 | OR + 6 + UR |
| 148 | OR + 7 + UR |
| 167 | OR + 8 + UR |
| 186 | OR + 9 + UR |
| 208 | OR + 10 + UR |

20 mm fingers with 6.2 mm pitch

| wood width | No. of cutters |
|------------|----------------|
| 20 | OR + UR |
| 38 | OR + 1 + UR |
| 57 | OR + 2 + UR |
| 76 | OR + 3 + UR |
| 94 | OR + 4 + UR |
| 113 | OR + 5 + UR |
| 132 | OR + 6 + UR |
| 150 | OR + 7 + UR |
| 169 | OR + 8 + UR |
| 187 | OR + 9 + UR |
| 206 | OR + 10 + UR |
| 224 | OR + 11 + UR |
| 243 | OR + 12 + UR |
| 262 | OR + 13 + UR |
| 280 | OR + 14 + UR |

10 mm finger joint / bore d= 50 mm

| Product features | | | | | | | | | | Order information | | |
|------------------|----------|--------|--------|----------|---|----------------|--------------------------|-------------------------------|--------------|-------------------|---|-----------|
| | Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
| OR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | s | 50574675 |
| MI | 250 | 41 | 19 | 50 | 6 | 3,8 | 10/11 | 5 | 6000 | 1 | s | 50574661 |
| UR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | s | 50574676 |

15 mm finger joint / bore d= 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50574666 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/15 | 5 | 9000 | 1 | s | 50574667 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50574668 |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50574669 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/16,5 | 5 | 9000 | 1 | s | 50574670 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50574671 |

15 mm finger joint / bore d= 60 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50574680 NEW |
| MI | 200 | 41 | 19 | 60 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50574681 NEW |
| UR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50574682 NEW |

15 mm finger joint / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50574683 NEW |
| MI | 200 | 41 | 19 | 70 | 4 | 3,8 | 15/15 | 5 | 7000 | 1 | s | 50574684 NEW |
| UR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 | 3 | 7000 | 1 | s | 50574685 NEW |

15 mm finger joint for PU glue without fiber / bore d= 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 PU | 3 | 8000 | 1 | s | 50578666 NEW |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/15 PU | 5 | 8000 | 1 | s | 50578667 NEW |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 PU | 3 | 8000 | 1 | s | 50578668 NEW |

15 mm finger joint for PU glue without fiber / bore d= 60 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 PU | 3 | 7000 | 1 | s | 50578684 NEW |
| MI | 200 | 41 | 19 | 60 | 4 | 3,8 | 15/15 PU | 5 | 7000 | 1 | s | 50578685 NEW |
| UR | 200 | 25,8 | 14,8 | 60 | 4 | 3,8 | 15/15 PU | 3 | 7000 | 1 | s | 50578686 NEW |

15 mm finger joint for PU glue without fiber / bore d= 70 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 PU | 3 | 7000 | 1 | s | 50578687 NEW |
| MI | 200 | 41 | 19 | 70 | 4 | 3,8 | 15/15 PU | 5 | 7000 | 1 | s | 50578688 NEW |
| UR | 200 | 25,8 | 14,8 | 70 | 4 | 3,8 | 15/15 PU | 3 | 7000 | 1 | s | 50578689 NEW |

20 mm finger joint / bore d= 50 mm

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 180 | 27,2 | 16,7 | 50 | 3 | 6,2 | 20/20 | 2 | 9000 | 1 | s | 50574672 |
| MI | 180 | 39,6 | 18,6 | 50 | 3 | 6,2 | 20/20 | 3 | 9000 | 1 | s | 50574673 |
| UR | 180 | 27,2 | 16,7 | 50 | 3 | 6,2 | 20/20 | 2 | 9000 | 1 | s | 50574674 |

20 mm finger joint / bore d= 70 mm

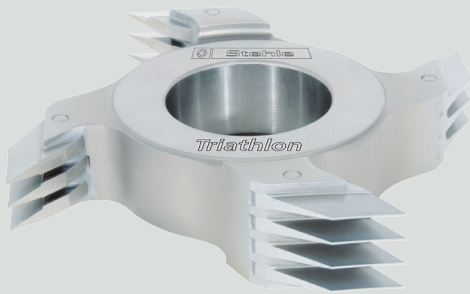
| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 27,2 | 16.7 | 70 | 4 | 6.2 | 20/20 | 2 | 7000 | 1 | s | 50574686 NEW |
| MI | 200 | 39,6 | 18.6 | 70 | 4 | 6.2 | 20/20 | 3 | 7000 | 1 | s | 50574687 NEW |
| UR | 200 | 27,2 | 16.7 | 70 | 4 | 6.2 | 20/20 | 2 | 7000 | 1 | s | 50574688 NEW |

20 mm finger joint for PU glue without fiber / bore d= 70 mm

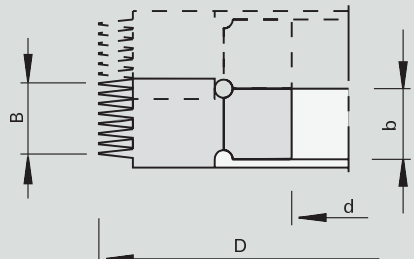
| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|---------------------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 200 | 27,2 | 16.7 | 70 | 4 | 6.2 | 20/20 PU | 2 | 7000 | 1 | s | 50578691 NEW |
| MI | 200 | 39,6 | 18.6 | 70 | 4 | 6.2 | 20/20 PU | 3 | 7000 | 1 | s | 50578692 NEW |
| UR | 200 | 27,2 | 16.7 | 70 | 4 | 6.2 | 20/20 PU | 2 | 7000 | 1 | s | 50578693 NEW |

HS 197 Finger Joint Cutters "TRIATHLON" - Z=2+2 and Z=3+3
HS-tipped


Product




Drawing



Machine




Application



Design

HS

MEC



| Machine / Application | Design | Advantages | Notes |
|--|---|---|--|
| <ul style="list-style-type: none"> • finger joint machines • machines with and without cross-cutting device • for longitudinal joints in soft woods | <ul style="list-style-type: none"> • cutting material: HS coated "TRIATHLON" | <ul style="list-style-type: none"> • multiple edge lives compared to traditional HS finger joint cutters | <ul style="list-style-type: none"> • extended finger joint profiles 10/11, 15/16.5 and 20/22 only for machines with cross-cutting device • no. of cutters: see table |

Overview

| wood width with finger length of | | | | Number of cutters |
|----------------------------------|---------------------|-----------------------------|-----------------------------|-------------------|
| | 10 or 15 mm fingers | 20 mm fingers; pitch 6.2 mm | 20 mm fingers; pitch 5.0 mm | |
| | with B = 28.6 | with B = 33 | with B = 37 | |
| | 24 | 28 | 32 | 1 |
| | 51 | 59 | 67 | 2 |
| | 77 | 90 | 102 | 3 |
| | 104 | 132 | 137 | 4 |
| | 131 | 152 | 172 | 5 |
| | 157 | 183 | 207 | 6 |
| | 184 | 214 | 242 | 7 |
| | 210 | 245 | 277 | 8 |
| | 237 | 276 | 312 | 9 |
| | 264 | 307 | 347 | 10 |

10 mm fingers

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|-------------------|-------|---|-----------|--|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. | |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | | |
| 160 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 10/10 | 7 | 9000 | 1 | s | 50576497 | |
| 250 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 10/10 | 7 | 6000 | 1 | s | 50576519 | |
| 160 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 10/11 | 7 | 9000 | 1 | s | 50576501 | |
| 250 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 10/11 | 7 | 6000 | 1 | s | 50576516 | |

15 mm fingers

| Product features | | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|---------|-------------------|-------|---|-----------|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | | [pc.] | | |
| 170 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 15/15 | 7 | 9000 | | 1 | s | 50576507 |
| 260 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 15/15 | 7 | 6000 | | 1 | s | 50576520 |
| 170 | 28,6 | 26.6 | 50 | 2+2 | 3.8 | 15/16,5 | 7 | 9000 | | 1 | s | 50576510 |
| 260 | 28,6 | 26.6 | 50 | 3+3 | 3.8 | 15/16,5 | 7 | 6000 | | 1 | s | 50576521 |

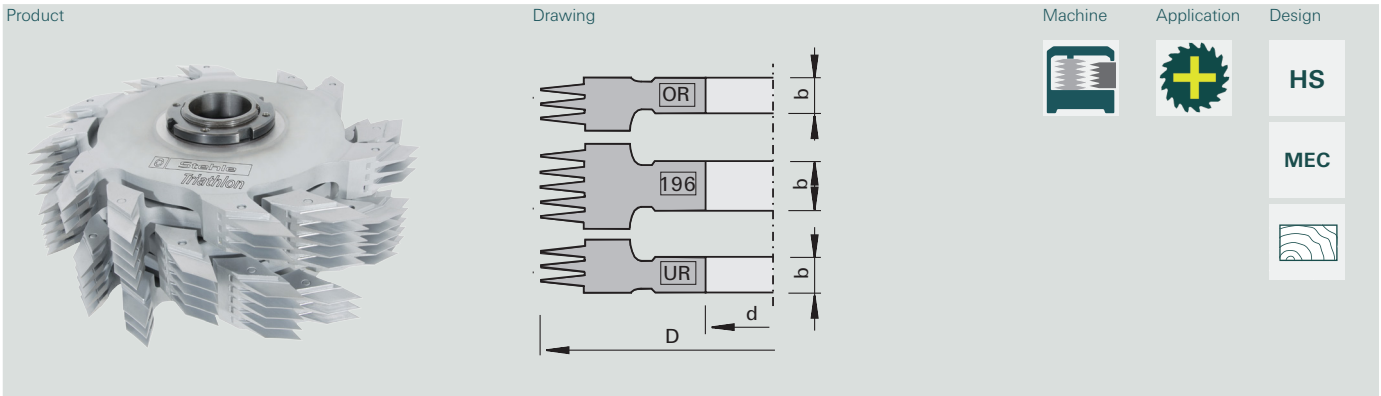
20 mm fingers with 6.2 mm pitch

| Product features | | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|---------|-------------------|-------|---|-----------|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | | [pc.] | | |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/20 | 5 | 9000 | | 1 | s | 50576512 |
| 180 | 33 | 31 | 50 | 2+2 | 6.2 | 20/22 | 5 | 9000 | | 1 | s | 50576514 |

20 mm fingers with 5.0 mm pitch

| Product features | | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|---------|-------------------|-------|---|-----------|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | | [pc.] | | |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/20 | 7 | 9000 | | 1 | s | 50576572 |
| 180 | 37 | 35 | 50 | 2+2 | 5.0 | 20/22 | 7 | 9000 | | 1 | s | 50576571 |

HS 196 High Performance Finger Joint Cutters "TRIATHLON" - Real Z=3, Z=4 and Z=6 HS-tipped



| Machine / Application | Design | Advantages | Notes |
|---|--|--|---|
| <ul style="list-style-type: none"> • high-performance finger joint machines • machines with and without cross-cutting device • for longitudinal joints in soft woods | <ul style="list-style-type: none"> • real Z=3, Z=4 or Z=6 for high feed rates up to 54 m/min • cutting material: HS coated "TRIATHLON" | <ul style="list-style-type: none"> • multiple edge lives compared to traditional HS finger joint cutters • high bending strength • reduced risk of tooth breaking • constant finger quality even with high feed rates thanks to double number of teeth compared to standard design | <ul style="list-style-type: none"> • extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device |

| 10 mm + 15 mm fingers with 3.8 mm pitch | |
|---|----------------|
| wood width | No. of cutters |
| 15 | OR + UR |
| 34 | OR + 1 + UR |
| 53 | OR + 2 + UR |
| 72 | OR + 3 + UR |
| 91 | OR + 4 + UR |
| 110 | OR + 5 + UR |
| 129 | OR + 6 + UR |
| 148 | OR + 7 + UR |
| 167 | OR + 8 + UR |
| 186 | OR + 9 + UR |
| 208 | OR + 10 + UR |

| 20 mm fingers with 6.2 mm pitch | |
|---------------------------------|----------------|
| wood width | No. of cutters |
| 20 | OR + UR |
| 38 | OR + 1 + UR |
| 57 | OR + 2 + UR |
| 76 | OR + 3 + UR |
| 94 | OR + 4 + UR |
| 113 | OR + 5 + UR |
| 132 | OR + 6 + UR |
| 150 | OR + 7 + UR |
| 169 | OR + 8 + UR |
| 187 | OR + 9 + UR |
| 206 | OR + 10 + UR |
| 224 | OR + 11 + UR |
| 243 | OR + 12 + UR |
| 262 | OR + 13 + UR |
| 280 | OR + 14 + UR |

10 mm fingers

| Product features | | | | | | | | | | Order information | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------------------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | | 50576675 |
| MI | 250 | 41 | 19 | 50 | 6 | 3,8 | 10/11 | 5 | 6000 | 1 | | 50576661 |
| UR | 250 | 26,4 | 15,4 | 50 | 6 | 3,8 | 10/11 | 3 | 6000 | 1 | | 50576676 |

15 mm fingers

| Product features | | | | | | | | | | Order information | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------------------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50576666 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/15 | 5 | 9000 | 1 | s | 50576667 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/15 | 3 | 9000 | 1 | s | 50576668 |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50576669 |
| MI | 170 | 41 | 19 | 50 | 4 | 3,8 | 15/16,5 | 5 | 9000 | 1 | s | 50576670 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3,8 | 15/16,5 | 3 | 9000 | 1 | s | 50576671 |

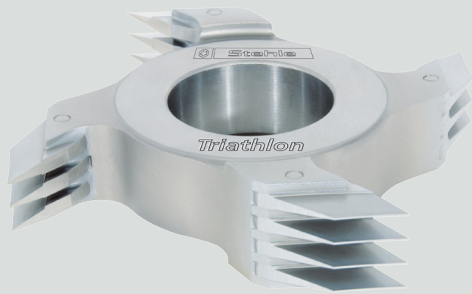
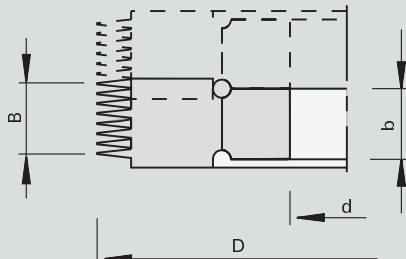



20 mm fingers

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 180 | 27,2 | 16,7 | 50 | 3 | 6.2 | 20/20 | 2 | 9000 | 1 | s | 50576672 |
| MI | 180 | 39,6 | 18,6 | 50 | 3 | 6.2 | 20/20 | 3 | 9000 | 1 | s | 50576673 |
| UR | 180 | 27,2 | 16,7 | 50 | 3 | 6.2 | 20/20 | 2 | 9000 | 1 | s | 50576674 |

15 mm finger joint for PU glue without fiber

| Product features | | | | | | | | Order information | | | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------|---|-----------|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 170 | 25,8 | 14,8 | 50 | 4 | 3.8 | 15/15 | 3 | 9000 | 1 | s | 50577678 |
| MI | 170 | 41 | 19 | 50 | 4 | 3.8 | 15/15 | 5 | 9000 | 1 | s | 50577679 |
| UR | 170 | 25,8 | 14,8 | 50 | 4 | 3.8 | 15/15 | 3 | 9000 | 1 | s | 50577680 |

HS 198 Finger Joint Cutters "TRIATHLON" - Z=6+6
HS-Super tipped

| Product | Drawing | Machine | Application | Design |
|--|---|---|---|---|
|  |  |  |  | <p>HS-Super</p> <p>MEC</p>  |

| Machine / Application | Design | Advantages | Notes |
|--|---|---|---|
| <ul style="list-style-type: none"> • finger joint machines • machines with cross-cutting device • for longitudinal joints in soft woods | <ul style="list-style-type: none"> • cutting material: HS-Super coated "TRIATHLON" | <ul style="list-style-type: none"> • multiple edge lives compared to traditional HS finger joint cutters | <ul style="list-style-type: none"> • extended finger joint profiles 6/7 only for machines with cross-cutting device • no. of cutters: see table |

Overview

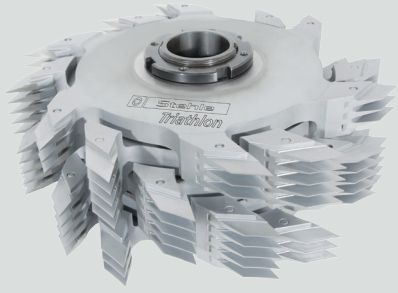
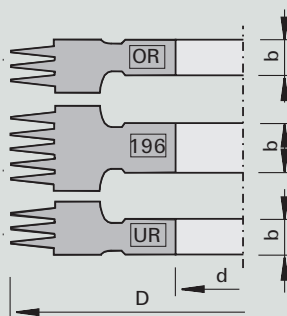



| wood width with finger length of | Number of cutters |
|----------------------------------|-------------------|
| 23 | 1 |
| 51 | 2 |
| 79 | 3 |
| 107 | 4 |
| 135 | 5 |
| 163 | 6 |
| 191 | 7 |
| 219 | 8 |
| 247 | 9 |
| 275 | 10 |

6/7 mm finger joint

| Product features | | | | | | | | Order information | | | |
|------------------|------|------|------|-----|-----------|---------------------|-------------------------|-------------------|-------|---|--|
| Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| 250 | 30 | 28 | 50 | 6+6 | 2.8 | 6/7 | 10 | 6000 | 1 | s | 50576700 NEW |

HS 196 High Performance Finger Joint Cutters "TRIATHLON" - Real Z=8

HS-Super tipped

| | | | | |
|--|--|--|--|--|
| <p>Product</p>  | <p>Drawing</p>  | <p>Machine</p>  | <p>Application</p>  | <p>Design</p> <div style="border: 1px solid black; padding: 2px; text-align: center;"> HS-Super </div> <div style="border: 1px solid black; padding: 2px; text-align: center;"> MEC </div>  |
|--|--|--|--|--|

| Machine / Application | Design | Advantages | Notes |
|---|--|--|---|
| <ul style="list-style-type: none"> • high-performance finger joint machines • machines with cross-cutting device • for longitudinal joints in soft woods | <ul style="list-style-type: none"> • real Z=8 for high feed rates up to 72 m/min • cutting material: HS-Super coated "TRIATHLON" | <ul style="list-style-type: none"> • multiple edge lives compared to traditional HS finger joint cutters • high bending strength • reduced risk of tooth breaking • constant finger quality even with high feed rates thanks to double number of teeth compared to standard design | <ul style="list-style-type: none"> • extended finger joint profiles 6/7 for machines with cross-cutting device |

| 10 mm + 15 mm fingers with 3.8 mm pitch | |
|---|----------------|
| wood width | No. of cutters |
| 15 | OR + UR |
| 34 | OR + 1 + UR |
| 53 | OR + 2 + UR |
| 72 | OR + 3 + UR |
| 91 | OR + 4 + UR |
| 110 | OR + 5 + UR |
| 129 | OR + 6 + UR |
| 148 | OR + 7 + UR |
| 167 | OR + 8 + UR |
| 186 | OR + 9 + UR |
| 208 | OR + 10 + UR |

| 20 mm fingers with 6.2 mm pitch | |
|---------------------------------|----------------|
| wood width | No. of cutters |
| 20 | OR + UR |
| 38 | OR + 1 + UR |
| 57 | OR + 2 + UR |
| 76 | OR + 3 + UR |
| 94 | OR + 4 + UR |
| 113 | OR + 5 + UR |
| 132 | OR + 6 + UR |
| 150 | OR + 7 + UR |
| 169 | OR + 8 + UR |
| 187 | OR + 9 + UR |
| 206 | OR + 10 + UR |
| 224 | OR + 11 + UR |
| 243 | OR + 12 + UR |
| 262 | OR + 13 + UR |
| 280 | OR + 14 + UR |

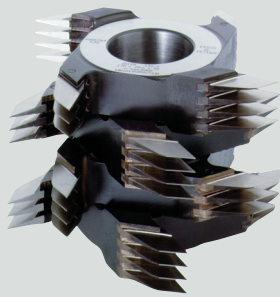
6 mm finger joint

| Product features | | | | | | | | | | Order information | | |
|------------------|------|------|------|------|---|-----------|---------------------|-------------------------|---------|-------------------|---|--|
| | Ø D | B | b | Ø d | Z | Partition | Finger joint length | Number of finger joints | nmax | PU | L | Order-No. |
| | [mm] | [mm] | [mm] | [mm] | | [mm] | [mm] | [pc.] | [min-1] | [pc.] | | |
| OR | 250 | 21,6 | 12.2 | 50 | 8 | 2.8 | 6/7 | 4 | 6000 | 1 | s | 50577681 NEW |
| MI | 250 | 38,4 | 19.6 | 50 | 8 | 2.8 | 6/7 | 7 | 6000 | 1 | s | 50577682 NEW |
| UR | 250 | 21,6 | 12.2 | 50 | 8 | 2.8 | 6/7 | 4 | 6000 | 1 | s | 50577683 NEW |

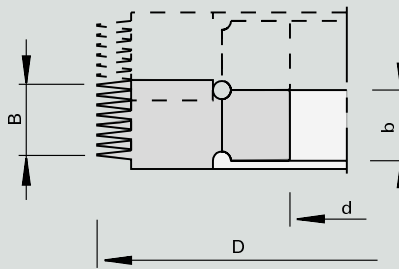
HW 198 Finger Joint Cutters - Z=2+2 and Z=3+3

HW-tipped

Product



Drawing



Machine



Application



Design



HW

MEC

Machine / Application

- finger joint machines
- machines with and without cross-cutting device
- for longitudinal joints in hard and exotic woods

Design

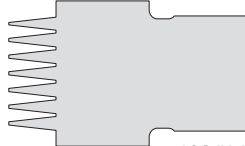
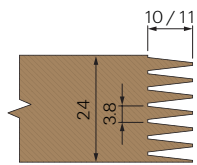
- cutting material: HW

Advantages

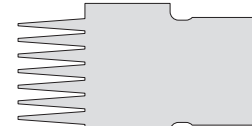
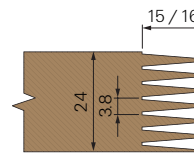
- multiple edge lives compared to traditional HS finger joint cutters

Notes

- extended finger joint profiles 10/11, 15/16,5 and 20/22 only for machines with cross-cutting device



198/H 198 160x28,6x50
(250x28,6x50)



198/H 198 170x28,6x50
(260x28,6x50)

10 mm fingers

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 160 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 10/10 | 7 | 9000 | 1 | s | 50640100 |
| 250 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 10/10 | 7 | 6000 | 1 | s | 50640105 |
| 160 | 9,6 | 7,6 | 50 | 2+2 | 3,8 | 10/11 | 2 | 9000 | 1 | s | 50640121 |
| 160 | 13,4 | 11,4 | 50 | 2+2 | 3,8 | 10/11 | 3 | 9000 | 1 | s | 50640122 |
| 250 | 13,4 | 11,4 | 50 | 3+3 | 3,8 | 10/11 | 3 | 9000 | 1 | s | 50640111 |
| 160 | 17,2 | 15,2 | 50 | 2+2 | 3,8 | 10/11 | 4 | 9000 | 1 | s | 50640123 |
| 250 | 17,2 | 15,2 | 50 | 3+3 | 3,8 | 10/11 | 4 | 6000 | 1 | s | 50640110 |
| 160 | 21 | 19 | 50 | 2+2 | 3,8 | 10/11 | 5 | 9000 | 1 | s | 50640124 |
| 250 | 21 | 19 | 50 | 3+3 | 3,8 | 10/11 | 5 | 6000 | 1 | s | 50640109 |
| 160 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 10/11 | 7 | 9000 | 1 | | 50640101 |
| 250 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 10/11 | 7 | 6000 | 1 | s | 50640106 |

15 mm fingers

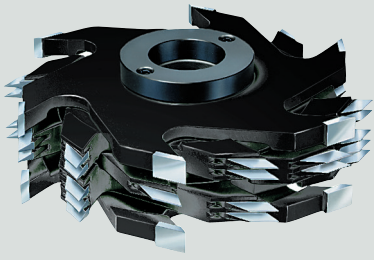




Product features

Order information

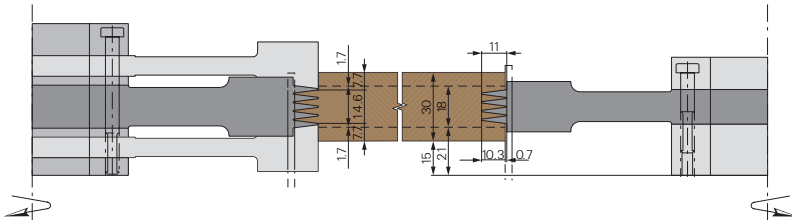
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | PU [pc.] | L | Order-No. |
|----------|--------|--------|----------|-----|----------------|--------------------------|-------------------------------|--------------|----------|---|-----------|
| 170 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 15/15 | 7 | 9000 | 1 | s | 50640102 |
| 260 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/15 | 7 | 6000 | 1 | s | 50640107 |
| 170 | 28,6 | 26,6 | 50 | 2+2 | 3,8 | 15/16,5 | 7 | 9000 | 1 | s | 50640103 |
| 260 | 28,6 | 26,6 | 50 | 3+3 | 3,8 | 15/16,5 | 7 | 6000 | 1 | s | 50640108 |

HS 194 Edge Finger Joint Cutters

HS/HW-tipped

| | | | | |
|---|---------|---|---|---|
| Product | Drawing | Machine | Application | Design |
|  | |  |  |  |
| | | | | MAN |
| | | | | MEC |
| | | | |  |

| Machine / Application | Design | Advantages | Notes |
|--|---|------------|---|
| <ul style="list-style-type: none"> finger joint machines machines with cross-cutting device for longitudinal joints with close fit outside joints e.g. windows, furniture parts | <ul style="list-style-type: none"> cutting material: HS-tipped for soft woods cutting material: HW-tipped for hard and exotic woods | | <ul style="list-style-type: none"> suitable for 198 finger joint cutters with finger length 10/11 mm |



HS-tipped

| Product features | | | | | | | | Order information | | | | |
|------------------|----------|--------|----------|---|----------------|--------------------------|--------------|-------------------|--|----------|---|-----------|
| Cutter-no. | Ø D [mm] | B [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | nmax [min-1] | | | PU [pc.] | L | Order-No. |
| 194.1.3 | 250 | 21 | 50 | 6 | 3.8 | 10 | 6000 | MEC | | 1 | s | 50671984 |

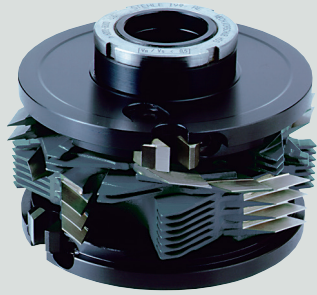
HW-tipped

| Product features | | | | | | | | Order information | | | | |
|------------------|----------|--------|----------|---|----------------|--------------------------|--------------|-------------------|--|----------|---|-----------|
| Cutter-no. | Ø D [mm] | B [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | nmax [min-1] | | | PU [pc.] | L | Order-No. |
| 194.1 | 250 | 21 | 50 | 6 | 3.8 | 10 | 6000 | MAN | | 1 | s | 50671985 |
| 194.3 | 160 | 21 | 50 | 4 | 3.8 | 10 | 9000 | MAN | | 1 | | 50671984 |

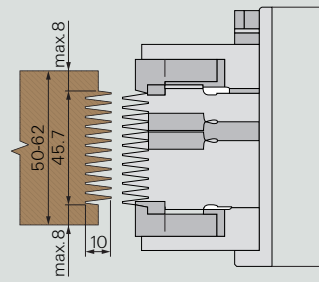
HS 199 Finger Joint Cutters / Edge Finger Joint Cutters

HSS-/TC-tipped, tight-closing without gap on finger-joint edge

Product



Drawing



Machine



Application



Design



MAN

MEC

Machine / Application

- finger joint machines
- cutter 199 can also be applied on table shapers
- for longitudinal joints with close fit finger joint profile possible

Design

- Cutter 198 MEC
- Cutter 199 MAN
- cutting material: HS-tipped for soft woods
- cutting material: HW-tipped for hard and exotic woods

Advantages

- reduced kick-back behaviour at 199 thanks to a reflector comb located in front of the cutting edges

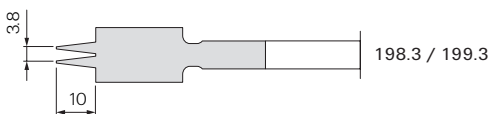
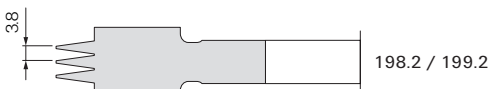
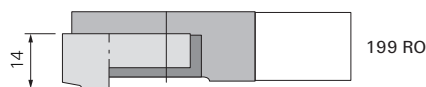
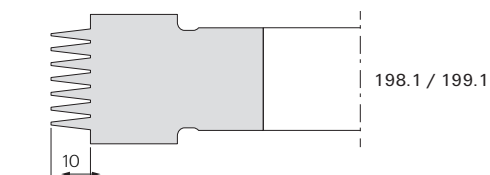
Notes

- edge finger joint cutters can be combined with 199.1 - 199.3 und 198.1 - 198.3

Overview

| finger jointing width ZB | no. of cutters/type: | 198/199.1 | 198/199.2 | 198/199.3 | required length of bushing |
|--------------------------|----------------------|-----------|-----------|-----------|----------------------------|
| 7,6 | | - | - | 1 | 80 |
| 11,4 | | - | 1 | - | 80 |
| 15,2 | | - | - | 2 | 80 |
| 19 | | - | 1 | 1 | 80 |
| 22,8 | | - | 2 | - | 80 |
| 26,6 | | 1 | - | - | 80 |
| 30,4 | | - | 2 | 1 | 112 |
| 34,2 | | 1 | - | 1 | 112 |
| 38 | | 1 | 1 | - | 112 |
| 41,8 | | 1 | - | 2 | 112 |
| 45,6 | | 1 | 1 | 1 | 112 |
| 49,4 | | 1 | 2 | - | 112 |
| 57 | | 1 | 2 | 1 | 130 |
| 64,6 | | 2 | 1 | - | 130 |
| 68,4 | | 2 | - | 2 | 130 |

further finger jointing widths possible



HS-tipped

| Product features | | | | | | | | Order information | | | |
|------------------|-------------|-----------|-------------|-----|-------------------|-------------------------------------|----------------------|-------------------|-------------|---|-----------|
| Cutter-no. | Ø D [mm] | B [mm] | Ø d [mm] | Z | Partition [mm] | Number of finger joints [pc.] | nmin-nmax [min-1] | | PU [pc.] | L | Order-No. |
| 199.1 | 160 | 28,6 | 50 | 2+2 | 3,8 | 7 | 6000-9000 | MAN | 1 | s | 50572530 |
| 199.2 | 160 | 13,4 | 50 | 2+2 | 3,8 | 3 | 6000-9000 | MAN | 1 | s | 50572531 |
| 199.3 | 160 | 9,6 | 50 | 2+2 | 3,8 | 2 | 6000-9000 | MAN | 1 | s | 50572532 |
| 199 RO | 150 | 20 | 50 | 2 | 3,8 | | 6000-8000 | MAN | 1 | s | 50572528 |
| 199 RU | 150 | 20 | 50 | 2 | 3,8 | | 6000-8000 | MAN | 1 | s | 50572529 |
| 198.1 | 160 | 28,6 | 50 | 2+2 | 3,8 | 7 | | MEC | 1 | s | 50572535 |
| 198.2 | 160 | 13,4 | 50 | 2+2 | 3,8 | 3 | | MEC | 1 | s | 50572533 |
| 198.3 | 160 | 9,6 | 50 | 2+2 | 3,8 | 2 | | MEC | 1 | s | 50572534 |

HW-tipped

| Product features | | | | | | | | Order information | | | |
|------------------|-------------|-----------|-------------|-----|-------------------|-------------------------------------|----------------------|-------------------|-------------|---|-----------|
| Cutter-no. | Ø D [mm] | B [mm] | Ø d [mm] | Z | Partition [mm] | Number of finger joints [pc.] | nmin-nmax [min-1] | | PU [pc.] | L | Order-No. |
| 199.1 | 160 | 28,6 | 50 | 2+2 | 3,8 | 7 | 6000-9000 | MAN | 1 | s | 50640114 |
| 199.2 | 160 | 13,4 | 50 | 2+2 | 3,8 | 3 | 6000-9000 | MAN | 1 | s | 50640115 |
| 199.3 | 160 | 9,6 | 50 | 2+2 | 3,8 | 2 | 6000-9000 | MAN | 1 | s | 50640116 |
| 199 RO | 150 | 20 | 50 | 2 | 3,8 | | 6000-8000 | MAN | 1 | s | 50640210 |
| 199 RU | 150 | 20 | 50 | 2 | 3,8 | | 6000-8000 | MAN | 1 | s | 50640211 |
| 198.1 | 160 | 28,6 | 50 | 2+2 | 3,8 | 7 | | MEC | 1 | s | 50640113 |
| 198.2 | 160 | 13,4 | 50 | 2+2 | 3,8 | 3 | | MEC | 1 | s | 50640117 |
| 198.3 | 160 | 9,6 | 50 | 2+2 | 3,8 | 2 | | MEC | 1 | s | 50640118 |

| Spare parts | Dimension [mm] | suitable for | PU [pc.] | L | Order-No. |
|--|-------------------|--------------|-------------|---|-----------|
| Inserts for edge finger joint cutters 199 RO (HS) | | 50572528 | 2 | s | 50572550 |
| Inserts for edge finger joint cutters 199 RO (HW) | | 50640210 | 2 | s | 50640212 |
| Inserts for edge finger joint cutters 199 RU (HS) | | 50572529 | 2 | s | 50572551 |
| Inserts for edge finger joint cutters 199 RU (HW) | | 50640211 | 2 | s | 50640213 |
| Set Screws | M8x16 DIN 6912 | For all | 10 | | 50949533 |
| Set Screws | M12x1x12 SW6 | For all | 10 | | 50930320 |

HS 195 Finger Joint Cutterheads

with exchangeable HS cutting edges

| | | | | |
|---|---|---|---|--|
| Product | Drawing | Machine | Application | Design |
|  |  |  |  | <div style="border: 1px solid black; padding: 2px; text-align: center;">HS</div> <div style="border: 1px solid black; padding: 2px; text-align: center;">MEC</div> <div style="border: 1px solid black; padding: 2px; text-align: center;"></div> |

| | | | |
|--|--|---|-------|
| Machine / Application | Design | Advantages | Notes |
| <ul style="list-style-type: none"> finger joint machines for longitudinal joints in highly stressed components | <ul style="list-style-type: none"> body made from steel 4/6 exchangeable knives (160 mm) or 6/8 exchangeable knives (250 mm) for particularly high feedrates secured against twisting cutting material: HS or HS-TRIATHLON | <ul style="list-style-type: none"> multiple edge lives compared to conventional material, increased edge lives and higher wear resistance and gliding features thanks to TRIATHLON coating | |

Overview

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

195 Finger Joint Cutterhead Body (without knives)

| Product features | | | | | | | Order information | | |
|------------------|-----------|--------|--------|----------|-----|--------------|-------------------|---|-----------|
| Ø D [mm] | Ø D1 [mm] | B [mm] | b [mm] | Ø d [mm] | Z | nmax [min-1] | PU [pc.] | L | Order-No. |
| 129.8 | 160/170 | 30.4 | 30.4 | 50 | 2+2 | 8500 | 1 | s | 50571101 |
| 129.8 | 160/170 | 30.4 | 30.4 | 50 | 3+3 | 8500 | 1 | s | 50571102 |
| 216 | 250/260 | 30.4 | 30.4 | 50 | 2+2 | 6000 | 1 | s | 50571103 |
| 216 | 250/260 | 30.4 | 30.4 | 50 | 3+3 | 6000 | 1 | s | 50571104 |
| 216 | 250/260 | 30.4 | 30.4 | 50 | 4+4 | 6000 | 1 | s | 50571105 |

195 Finger Joint Cutting Edges HS

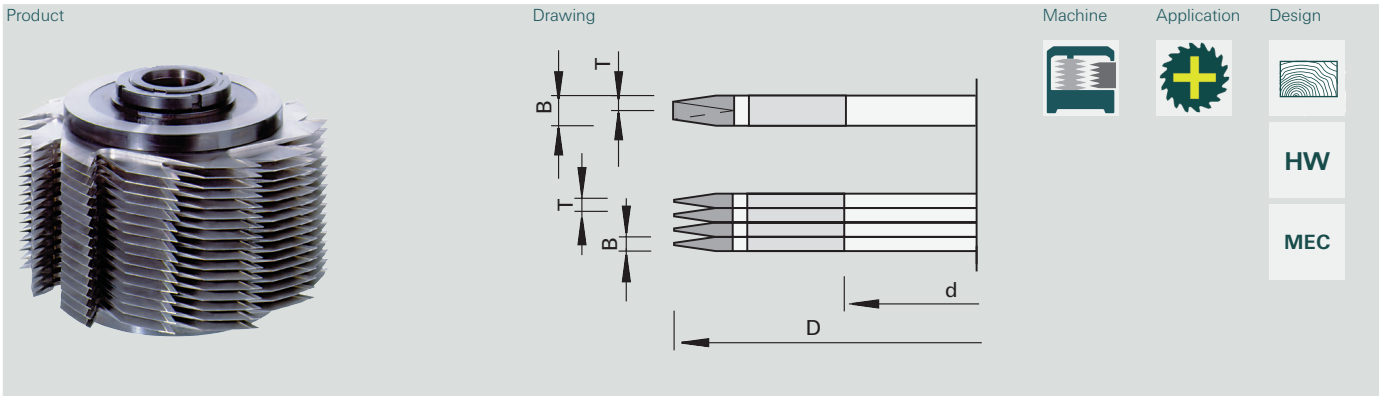
| Knives | PU [pc.] | L | Order-No. |
|---------------------------|----------|---|-----------|
| HS Cutting Insert 10/10 | 4 | | 50570980 |
| HS Cutting Insert 10/11 | 4 | | 50570981 |
| HS Cutting Insert 15/15 | 4 | s | 50570982 |
| HS Cutting Insert 15/16.5 | 4 | s | 50570983 |

195 Finger Joint Cutting Edges HS TRIATHLON

| Knives | PU [pc.] | L | Order-No. |
|-------------------------------------|----------|---|-----------|
| HS TRIATHLON Cutting Insert 10/10 | 4 | | 50576991 |
| HS TRIATHLON Cutting Insert 10/11 | 4 | | 50576993 |
| HS TRIATHLON Cutting Insert 15/15 | 4 | s | 50576997 |
| HS TRIATHLON Cutting Insert 15/16.5 | 4 | | 50576998 |

| Spare parts | Dimension [mm] | PU [pc.] | L | Order-No. |
|---|-----------------------|----------|---|-----------|
| Set Screws - with hexagon socket and dog point | M8x20 DIN EN ISO 4028 | 10 | | 001625 |
| Screwdrivers with sliding handle for hexagon socket | SW4x100 | 1 | | 166091 |

HW 200 Finger Joint Cutters / Edge Finger Joint Cutters disc-type pitch 3.8 mm



Machine Application Design



HW

MEC

| Machine / Application | Design | Advantages | Notes |
|---|---|--|---|
| <ul style="list-style-type: none"> • finger joint machines • machines with cross-cutting device • for end grain finger jointing of hard and soft woods • joint with or without glue gap | <ul style="list-style-type: none"> • high-tensile steel body • cutting material: HW | <ul style="list-style-type: none"> • extremely long edge lives thanks to the special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges | <ul style="list-style-type: none"> • adjustable to any wood thickness with bushing |

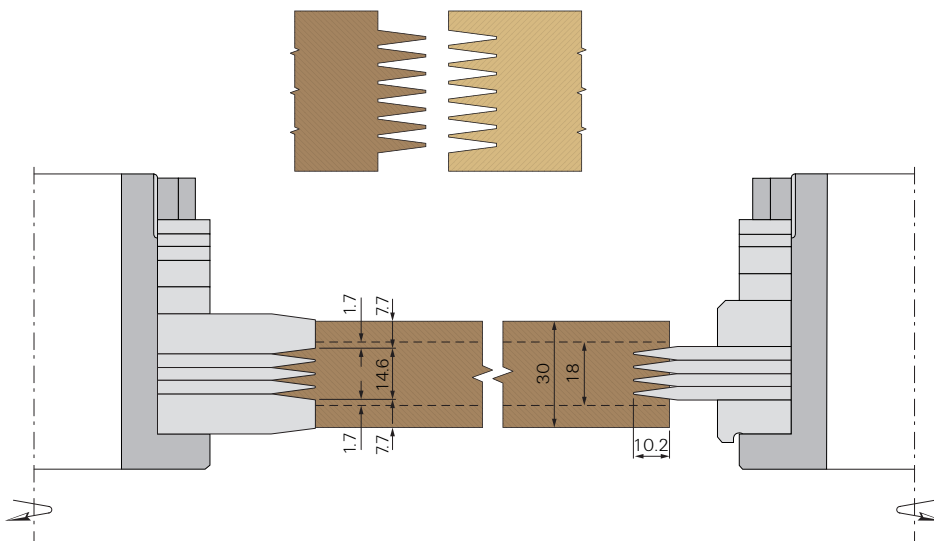
Finger Joint Cutters

| Product features | | | | | | | | | | Order information | | |
|------------------|--------|--------|----------|---|----------------|--------------------------|-------------------------------|--------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 160 | 3,8 | 3,8 | 70 | 4 | 3,8 | 10/11 | 4 | 11800 | | 1 | | 50640178 |
| 250 | 3,8 | 3,8 | 70 | 6 | 3,8 | 10/11 | 6 | 7400 | | 1 | | 50640173 |

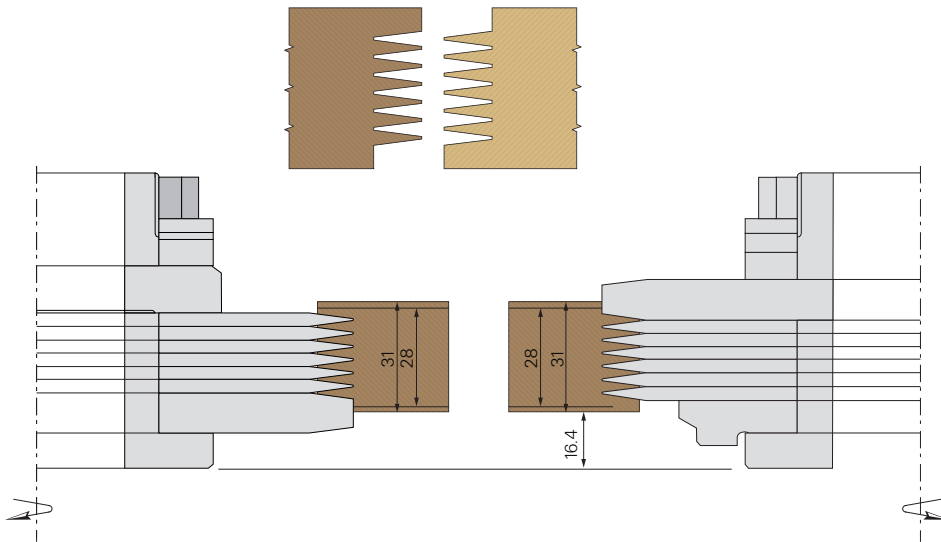
Edge finger Joint Cutter

| Product features | | | | | | | | | | Order information | | |
|------------------|--------|--------|----------|---|----------------|--------------------------|-------------------------------|--------------|--|-------------------|---|-----------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Partition [mm] | Finger joint length [mm] | Number of finger joints [pc.] | nmax [min-1] | | PU [pc.] | L | Order-No. |
| 160 | 15,2 | 15,2 | 70 | 4 | 3,8 | 10/11 | 4 | 11800 | | 1 | s | 50640185 |
| 250 | 15,2 | 15,2 | 70 | 6 | 3,8 | 10/11 | 6 | 7400 | | 1 | | 50640184 |

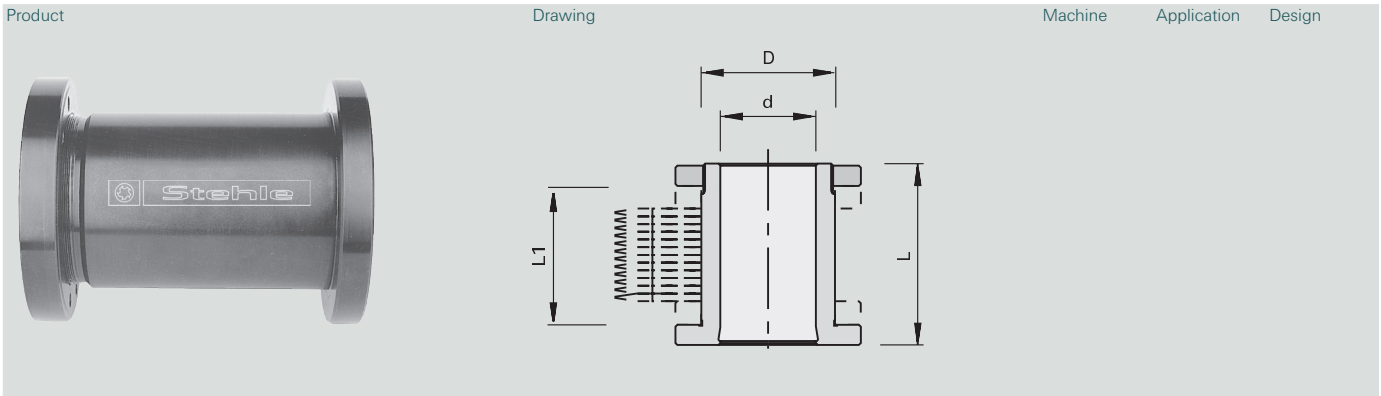
working on two spindles with double-sided butt joint (single sided)



working on two spindles with double-sided butt joint (staggered)



Bushings for Finger Joint Cutters



| Machine / Application | Design | Advantages | Notes |
|--|--|---|---|
| <ul style="list-style-type: none"> for clamping of finger joint cutters and edge finger joint cutters | <ul style="list-style-type: none"> high-tensile steel body spacers \varnothing 97 mm for cutters \varnothing 160-210 mm (not required) | <ul style="list-style-type: none"> high concentric and runout accuracy for varying wood thicknesses | <ul style="list-style-type: none"> fill intermediate sizes with spacers for cutter \varnothing 250 mm install at least one spacer \varnothing 177 on top and bottom fastening nut or hydraulic clamping for cutter attachment must be ordered separately for cutter sets over 100 mm height we recommend hydraulic clamping the bushing length depends on the wood height "H" and on the type of nut accessories: mounting device, mounting ring and wrench is imperative for self-resharpening |

| Product features | | | | Order information | | | | |
|-------------------------|----------------------|----------------|----------------------|-------------------|----------------------|-----------|---|-----------|
| \varnothing D [mm] | \varnothing d [mm] | L [mm] | L1 [mm] | PU [pc.] | L | Order-No. | | |
| 70 | 50 | 90 | 57 | 1 | | 178188 | | |
| 70 | 50 | 120 | 87 | 1 | | 181035 | | |
| 70 | 50 | 130 | 97 | 1 | | 178171 | | |
| 70 | 50 | 195 | 162 | 1 | | 178172 | | |
| 70 | 50 | 220 | 187 | 1 | s | 178173 | | |
| 70 | 50 | 240 | 207 | 1 | | 178174 | | |
| Spacer Rings | | | \varnothing D [mm] | B [mm] | \varnothing d [mm] | PU [pc.] | L | Order-No. |
| | | | 100 | 7,6 | 70 | 1 | | 180940 |
| | | | 100 | 11,4 | 70 | 1 | | 180941 |
| | | | 175 | 7,6 | 70 | 1 | | 186163 |
| | | | 175 | 11,4 | 70 | 1 | | 181034 |
| Spare parts | | Dimension [mm] | PU [pc.] | L | Order-No. | | | |
| Mounting Devices | | | 1 | | 177103 | | | |
| Mounting Rings | | 96x70x60 | 1 | | 177546 | | | |
| Pin-type face wrenches | | | 1 | | 177102 | | | |
| Face Nuts | | M68x1,5x14 | 1 | | 177104 | | | |
| Hydraulic Clamping Nuts | | M68x1,5x56 | 1 | | 178787 | | | |
| Screwdrivers | | SW4x100 | 1 | | 166091 | | | |

Saw Hoggers HW for finger jointing lines without bushing

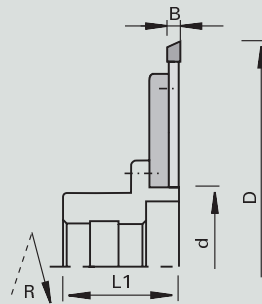
Product

Drawing

Machine

Application

Design



HW

MEC

Machine / Application

Design

Advantages

Notes

- finger joint machines
- for chip-free cross-cutting of solid woods

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

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

Product features

Order information

| Ø D [mm] | B [mm] | b [mm] | L1 [mm] | Ø d [mm] | Z | DKN [mm] | | | PU [pc.] | L | Order-No. [L] | L | Order-No. [R] | |
|--------------------------------|--------|----------------------|---------|----------|-------|----------|--------|--|----------|----------|---------------|---------------|---------------|---------------|
| 250 | 8,0 | 44 | 59 | 80 | 60 | 12x3,3 | Grecon | | 1 | ⊕ | 182379 | ⊕ | 182378 | |
| 300 | 8 | 44 | 59 | 80 | 60 | 12x3,3 | Grecon | | 1 | s | 182603 | s | 182604 | |
| 350 | 10 | 44 | 59 | 80 | 60+12 | 12x3,3 | Grecon | | 1 | s | 182609 | s | 182610 | |
| Spare parts | | Dimension [mm] | | | | | | | | PU [pc.] | L | Order-No. [L] | L | Order-No. [R] |
| Hogging Saw Blades | | Ø250x6,3/5xØ75 Z80 | | | | | | | | 1 | | 189033 | | 189032 |
| Hogging Saw Blades | | Ø250x8,0/6,1xØ80 Z60 | | | | | | | | 1 | | 189223 | | 189222 |
| Hogging Saw Blades | | Ø300x8,0/6,1xØ80 Z60 | | | | | | | | 1 | | 189244 | | 189245 |
| Hogging Saw Blades | | Ø350x10,0xØ80 Z60+12 | | | | | | | | 1 | s | 189246 | # | 189247 |
| Flanges | | Ø210x8,4xØ80 | | | | | | | | 1 | | | | 182377 |
| Countersunk Flat Headed Screws | | M8x20 DIN 799 1-8.8 | | | | | | | | 10 | | | | 056378 |
| Countersunk Flat Headed Screws | | M5x12 T20 | | | | | | | | 10 | | | | 166709 |
| Screwdrivers | | T20x100 | | | | | | | | 1 | | | | 166092 |
| Bushings for Grecon | | Ø113x59x40DKN | | | | | | | | 1 | | | | 189100 |
| Bushings for DIMTER | | Ø206x100,3x38 DKN | | | | | | | | 1 | | | | 178294 |

HW Scoring Saw Blades for finger joint machines

Scoring Saw Blades HW - ATB

| | | | | |
|---------|---------|---------|-------------|---|
| Product | Drawing | Machine | Application | Design |
| | | | | <div style="border: 1px solid black; padding: 2px;">3-0-1</div> <div style="border: 1px solid black; padding: 2px;">HW TC06</div> <div style="border: 1px solid black; padding: 2px;">WS</div> |

| | | | |
|--|--|------------|--|
| Machine / Application | Design | Advantages | Notes |
| <ul style="list-style-type: none"> • finger jointing lines Grecon • for scoring of solid woods | <ul style="list-style-type: none"> • 6 countersunk pin holes on both sides each • for left and right hand rotation • tooth configuration: alternate top bevel "WS" • cutting material: HW TC06 | | <ul style="list-style-type: none"> • along and across the grain, from below |

| Product features | | | | | | | | Order information | | | |
|------------------|--------|--------|----------|----|------------------|----------------|-------------------|-------------------|---|-----------|--|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Cutting quality* | Hook angle [°] | NL | PU [pc.] | L | Order-No. | |
| 200 | 7,0 | 4,0 | 75 | 48 | ▲▲▲ | 10 | 2x6/6,5/95 Grecon | 1 | | 189539 | |

HW Scoring Saw Blades for finger joint machines

Scoring Saw Blades HW - top bevel

| | | | | |
|---------|---------|---------|-------------|---|
| Product | Drawing | Machine | Application | Design |
| | | | | <div style="border: 1px solid black; padding: 2px;">3-0-1</div> <div style="border: 1px solid black; padding: 2px;">HW TC06</div> <div style="border: 1px solid black; padding: 2px;">ES</div> |

| | | | |
|--|---|------------|---|
| Machine / Application | Design | Advantages | Notes |
| <ul style="list-style-type: none"> • finger jointing lines Grecon Combipact • for scoring of solid woods | <ul style="list-style-type: none"> • tooth configuration: top bevel "ES (right + left)" • cutting material: HW TC06 | | <ul style="list-style-type: none"> • along and across the grain, from above and below • sense of rotation see drawing |

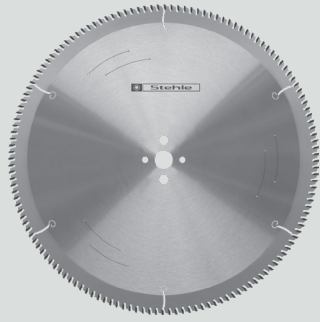
| Product features | | | | | | | | Order information | | | | |
|------------------|--------|--------|----------|----|------------------|----------------|----------|-------------------|---|---------------|---|---------------|
| Ø D [mm] | B [mm] | b [mm] | Ø d [mm] | Z | Cutting quality* | Hook angle [°] | NL | PU [pc.] | L | Order-No. [L] | L | Order-No. [R] |
| 200 | 5,1 | 3,5 | 75 | 48 | ▲▲▲ | 10 | 6/7/95 | 1 | | 188948 | | 188947 |
| 200 | 4,7 | 3,4 | 75 | 64 | ▲▲▲▲ | 10 | 6/6,6/95 | 1 | | 189035 | | 189034 |
| 200 | 6,0 | 4,0 | 75 | 48 | ▲▲▲ | 10 | 6/6,5/95 | 1 | | | | 189540 |

HW

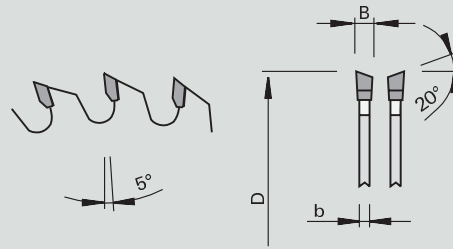
OKW

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

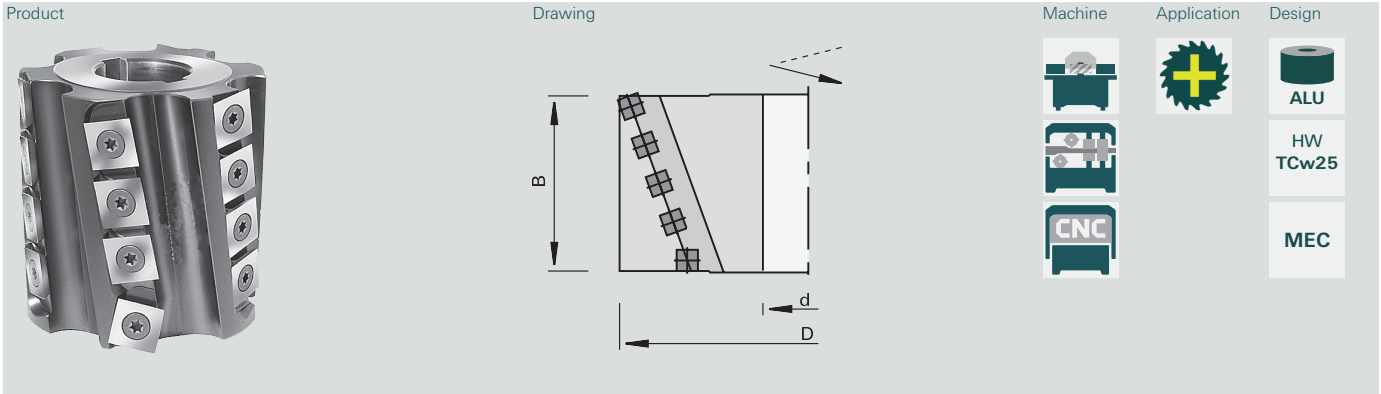
Order information

| Ø D [mm] | B [mm] | b [mm] | Ø 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 Combi2 matches 2/7/42 and 2/9/46 and 2/10/60
For suitable reducing rings see chapter CONSTRUCTION/Saws/Reducing Rings

HW 5570 Spiral Cutterheads with HW turnover knife



| Machine / Application | Design | Advantages | Notes |
|---|--|--|---|
| <ul style="list-style-type: none"> molders stationary milling centers for milling, rough-planing and finish-planing in solid woods | <ul style="list-style-type: none"> with four-sided turnover knives, with rounded edges spiral cutting layout of turnover knives and cut division high-tensile aluminum body | <ul style="list-style-type: none"> easy hogging, low cutting pressure and low noise level | <ul style="list-style-type: none"> for finish cut other dimensions on request |

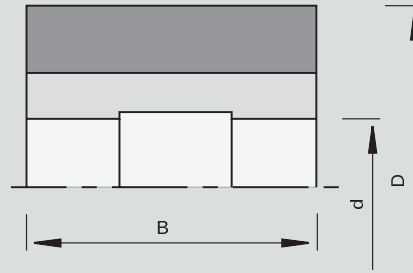
| Product features | | | | | Order information | | | | | | |
|--------------------------------------|--------|----------|----------------|--------------|-------------------|--------|--------|------------------|----------|-----------|-----------|
| Ø D [mm] | B [mm] | Ø d [mm] | Z | nmax [min-1] | | | | PU [pc.] | L | Order-No. | |
| 125 | 100 | 40 | 2+2 | 12000 | | | | 1 | s | 50665050 | |
| 125 | 130 | 40 | 2+2 | 12000 | | | | 1 | s | 50665101 | |
| 125 | 170 | 40 | 2+2 | 12000 | | | | 1 | s | 50665102 | |
| 125 | 230 | 40 | 2+2 | 12000 | | | | 1 | s | 50665103 | |
| 125 | 240 | 40 | 2+2 | 12000 | | | | 1 | s | 50665104 | |
| Turnover Knives | | | | | B [mm] | H [mm] | S [mm] | Cutting material | PU [pc.] | L | Order-No. |
| Turnover Knives (with rounded edges) | | | | | 15 | 15 | 2.5 | TCw20 | 10 | s | 50820017 |
| Spare parts | | | Dimension [mm] | | | | | PU [pc.] | L | Order-No. | |
| Countersunk Flat Headed Screws | | | M5x15,5 T20 | | | | | 10 | | 182112 | |
| Screwdrivers | | | T20x100 | | | | | 1 | | 166092 | |

HS 556-1 Planing Cutterheads

Product



Drawing



Machine



Application



Design

- HW
- HSSL
- HS
- MEC

Machine / Application

- multi spindle planing machines
- for planing of solid woods

Design

- n max = 9,000 min-1

Advantages

Notes

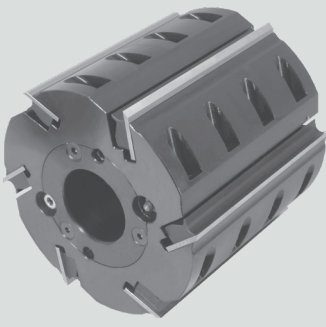
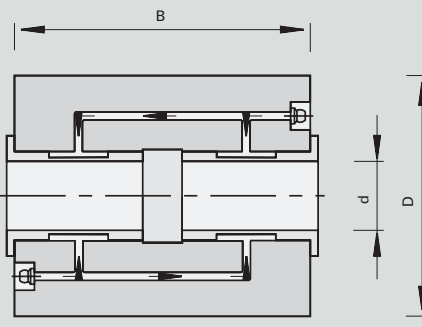


- tipped with HS knives (18%) 30x3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods

Product features

Order information

| Ø D [mm] | B [mm] | Ø d [mm] | Z | | | | | | | PU [pc.] | L | Order-No. |
|---------------------|--------|----------|------------------------|--|--|--|--|--|--|----------|---|-----------|
| 125 | 80 | 40 | 4 | | | | | | | 1 | o | 50561046 |
| 125 | 100 | 40 | 4 | | | | | | | 1 | o | 50561038 |
| 125 | 130 | 40 | 4 | | | | | | | 1 | o | 50561035 |
| 125 | 150 | 40 | 4 | | | | | | | 1 | o | 50561036 |
| 125 | 180 | 40 | 4 | | | | | | | 1 | o | 50561037 |
| 125 | 240 | 40 | 4 | | | | | | | 1 | o | 50561054 |
| Spare parts | | | Dimension [mm] | | | | | | | PU [pc.] | L | Order-No. |
| Clamping Bars | | | B=80 | | | | | | | 2 | o | 179205 |
| Clamping Bars | | | B=100 | | | | | | | 2 | o | 181191 |
| Clamping Bars | | | B=130 | | | | | | | 2 | o | 179198 |
| Clamping Bars | | | B=150 | | | | | | | 2 | o | 179199 |
| Clamping Bars | | | B=180 | | | | | | | 2 | o | 179200 |
| Clamping Bars | | | B=240 | | | | | | | 2 | o | 50562677 |
| Set Screws | | | M10x25 DIN EN ISO 4028 | | | | | | | 10 | | 168108 |
| Cranked Wrench Keys | | | SW5 DIN ISO 2936 | | | | | | | 1 | | 009674 |

HS 520-1 Hydro Planing Cutterheads

| | | | | |
|--|---|--|--|--|
| <p>Product</p>  | <p>Drawing</p>  | <p>Machine</p>  | <p>Application</p>  | <p>Design</p> <div style="border: 1px solid black; padding: 5px; text-align: center;"> <p>HW</p> <hr/> <p>HSSL</p> <hr/> <p>HS</p> <hr/> <p>MEC</p> </div> |
|--|---|--|--|--|

| Machine / Application | Design | Advantages | Notes |
|---|--------|---|---|
| <ul style="list-style-type: none"> hydro profile molders for planing of solid woods | | <ul style="list-style-type: none"> high concentric accuracy and precise tool balancing thanks to Hydro clamping (system Weinig) for precise concentricity tolerance high feed rates and optimum cutting quality | <ul style="list-style-type: none"> HS-tipped knives 30 x 3 mm alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods peripheral application of pressure on request |

| Product features | | | | | | Order information | | |
|------------------|--------|----------|----|--|--------------|-------------------|---|-----------|
| Ø D [mm] | B [mm] | Ø d [mm] | Z | | nmax [min-1] | PU [pc.] | L | Order-No. |
| 143 | 60 | 40 | 4 | | 8500 | 1 | s | 58562686 |
| 143 | 130 | 40 | 4 | | 8500 | 1 | s | 58562689 |
| 143 | 230 | 40 | 4 | | 8500 | 1 | s | 58562990 |
| 163 | 60 | 50 | 4 | | 6000 | 1 | s | 58562687 |
| 163 | 100 | 50 | 4 | | 6000 | 1 | s | 58562691 |
| 163 | 130 | 50 | 4 | | 6000 | 1 | s | 58562741 |
| 163 | 130 | 50 | 4 | | 6000 | 1 | s | 58562693 |
| 163 | 180 | 50 | 4 | | 6000 | 1 | s | 58562700 |
| 163 | 230 | 50 | 4 | | 6000 | 1 | s | 58562695 |
| 163 | 260 | 50 | 4 | | 6000 | 1 | s | 58562697 |
| 163 | 310 | 50 | 4 | | 6000 | 1 | s | 58562701 |
| 163 | 60 | 50 | 6 | | 6000 | 1 | s | 58562688 |
| 163 | 100 | 50 | 6 | | 6000 | 1 | s | 58562692 |
| 163 | 130 | 50 | 6 | | 6000 | 1 | s | 58562742 |
| 163 | 150 | 50 | 6 | | 6000 | 1 | s | 58562694 |
| 163 | 180 | 50 | 6 | | 6000 | 1 | s | 58562702 |
| 163 | 230 | 50 | 6 | | 6000 | 1 | s | 58562696 |
| 163 | 260 | 50 | 6 | | 6000 | 1 | s | 58562698 |
| 163 | 310 | 50 | 6 | | 6000 | 1 | s | 58562703 |
| 163 | 60 | 50 | 8 | | 6000 | 1 | s | 58562738 |
| 163 | 100 | 50 | 8 | | 6000 | 1 | s | 58562740 |
| 163 | 130 | 50 | 8 | | 6000 | 1 | s | 58562739 |
| 163 | 150 | 50 | 8 | | 6000 | 1 | s | 58562743 |
| 163 | 180 | 50 | 8 | | 6000 | 1 | s | 58562750 |
| 163 | 230 | 50 | 8 | | 6000 | 1 | s | 58562744 |
| 163 | 260 | 50 | 8 | | 6000 | 1 | s | 58562745 |
| 163 | 310 | 50 | 8 | | 6000 | 1 | s | 58562751 |
| 203 | 100 | 50 | 12 | | 6000 | 1 | s | 58562752 |
| 203 | 150 | 50 | 12 | | 6000 | 1 | s | 58562753 |
| 203 | 230 | 50 | 12 | | 6000 | 1 | s | 58562754 |
| 203 | 260 | 50 | 12 | | 6000 | 1 | s | 58562755 |
| 203 | 310 | 50 | 12 | | 6000 | 1 | s | 58562756 |
| 203 | 330 | 50 | 12 | | 6000 | 1 | s | 58562757 |

| Spare parts | Dimension [mm] | PU [pc.] | L | Order-No. |
|-------------------|------------------------|----------|---|-----------|
| Set Screws | M12x25 DIN EN ISO 4028 | 10 | | 181466 |
| Screwdrivers | SW6x200 | 1 | | 167817 |
| Grease Guns | | 1 | | 163706 |
| Grease Cartridges | | 1 | | 163707 |

HS 569 Planing Knives HS

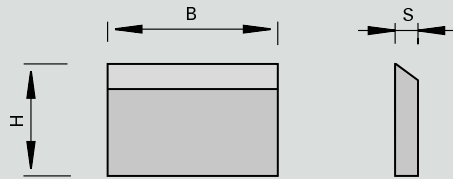
Product

Drawing

Machine

Application

Design



3-0-1

HS
18%



Machine / Application

- for use in planing cutterheads
- also suitable for thermoplastic such as PE, PP, PVC

Design

- cutting material: high speed steel for the machining of soft woods
- wedge angle 40°

Advantages

- HSPlus quality for long edge lives

Notes

- from safety reasons please always mount knives and support plates with equal weight (packing unit VE) opposite each other
- packing unit 2 pieces

Product features


Order information

| B [mm] | H [mm] | S [mm] | PU [pc.] | L | Order-No. |
|--------|--------|--------|----------|---|---------------------------|
| 60 | 30 | 3 | 2 | s | 58400131 NEW |
| 80 | 30 | 3 | 2 | s | 58400132 NEW |
| 100 | 30 | 3 | 2 | | 58400133 NEW |
| 120 | 30 | 3 | 2 | s | 58400134 NEW |
| 130 | 30 | 3 | 2 | | 58400135 NEW |
| 150 | 30 | 3 | 2 | | 58400136 NEW |
| 160 | 30 | 3 | 2 | | 58400137 NEW |
| 170 | 30 | 3 | 2 | | 58400161 NEW |
| 180 | 30 | 3 | 2 | | 58400138 NEW |
| 180 | 35 | 3 | 2 | s | 58400201 NEW |
| 210 | 30 | 3 | 2 | s | 58400162 NEW |
| 230 | 30 | 3 | 2 | | 58400139 NEW |
| 240 | 30 | 3 | 2 | | 58400206 NEW |
| 260 | 30 | 3 | 2 | | 58400163 NEW |
| 300 | 30 | 3 | 2 | | 58400140 NEW |
| 300 | 35 | 3 | 2 | | 58400202 NEW |
| 310 | 30 | 3 | 2 | | 58400147 NEW |
| 310 | 35 | 3 | 2 | s | 58400187 NEW |
| 320 | 30 | 3 | 2 | | 58400205 NEW |
| 330 | 30 | 3 | 2 | s | 58400141 NEW |
| 350 | 30 | 3 | 2 | | 58400198 NEW |
| 350 | 35 | 3 | 2 | s | 58400188 NEW |
| 400 | 30 | 3 | 2 | | 58400170 NEW |
| 400 | 35 | 3 | 2 | s | 58400171 NEW |
| 410 | 30 | 3 | 2 | | 58400149 NEW |
| 410 | 35 | 3 | 2 | | 58400158 NEW |
| 420 | 30 | 3 | 2 | | 58400142 NEW |
| 420 | 35 | 3 | 2 | s | 58400190 NEW |
| 450 | 30 | 3 | 2 | | 58400150 NEW |
| 460 | 30 | 3 | 2 | s | 58400151 NEW |
| 460 | 35 | 3 | 2 | s | 58400192 NEW |
| 500 | 30 | 3 | 2 | | 58400143 NEW |
| 500 | 35 | 3 | 2 | | 58400196 NEW |
| 510 | 30 | 3 | 2 | | 58400152 NEW |
| 510 | 35 | 3 | 2 | | 58400159 NEW |
| 520 | 30 | 3 | 2 | | 58400184 NEW |
| 530 | 30 | 3 | 2 | | 58400144 NEW |
| 530 | 35 | 3 | 2 | | 58400166 NEW |
| 600 | 30 | 3 | 2 | s | 58400165 NEW |
| 600 | 35 | 3 | 2 | | 58400193 NEW |
| 610 | 30 | 3 | 2 | | 58400153 NEW |
| 610 | 35 | 3 | 2 | | 58400160 NEW |

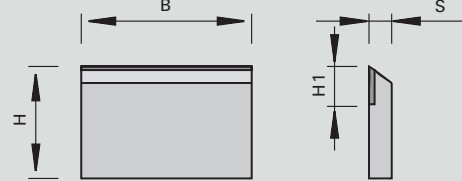
| Product features | | | | | | | Order information | | |
|------------------|--------|--------|--|--|--|--|-------------------|---|---------------------|
| B [mm] | H [mm] | S [mm] | | | | | PU [pc.] | L | Order-No. |
| 630 | 30 | 3 | | | | | 2 | | 58400145 NEW |
| 630 | 35 | 3 | | | | | 2 | | 58400194 NEW |
| 635 | 35 | 3 | | | | | 2 | s | 58400195 NEW |
| 640 | 30 | 3 | | | | | 2 | | 58400154 NEW |
| 640 | 35 | 3 | | | | | 2 | | 58400167 NEW |
| 710 | 30 | 3 | | | | | 2 | s | 58400155 NEW |
| 710 | 35 | 3 | | | | | 2 | | 58400179 NEW |
| 810 | 30 | 3 | | | | | 2 | | 58400156 NEW |
| 810 | 35 | 3 | | | | | 2 | s | 58400164 NEW |
| 840 | 30 | 3 | | | | | 2 | | 58400157 NEW |
| 1000 | 30 | 3 | | | | | 2 | s | 58400185 NEW |
| 1000 | 35 | 3 | | | | | 2 | | 58400168 NEW |
| 1040 | 25 | 3 | | | | | 2 | s | 58400183 NEW |
| 1050 | 30 | 3 | | | | | 2 | | 58400174 NEW |
| 1050 | 35 | 3 | | | | | 2 | | 58400175 NEW |

HW 569 Planing Knives HW


Product




Drawing




Machine



Application



Design



Machine / Application

- for use in planing cutterheads

Design

- cutting material: HW-tipped for hard woods

Advantages

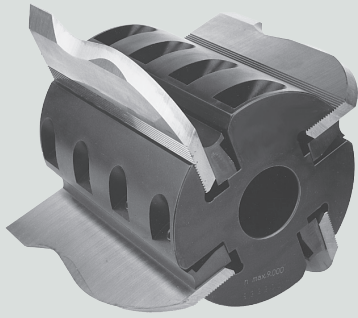
Notes

- packing unit: 2 pieces

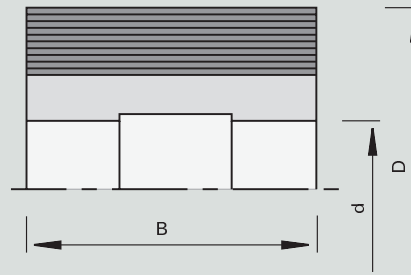
| Product features | | | | | | | Order information | | |
|------------------|--------|--------|---------|--|--|--|-------------------|---|-----------|
| B [mm] | H [mm] | S [mm] | H1 [mm] | | | | PU [pc.] | L | Order-No. |
| 60 | 30 | 3.0 | 11 | | | | 2 | s | 50400021 |
| 100 | 30 | 3.0 | 11 | | | | 2 | s | 50400023 |
| 120 | 30 | 3.0 | 11 | | | | 2 | s | 50400024 |
| 130 | 30 | 3.0 | 11 | | | | 2 | s | 50400025 |
| 150 | 30 | 3.0 | 11 | | | | 2 | s | 50400026 |
| 160 | 30 | 3.0 | 11 | | | | 2 | s | 50400036 |
| 170 | 30 | 3.0 | 11 | | | | 2 | s | 50400027 |
| 180 | 30 | 3.0 | 11 | | | | 2 | s | 50400028 |
| 210 | 30 | 3.0 | 11 | | | | 2 | s | 50400029 |
| 230 | 30 | 3.0 | 11 | | | | 2 | s | 50400030 |
| 260 | 30 | 3.0 | 11 | | | | 2 | s | 50400031 |
| 310 | 30 | 3.0 | 11 | | | | 2 | s | 50400032 |
| 310 | 35 | 3.0 | 11 | | | | 2 | s | 50400073 |
| 400 | 35 | 3.0 | 11 | | | | 2 | s | 50400077 |
| 410 | 30 | 3.0 | 11 | | | | 2 | s | 50400033 |
| 410 | 35 | 3.0 | 11 | | | | 2 | s | 50400074 |
| 460 | 30 | 3.0 | 11 | | | | 2 | s | 50400078 |
| 500 | 30 | 3.0 | 11 | | | | 2 | s | 50400079 |
| 510 | 30 | 3.0 | 11 | | | | 2 | s | 50400034 |
| 510 | 35 | 3.0 | 11 | | | | 2 | s | 50400075 |
| 600 | 30 | 3.0 | 11 | | | | 2 | s | 50400080 |
| 610 | 30 | 3.0 | 11 | | | | 2 | s | 50400035 |
| 640 | 30 | 3.0 | 11 | | | | 2 | s | 50400083 |
| 810 | 30 | 3.0 | 11 | | | | 2 | s | 50400063 |

525 Profile Cutterheads

Product



Drawing



Machine



Application



Design

HS

MEC

Machine / Application

- molders
- for profiling of solid woods

Design

- hook angle 25 degrees

Advantages

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

Notes

- fixed-shape knife clamping by highly precise serration 60 degrees, partition 1.6mm
- adjustable knives
- profile depth and cutting circle diameter see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead with clamping bar

Product features

Order information

| Ø D [mm] | B [mm] | Ø d [mm] | Z | | | | | | | PU [pc.] | L | Order-No. |
|----------|--------|----------|---|--|--|--|--|--|--|----------|---|-----------|
| 122 | 40 | 40 | 4 | | | | | | | 1 | s | 50822780 |
| 122 | 60 | 40 | 4 | | | | | | | 1 | s | 50822781 |
| 122 | 80 | 40 | 4 | | | | | | | 1 | s | 50822782 |
| 122 | 100 | 40 | 4 | | | | | | | 1 | s | 50822783 |
| 122 | 130 | 40 | 4 | | | | | | | 1 | s | 50822784 |
| 122 | 150 | 40 | 4 | | | | | | | 1 | s | 50822785 |
| 122 | 180 | 40 | 4 | | | | | | | 1 | s | 50822786 |
| 122 | 230 | 40 | 4 | | | | | | | 1 | s | 50822787 |
| 137 | 60 | 50 | 4 | | | | | | | 1 | s | 50822790 |
| 137 | 80 | 50 | 4 | | | | | | | 1 | s | 50822791 |
| 137 | 100 | 50 | 4 | | | | | | | 1 | s | 50822792 |
| 137 | 130 | 50 | 4 | | | | | | | 1 | s | 50822793 |
| 137 | 150 | 50 | 4 | | | | | | | 1 | s | 50822794 |
| 137 | 180 | 50 | 4 | | | | | | | 1 | s | 50822795 |
| 137 | 230 | 50 | 4 | | | | | | | 1 | s | 50822798 |

| Spare parts | Dimension [mm] | | | | PU [pc.] | L | Order-No. |
|---------------|------------------------|--|--|--|----------|---|-----------|
| Clamping Bars | B=40 | | | | 2 | o | 179221 |
| Clamping Bars | B=60 | | | | 2 | o | 179222 |
| Clamping Bars | B=80 | | | | 2 | o | 179223 |
| Clamping Bars | B=100 | | | | 2 | o | 179224 |
| Clamping Bars | B=130 | | | | 2 | o | 179225 |
| Clamping Bars | B=150 | | | | 2 | o | 179226 |
| Clamping Bars | B=180 | | | | 2 | o | 179227 |
| Clamping Bars | B=230 | | | | 2 | o | 179228 |
| Dummy Pieces | B=40 | | | | 2 | o | 179229 |
| Dummy Pieces | B=60 | | | | 2 | o | 179230 |
| Dummy Pieces | B=80 | | | | 2 | o | 179231 |
| Dummy Pieces | B=100 | | | | 2 | o | 179232 |
| Dummy Pieces | B=130 | | | | 2 | o | 179233 |
| Dummy Pieces | B=150 | | | | 2 | o | 179234 |
| Dummy Pieces | B=180 | | | | 2 | o | 179235 |
| Dummy Pieces | B=230 | | | | 2 | o | 179236 |
| Set Screws | M10x20 DIN EN ISO 4028 | | | | 10 | | 815807 |
| Screwdrivers | SW5x150 | | | | 1 | | 168703 |

Maximum cutting circle diameter

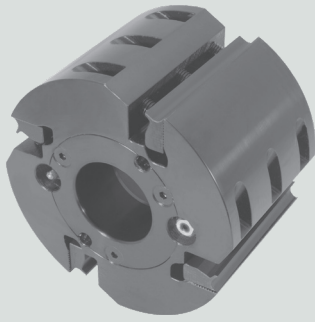
| | HS | HW | ST | HS | HW | HS | ST |
|------------------------|-----|-----|-----|-----|-----|-----|-----|
| Knife height H [mm] | 50 | 50 | 55 | 60 | 60 | 70 | 70 |
| Knife thickness S [mm] | 8 | 10 | 10 | 8 | 10 | 8 | 10 |
| Profile depth T [mm] | 12 | 10 | 15 | 20 | 18 | 30 | 27 |
| Dmax at D=122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

Maximum RPM

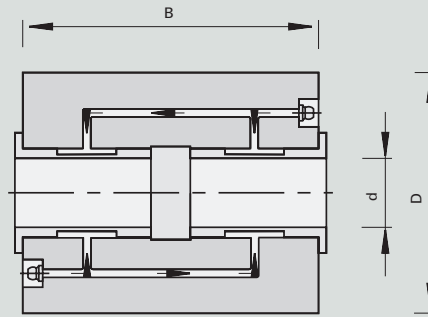
| | 50 | 55 | 60 | 70 | | | |
|---------------------|------|------|------|------|--|--|--|
| Knife height H [mm] | | | | | | | |
| Dmax at D=122 | 161 | 171 | 181 | 201 | | | |
| Max.RPM (min-1): | 9000 | 8400 | 8000 | 7200 | | | |
| Dmax at D=137 | 176 | 186 | 196 | 216 | | | |
| Max.RPM (min-1): |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

521-1 Hydro Profile Cutterheads

Product



Drawing



Machine



Application



Design

HS

MEC

Machine / Application

- hydro profile molders
- for profiling of solid woods

Design

- body made from steel

Advantages

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

Notes

- adjustable knives
- profile depth and cutting circle diameter see table
- for back-serrated blanks S = 5, 8, 10 mm
- included in delivery: cutterhead with clamping bar

Product features

Order information

| Ø D [mm] | B [mm] | Ø d [mm] | Z | | | | | | | PU [pc.] | L | Order-No. |
|----------|--------|----------|---|--|--|--|--|--|--|----------|---|-----------|
| 137 | 60 | 40 | 4 | | | | | | | 1 | o | 58562920 |
| 137 | 100 | 40 | 4 | | | | | | | 1 | o | 58562921 |
| 137 | 130 | 40 | 4 | | | | | | | 1 | o | 58562922 |
| 137 | 150 | 40 | 4 | | | | | | | 1 | o | 58562923 |
| 137 | 180 | 40 | 4 | | | | | | | 1 | o | 58562924 |
| 137 | 230 | 40 | 4 | | | | | | | 1 | o | 58562925 |
| 150 | 60 | 50 | 4 | | | | | | | 1 | o | 58562926 |
| 150 | 60 | 50 | 6 | | | | | | | 1 | o | 58562934 |
| 150 | 100 | 50 | 4 | | | | | | | 1 | o | 58562927 |
| 150 | 100 | 50 | 6 | | | | | | | 1 | o | 58562935 |
| 150 | 130 | 50 | 4 | | | | | | | 1 | o | 58562928 |
| 150 | 130 | 50 | 6 | | | | | | | 1 | o | 58562936 |
| 150 | 150 | 50 | 4 | | | | | | | 1 | o | 58562929 |
| 150 | 150 | 50 | 6 | | | | | | | 1 | o | 58562937 |
| 150 | 180 | 50 | 4 | | | | | | | 1 | o | 58562930 |
| 150 | 180 | 50 | 6 | | | | | | | 1 | o | 58562938 |
| 150 | 230 | 50 | 4 | | | | | | | 1 | o | 58562931 |
| 150 | 230 | 50 | 6 | | | | | | | 1 | o | 58562939 |
| 150 | 260 | 50 | 4 | | | | | | | 1 | o | 58562932 |
| 150 | 260 | 50 | 6 | | | | | | | 1 | o | 58562940 |
| 150 | 310 | 50 | 4 | | | | | | | 1 | o | 58562933 |
| 150 | 310 | 50 | 6 | | | | | | | 1 | o | 58562941 |
| 163 | 60 | 50 | 8 | | | | | | | 1 | o | 58562942 |
| 163 | 100 | 50 | 8 | | | | | | | 1 | o | 58562943 |
| 163 | 130 | 50 | 8 | | | | | | | 1 | o | 58562944 |
| 163 | 150 | 50 | 8 | | | | | | | 1 | o | 58562945 |
| 163 | 180 | 50 | 8 | | | | | | | 1 | o | 58562946 |
| 163 | 230 | 50 | 8 | | | | | | | 1 | o | 58562947 |
| 163 | 260 | 50 | 8 | | | | | | | 1 | o | 58562948 |
| 163 | 310 | 50 | 8 | | | | | | | 1 | o | 58562949 |

Spare parts

Dimension [mm]

| | Dimension [mm] | PU [pc.] | L | Order-No. |
|-------------------|------------------------|----------|---|-----------|
| Set Screws | M12x25 DIN EN ISO 4028 | 10 | | 181466 |
| Screwdrivers | SW6x200 | 1 | | 167817 |
| Grease Guns | | 1 | | 163706 |
| Grease Cartridges | | 1 | | 163707 |

Maximum cutting circle diameter

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

Maximum RPM

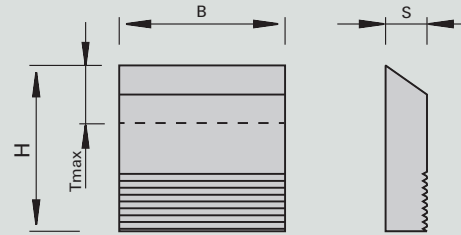
| Knife height H [mm] | 50 | 55 | 60 | 70 | | | |
|---------------------|------|------|------|------|--|--|--|
| Dmax at D=137 | 174 | 184 | 194 | 214 | | | |
| Max.RPM (min-1): | 8300 | 7800 | 7400 | 6700 | | | |
| Dmax at D=150 | 189 | 199 | 209 | 229 | | | |
| Max.RPM (min-1): | 7700 | 7300 | 6900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

HS 525 Blanks with serrated back HS

Product



Drawing



Machine



Application



Design



Machine / Application

- for use in profile cutterheads with serration

Design

- cutting material: HS for soft woods

Advantages

Notes

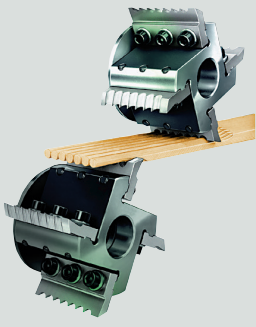
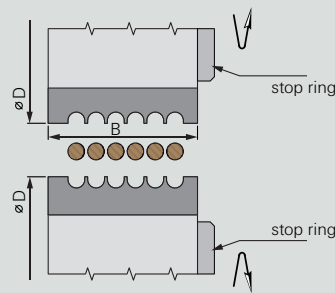


- Tmax = maximum profile depth
- packing unit 2 pieces

Product features

Order information

| B [mm] | H [mm] | S [mm] | Tmax [mm] | | | | | | | PU [pc.] | L | Order-No. |
|--------|--------|--------|-----------|--|--|--|--|--|--|----------|---|-----------|
| 40 | 40 | 8.0 | - | | | | | | | 2 | o | 50822701 |
| 40 | 50 | 8.0 | 12 | | | | | | | 2 | o | 50822712 |
| 40 | 60 | 8.0 | 20 | | | | | | | 2 | | 50822713 |
| 40 | 70 | 8.0 | 30 | | | | | | | 2 | | 50822737 |
| 50 | 40 | 8.0 | - | | | | | | | 2 | o | 50822702 |
| 50 | 50 | 8.0 | 12 | | | | | | | 2 | s | 50822711 |
| 60 | 40 | 8.0 | 12 | | | | | | | 2 | o | 50822703 |
| 60 | 50 | 8.0 | 20 | | | | | | | 2 | s | 50822714 |
| 60 | 60 | 8.0 | 20 | | | | | | | 2 | | 50822715 |
| 60 | 70 | 8.0 | 30 | | | | | | | 2 | | 50822738 |
| 80 | 40 | 8.0 | - | | | | | | | 2 | o | 50822704 |
| 80 | 50 | 8.0 | 12 | | | | | | | 2 | o | 50822716 |
| 80 | 60 | 8.0 | 20 | | | | | | | 2 | o | 50822717 |
| 80 | 70 | 8.0 | 30 | | | | | | | 2 | | 50822739 |
| 100 | 40 | 8.0 | - | | | | | | | 2 | o | 50822705 |
| 100 | 50 | 8.0 | 12 | | | | | | | 2 | s | 50822718 |
| 100 | 60 | 8.0 | 20 | | | | | | | 2 | s | 50822719 |
| 100 | 70 | 8.0 | 30 | | | | | | | 2 | | 50822740 |
| 130 | 40 | 8.0 | - | | | | | | | 2 | o | 50822706 |
| 130 | 50 | 8.0 | 12 | | | | | | | 2 | s | 50822720 |
| 130 | 60 | 8.0 | 20 | | | | | | | 2 | o | 50822721 |
| 130 | 70 | 8.0 | 30 | | | | | | | 2 | s | 50822741 |
| 150 | 40 | 8.0 | - | | | | | | | 2 | o | 50822707 |
| 150 | 50 | 8.0 | 12 | | | | | | | 2 | o | 50822722 |
| 150 | 60 | 8.0 | 20 | | | | | | | 2 | o | 50822723 |
| 150 | 70 | 8.0 | 30 | | | | | | | 2 | o | 50822742 |
| 180 | 40 | 8.0 | - | | | | | | | 2 | o | 50822708 |
| 180 | 50 | 8.0 | 12 | | | | | | | 2 | s | 50822724 |
| 180 | 60 | 8.0 | 20 | | | | | | | 2 | s | 50822725 |
| 180 | 70 | 8.0 | 30 | | | | | | | 2 | o | 50822743 |
| 230 | 40 | 8.0 | 12 | | | | | | | 2 | | 50822709 |
| 230 | 50 | 8.0 | 12 | | | | | | | 2 | o | 50822733 |
| 230 | 60 | 8.0 | 20 | | | | | | | 2 | s | 50822735 |
| 230 | 70 | 8.0 | 30 | | | | | | | 2 | o | 50822744 |
| 260 | 40 | 8.0 | - | | | | | | | 2 | o | 50822710 |
| 260 | 50 | 8.0 | 12 | | | | | | | 2 | o | 50822734 |
| 260 | 60 | 8.0 | 20 | | | | | | | 2 | o | 50822736 |
| 260 | 70 | 8.0 | 30 | | | | | | | 2 | o | 50822745 |
| 650 | 40 | 8.0 | - | | | | | | | 2 | # | 50822751 |
| 650 | 50 | 8.0 | 12 | | | | | | | 2 | s | 50822752 |
| 650 | 60 | 8.0 | 20 | | | | | | | 2 | | 50822753 |
| 650 | 70 | 8.0 | 30 | | | | | | | 2 | | 50822754 |

HS 464 Multi Dowel Cutterheads

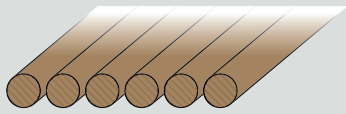
| | | | | |
|--|--|--|--|---|
| <p>Product</p>  | <p>Drawing</p>  | <p>Machine</p>  | <p>Application</p>  | <p>Design</p> <div style="border: 1px solid black; padding: 5px; text-align: center;"> HS </div> <div style="border: 1px solid black; padding: 5px; text-align: center; margin-top: 5px;"> MEC </div> |
|--|--|--|--|---|

| | | | |
|--|--|---|--|
| <p>Machine / Application</p> <ul style="list-style-type: none"> • multi spindle milling machines • for the production of smooth round bars of 2 to 16 mm and of corrugated dowels of 6.1 to 16.1 mm in solid woods | <p>Design</p> <ul style="list-style-type: none"> • body made from steel • 2 or 4 knife holders | <p>Advantages</p> <ul style="list-style-type: none"> • quick knife change • self-centering knife seat | <p>Notes</p> <ul style="list-style-type: none"> • guide-plate for axial adjustment of knives • further profiles on request |
|--|--|---|--|

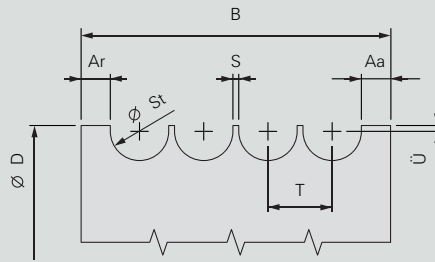
| Product features | | | | | | Order information | | |
|----------------------|--------|----------------------|----------------------------|---|-------------------|-------------------|---|-----------|
| $\varnothing D$ [mm] | B [mm] | $\varnothing d$ [mm] | $\varnothing d_{max}$ [mm] | Z | n_{max} [min-1] | PU [pc.] | L | Order-No. |
| 102 | 50 | 35 | 40 | 2 | 6000 | 1 | s | 50389261 |
| 102 | 75 | 35 | 40 | 2 | 6000 | 1 | s | 50389262 |
| 102 | 100 | 35 | 40 | 2 | 6000 | 1 | s | 50389263 |
| 102 | 50 | 40 | 40 | 2 | 6000 | 1 | s | 50389264 |
| 102 | 75 | 40 | 40 | 2 | 6000 | 1 | s | 50389265 |
| 102 | 100 | 40 | 40 | 2 | 6000 | 1 | s | 50389266 |
| 102 | 125 | 40 | 40 | 2 | 6000 | 1 | s | 50389267 |
| 102 | 150 | 40 | 40 | 2 | 6000 | 1 | s | 50389268 |
| 102 | 50 | 35 | 40 | 4 | 6000 | 1 | s | 50389269 |
| 102 | 75 | 35 | 40 | 4 | 6000 | 1 | s | 50389270 |
| 102 | 100 | 35 | 40 | 4 | 6000 | 1 | s | 50389271 |
| 102 | 50 | 40 | 40 | 4 | 6000 | 1 | s | 50389272 |
| 102 | 75 | 40 | 40 | 4 | 6000 | 1 | s | 50389273 |
| 102 | 100 | 40 | 40 | 4 | 6000 | 1 | s | 50389274 |
| 102 | 125 | 40 | 40 | 4 | 6000 | 1 | s | 50389275 |
| 102 | 150 | 40 | 40 | 4 | 6000 | 1 | s | 50389276 |
| Spare parts | | Dimension [mm] | | | | PU [pc.] | L | Order-No. |
| Head Cap Screws | | M8x30 | | | | 10 | | 180005 |
| Washers | | B=8,4 DIN 125 | | | | 10 | s | 50945505 |
| Cranked Wrench Keys | | SW6x100 | | | | 1 | o | 180383 |

HS 464 HS Knives smooth round bars for smooth round dowels

Product



Drawing



Machine



Application



Design



Machine / Application

Design

Advantages

Notes

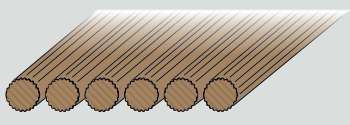
- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

KNIVES

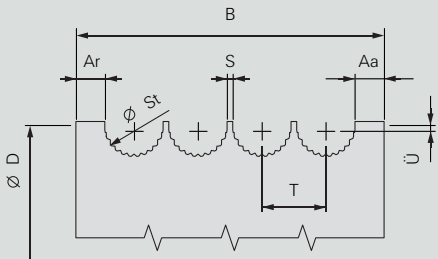
| St= bar Ø | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 |
|-------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| S = bridge | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1,5 | 1,5 |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

HS 464 HS Knives ripple bars for fine serration dowels


Product




Drawing




Machine



Application



Design



| Machine / Application | Design | Advantages | Notes |
|-----------------------|--------|------------|--|
| | | | <ul style="list-style-type: none"> small quantities: surcharge of 50% intermediate dimensions: surcharge of 25% on the next lower dimension indicate machine type when placing an order price per piece when ordering 8 identical knives |

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

HS 4000 Tongue and Groove Tools

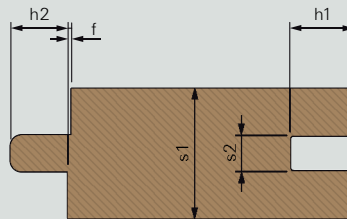
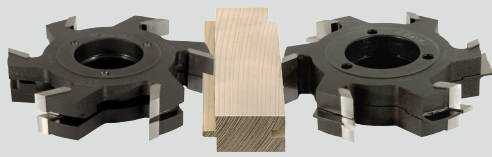
Product

Drawing

Machine

Application

Design



HS
MEC

Machine / Application

Design

Advantages

Notes

- molders
- double end tenoners
- for tongue and groove board with or without space allowance in material (=open joint) or chamfer in soft and hard woods
- body made from steel
- adjustable by means of spacers
- highest precision thanks to plane parallelism of all parts
- secured against rotation by means of 3 driving pins on minor diameter 75 mm
- indicate sense of rotation, direction of feed and face side according to diagram I, II, III or IV when placing an order
- without indications we will deliver according to diagram I
- delivery with HW-tipping possible with surcharge

Product features

Order information

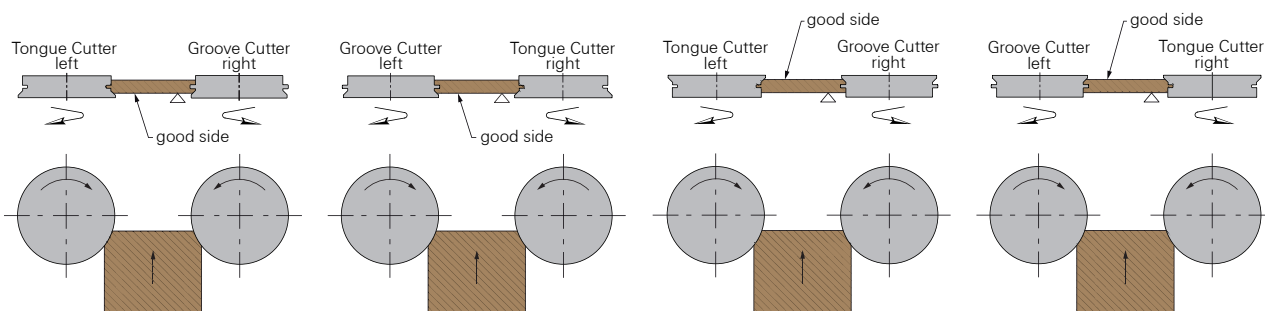
| Profile | Ø D [mm] | B [mm] | Ø d [mm] | nmax [min-1] | s1 [mm] | s2 [mm] | f [mm] | Z | PU [pc.] | L | Order-No. |
|---------|----------|--------|----------|--------------|---------|---------|--------|-----|----------|---|-----------|
| 501/502 | 180 | 35 | 40 | 8000 | 12-36 | 4,5-7,5 | 0,5 | 6 |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

Example I

Example II

Example III

Example IV

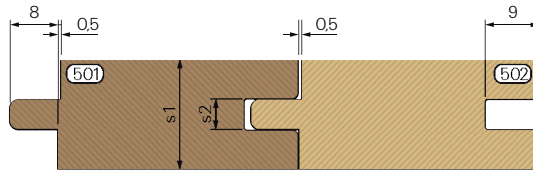


4000 Tongue and Groove Tools

Diagram I

Tongue Cutters

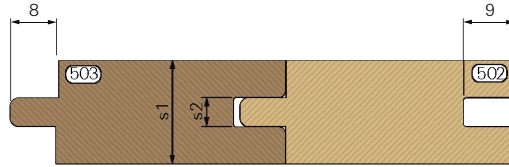
Profile 501



Grooving Cutters

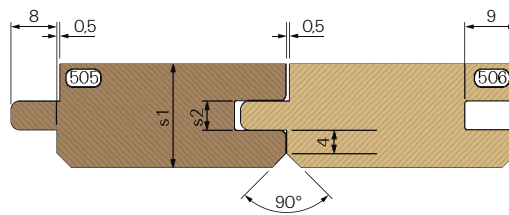
Profile 502

Profile 503



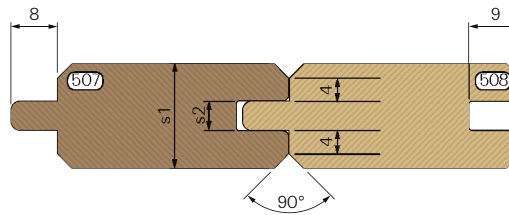
Profile 502

Profile 505



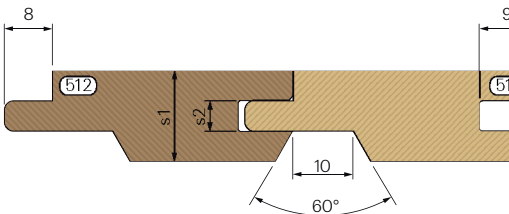
Profile 506

Profile 507



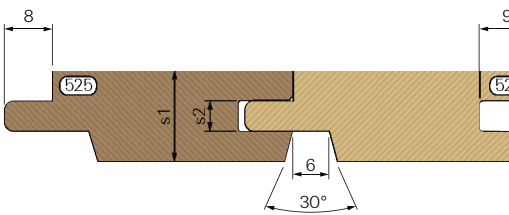
Profile 508

Profile 512



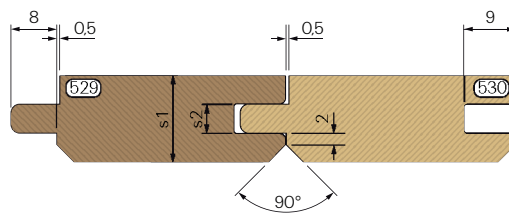
Profile 513

Profile 525



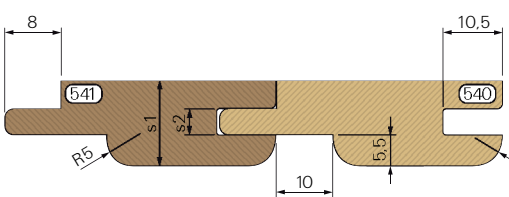
Profile 526

Profile 529



Profile 530

Profile 541



Profile 540

HW 4010 Tongue and Groove Tools - Silverline

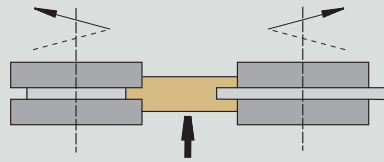
Product

Drawing

Machine

Application

Design



Machine / Application

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

Design

- body made from steel
- mounted on threaded bushing

Advantages

- excellent cutting results
- simple maintenance
- direct knife clamping
- consistent cutting circles after knife change

Notes

- when ordering, specify the threaded bushing
- pay attention to the spindle diameter (30, 40, 50 mm)!

Product features

Order information

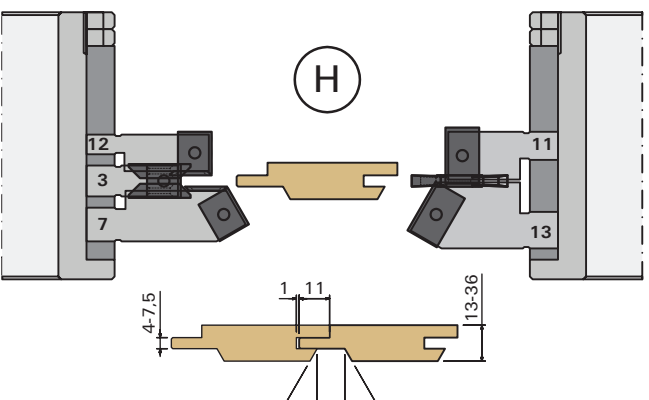
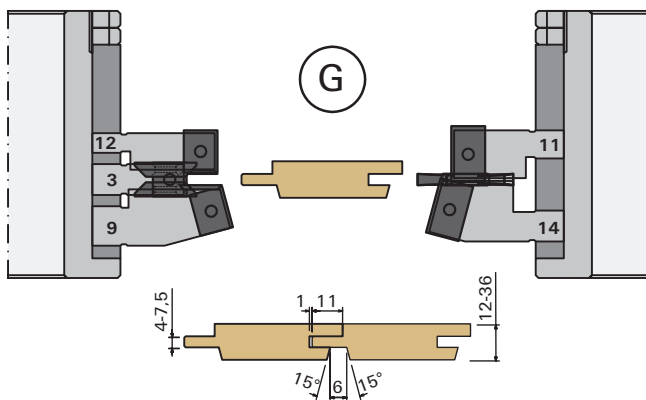
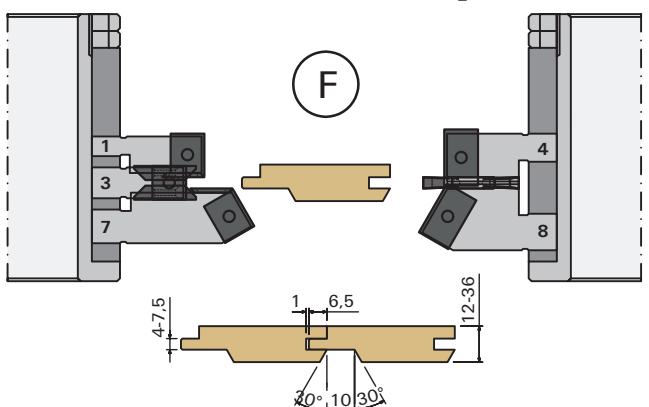
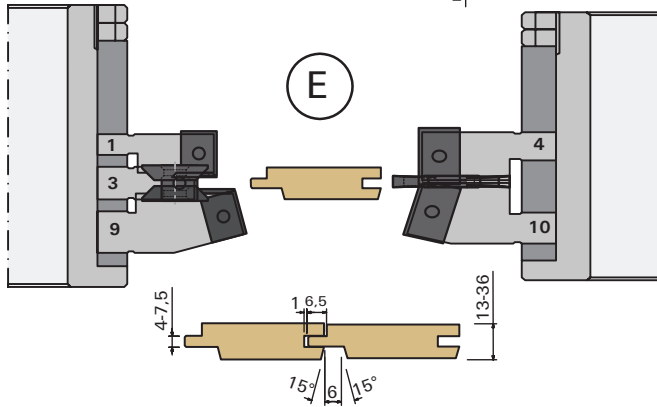
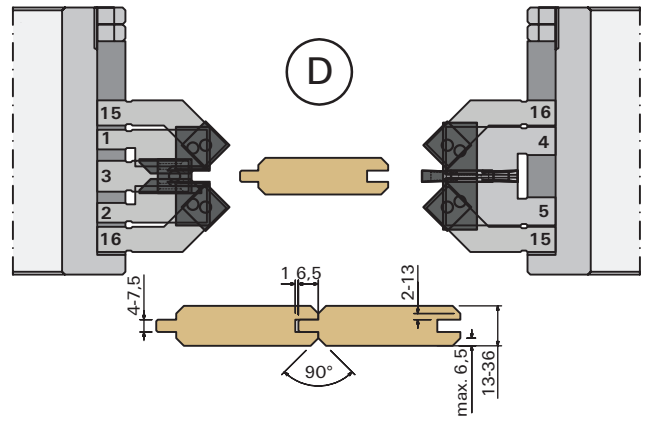
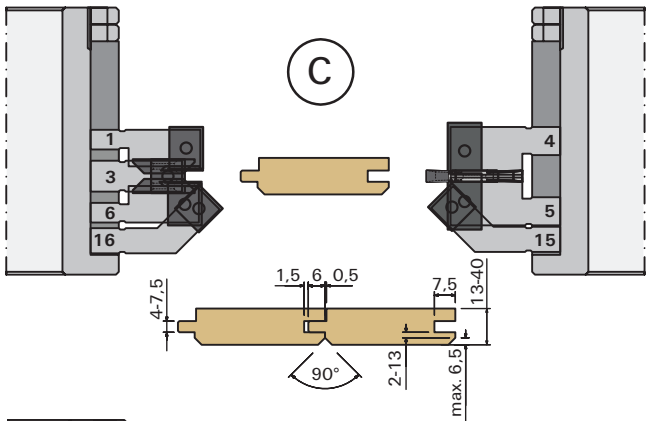
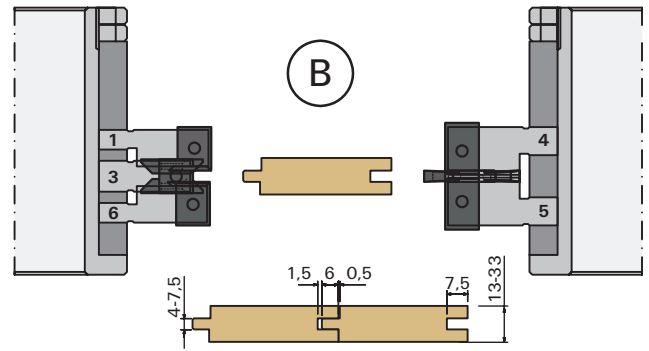
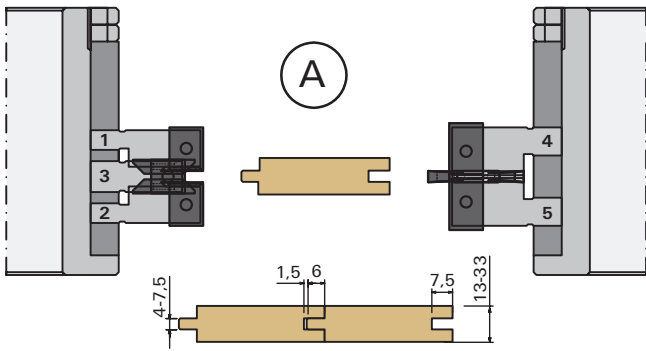
| Cutter-no. | Ø D [mm] | B [mm] | Ø d [mm] | nmax [min-1] | Z | | | | PU [pc.] | L | Order-No. |
|------------|----------|--------|----------|--------------|-----|--|--|--|----------|---|---------------------------|
| 1 | 140 | 15 | 60 | 8000 | 2+2 | | | | 1 | o | 68303016 NEW |
| 2 | 140 | 15 | 60 | 8000 | 2+1 | | | | 1 | o | 68303026 NEW |
| 3 | 127 | 12 | 60 | 8000 | 2 | | | | 1 | o | 68303036 NEW |
| 4 | 155 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303046 NEW |
| 5 | 155 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303056 NEW |
| 6 | 139 | 15 | 60 | 8000 | 2+2 | | | | 1 | o | 68303066 NEW |
| 7 | 175 | 15 | 60 | 8000 | 2+2 | | | | 1 | o | 68303076 NEW |
| 8 | 155 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303086 NEW |
| 9 | 160 | 15 | 60 | 8000 | 2+2 | | | | 1 | o | 68303096 NEW |
| 10 | 155 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303106 NEW |
| 11 | 164 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303116 NEW |
| 12 | 149 | 15 | 60 | 8000 | 2+2 | | | | 1 | o | 68303126 NEW |
| 13 | 165 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303136 NEW |
| 14 | 164 | 20 | 60 | 8000 | 2 | | | | 1 | o | 68303146 NEW |
| 15 | 154 | 12 | 60 | 8000 | 2 | | | | 1 | o | 68303156 NEW |
| 16 | 154 | 12 | 60 | 8000 | 2 | | | | 1 | o | 68303166 NEW |

| Turnover Knives | Dimension [mm] | | PU [pc.] | L | Order-No. |
|----------------------------|----------------|--|----------|---|---------------------------|
| Turnover Knives | 12x12x1,5 | 68303036, 68303156, 68303166 | 10 | | 50820012 |
| Grooving Insert | B=4 | 68303046, 68303056, 68303086, 68303106, 68303116, 68303136, 68303146 | 2 | o | 68002122 NEW |
| Raker Turnover Knives | 20x12x1,5 | 68303076, 68303086, 68303096, 68303136, 68303146 | 10 | | 50820020 NEW |
| Raker Turnover Knives | 15x12x1,5 | 68303016, 68303026, 68303046, 68303056, 68303066, 68303116, 68303126 | 10 | | 50820015 NEW |
| Chamfering Turnover Knives | 16x22x5,0 | 68303136, 68303146 | 10 | | 183668 NEW |

| Spare parts | Dimension | Suitable for | PU [pc.] | L | Order-No. |
|------------------|-----------------------|--------------|----------|---|---------------------------|
| Threaded Bushing | 60/30xGL95 right/left | For all | 1 | s | 60956030 NEW |
| Threaded Bushing | 60/40xGL95 right/left | For all | 1 | s | 60956040 NEW |
| Threaded Bushing | 60/50xGL95 right/left | For all | 1 | s | 60956050 NEW |

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Delivery according to diagram I



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| 178174 | 26 | 50400027 | s 34 | 50572676 | s 7 | 50577103 | s 6 |
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