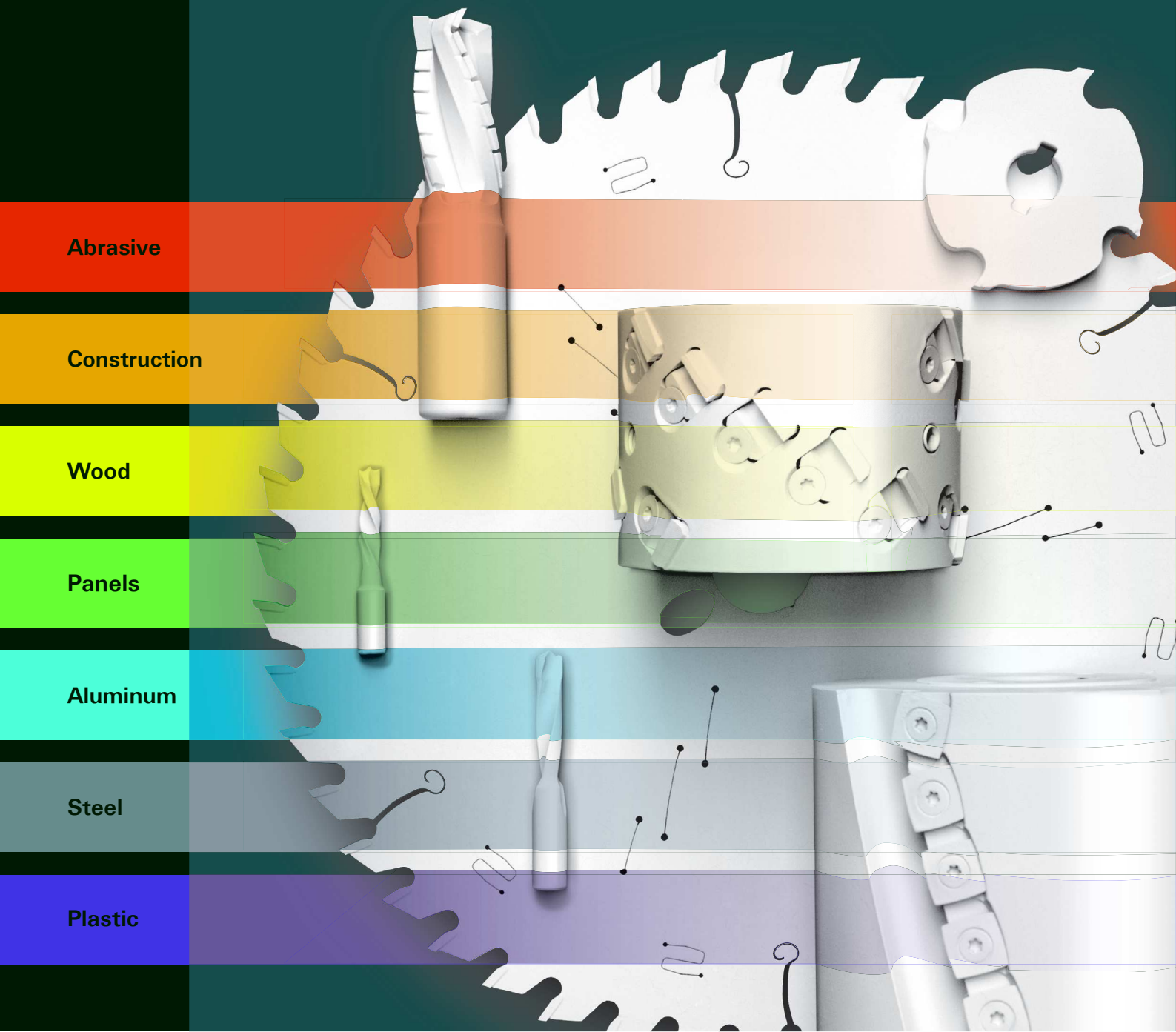
Stehle

Tool Program

2020

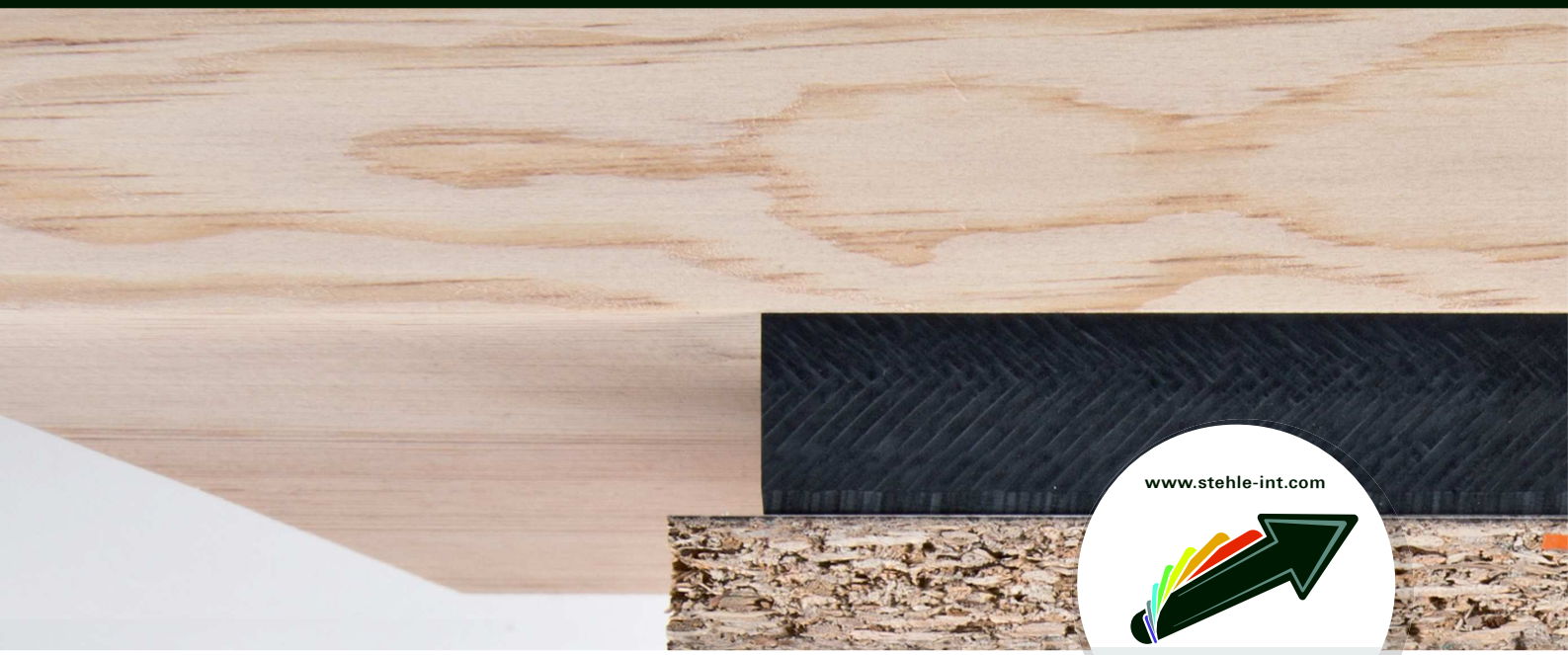


Stehle

Tool Program

2020

Innovative
Trend-Setting
Reliable



STEHLE IS RELIABLE

For more than 100 years Stehle has supplied their customers - end users and dealers - with technically up-to-date tools. Stehle is known for their high-precision and economic cutterheads for the machining of solid wood

Since the Stehle brand was integrated in the LEUCO group at the end of the 1990s, it has been systematically oriented towards the supply of specialized dealers. To meet this requirement, the product spectrum was completed by an extensive range of saw blades and tools for the machining of wood-based panels.

STEHLE IS RELIABLE ...

RELIABLE

Since January 2014, Daniel Schrenk has been CEO for Sales and Marketing of the Ledermann GmbH & Co. KG. Thanks to his training he exactly knows the demands of our customers.

STEHLE – a strong and reliable partner for trading companies. Today and in the future.

... The specialized trading companies for cutting tools are walking the tightrope between losing market share to the big tooling manufacturers on the one side, and on the other side the increasing opportunities of the upcoming digitisation to gain market share.

Digitisation – opportunity and challenge for trading companies?

It may sound contradictory from the first point of view. Because many of us think mainly the price is the major point in the e-business world whereas performance, function, smart handling or professional advisory service does not seem to be a topic.

But if you look more detailed lots of possibilities are coming up.
Simple and operating friendly colour code functions in an E-Catalogue, operating data and application data via QR Codes marked on the tool, 24hx7 day's web service and much more offer a lot of advantages for tool trading companies.

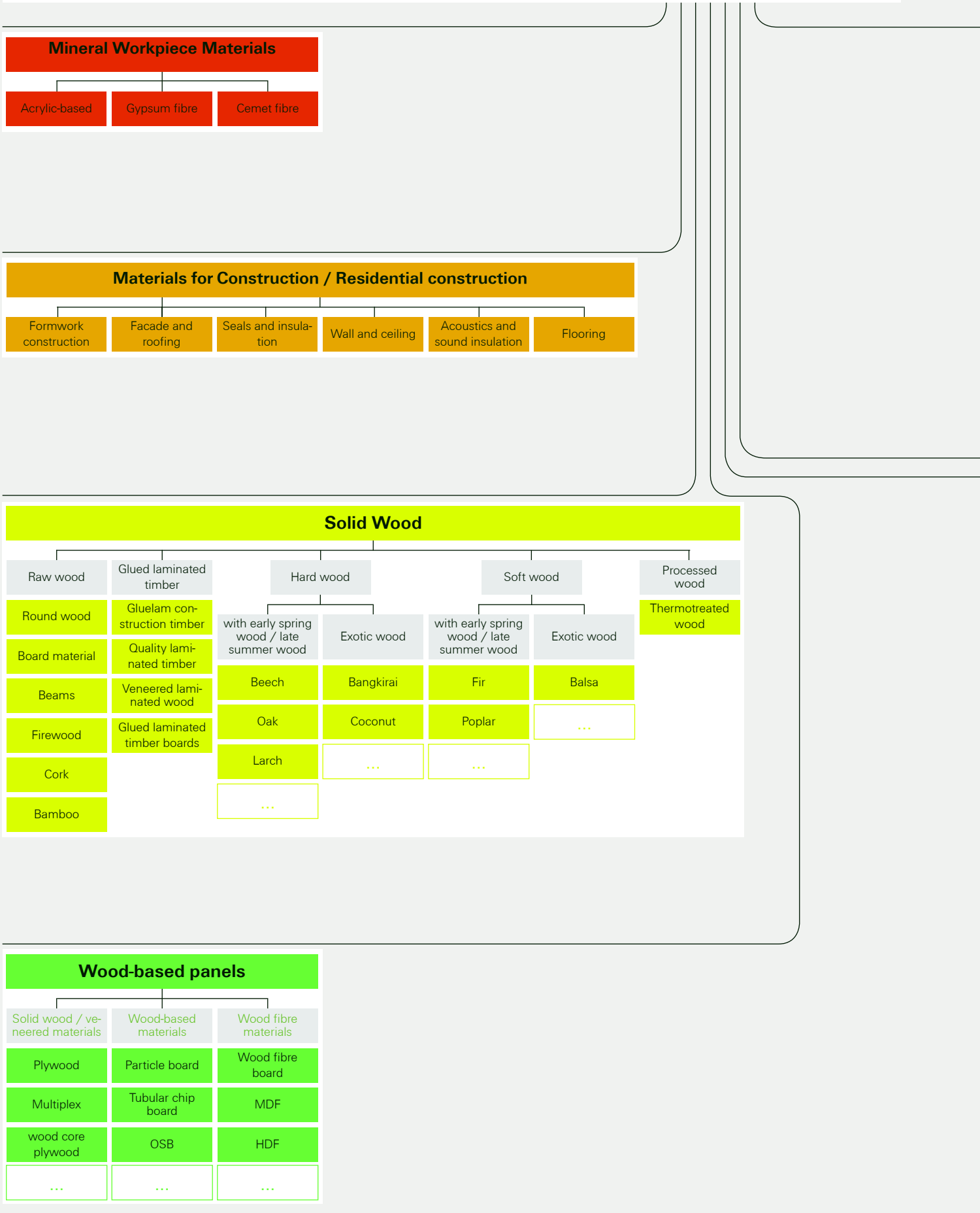
Stehle has already started with E-Commerce but there is still a long way to go. We see great opportunities in the digitisation and are determined to proceed this way together with you, our partner.

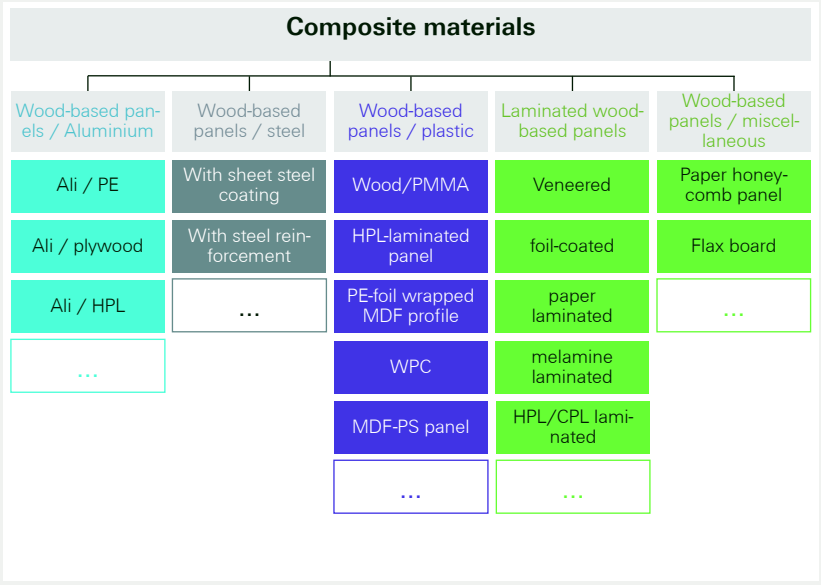
You can trust in Stehle as a strong and reliable partner, integrated in powerful and innovative company structure.

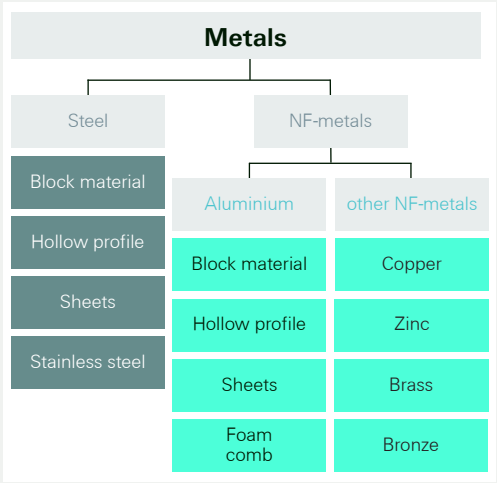
We wish you a lot of pleasure and success with our new catalogue, with the print version in your hands, or if you look in the online version on your PC, laptop or Smartphone wherever you are.

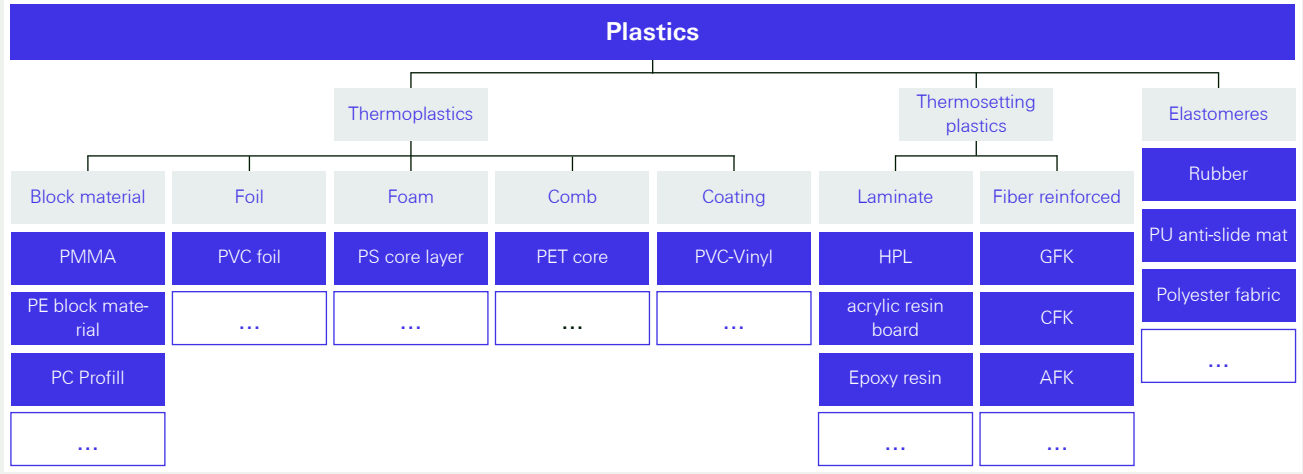
Daniel Schrenk,
CEO

Materials in woodworking, residential construction and related trades




Composite materials
Wood-based panels / Aluminium
Wood-based panels / steel
Wood-based panels / plastic
Laminated wood-based panels
Wood-based panels / miscellaneous
Ali / PE
Ali / plywood
Ali / HPL
...
With sheet steel coating
With steel reinforcement
...
Wood/PMMA
HPL-laminated panel
PE-foil wrapped MDF profile
WPC
MDF-PS panel
...
Veneered
foil-coated
paper laminated
melamine laminated
HPL/CPL laminated
...
Paper honeycomb panel
Flax board
...


Metals
Steel
Block material
Hollow profile
Sheets
Stainless steel
NF-metals
Aluminium
Block material
Hollow profile
Sheets
Foam comb
other NF-metals
Copper
Zinc
Brass
Bronze


Plastics
Thermoplastics
Thermosetting plastics
Elastomeres
Block material
Foil
Foam
Comb
Coating
Laminate
Fiber reinforced
PMMA
PE block material
PC Profill
...
PVC foil
...
PS core layer
...
PET core
...
PVC-Vinyl
...
HPL
acrylic resin board
Epoxy resin
...
GFK
CFK
AFK
...
Rubber
PU anti-slide mat
Polyester fabric
...

CIRCULAR SAW BLADES

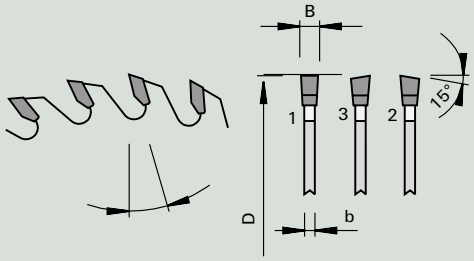
CONTENTS

HW HKS - solid for cordless portable saws

Portable saw blades HW - flat tooth - alternate top bevel

Product

Drawing



Machine

Application

Design

2-0-6

HW **TC10**

F-WS

Machine / Application

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

Design

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

Advantages

- low power consumption thanks to reduced kerf

Notes

- suitable for cordless machines

Product features | Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]		PU [pc.]	L	Order-No.	
136	1,5	1.0	20	18	▲	Dewalt	20		1		58110400	
136	1,5	1.0	20	24	▲▲	Dewalt	20		1		58110401	
160	1,6	1.2	20	18	▲	Mafell, Festool	20		1		58110413	NEW
160	1,6	1.2	20	48	▲▲▲▲	Mafell, Festool	20		1	o	58110419	NEW
165	1,6	1.2	20	24	▲	Makita, Festool, Bosch	20		1	o	58110423	NEW
165	1,6	1.2	20	18	▲	Makita, Dewalt, Bosch	20		1		58110402	
165	1,6	1.2	20	24	▲	Makita, Dewalt, Bosch	20		1		58110403	
165	1,6	1.2	20	36	▲▲	Makita, Dewalt, Bosch	20		1		58110404	
165	1,6	1.2	15,88	24	▲▲▲▲	Milwaky	20		1	o	58110421	NEW
165	1,6	1.2	20	48	▲▲▲▲	Makita, Dewalt, Bosch	20		1	o	58110420	NEW
165	1,6	1.2	15,88	40	▲▲▲	Milwaukee	15		1		58110405	
184	1,6	1.1	16	56	▲▲▲	Dewalt	15		1		58110406	
184	1,8	1.2	20	24	▲▲▲	Mafell	20		1		58110416	NEW
190	1,8	1.2	30	48	▲▲▲▲	Hilti	15		1	o	58110418	NEW
190	1,8	1.2	20	48	▲▲▲	Dewalt	15		1		58110407	
190	1,8	1.2	30	24	▲▲▲	Hilti, Milwaukee, Dewalt	20		1		58110417	NEW
210	1,8	1.2	30	60	▲▲▲	Dewalt Extrem	15		1		58110408	
216	2,0	1.4	30	24	▲	Dewalt	20		1		58110409	
216	2,0	1.4	30	36	▲▲	Dewalt	20		1		58110410	
216	2,0	1.4	30	60	▲▲▲	Dewalt	15		1		58110411	
250	2,2	1.6	30	24	▲	Dewalt, ELU, Festo	20		1		58110412	

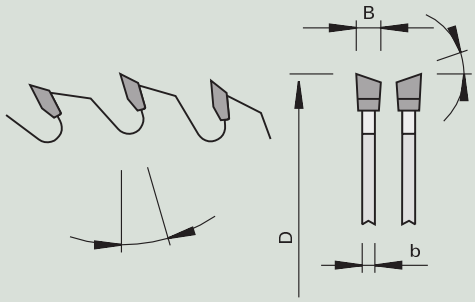
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW — HKS - solid for cordless portable saws

Portable Saw Blades HW - alternate top bevel

Product

Drawing



Machine

Application

Design

1-0-1

HW **TC10**

WS

Machine / Application

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

Design

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

Advantages

- low power consumption thanks to reduced kerf

Notes

- suitable for cordless machines

Product features / **Order information**

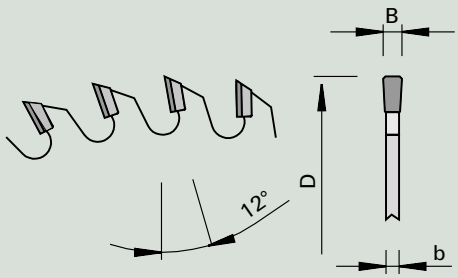
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]		PU [pc.]	L	Order-No.
190	1,8	1.3	30	20	▲	Hilti	20	●●●	1	o	58110415 NEW

DP — HKS - L for cordless portable saws

Portable Saw Blades DP - flat tooth

Product

Drawing



Machine

Application

Design

1-0-1

F

Machine / Application

- cordless portable saws
- for sizing cuts in cement-bound boards

Design

- tooth configuration: flat "F"
- cutting material: DP
- coated saw blade body

Advantages

- low power consumption thanks to reduced kerf

Notes

- cannot be used for stone, glass and nails
- suitable for cordless machines

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]		PU [pc.]	L	Order-No.
136	1,6	1.2	20	4	▲	12	●●●	1	o	50460500 NEW
160	1,6	1.2	20	6	▲	12	●●●	1	o	50460479 NEW
165	1,6	1.2	20	6	▲	12	●●●	1	o	50460480 NEW

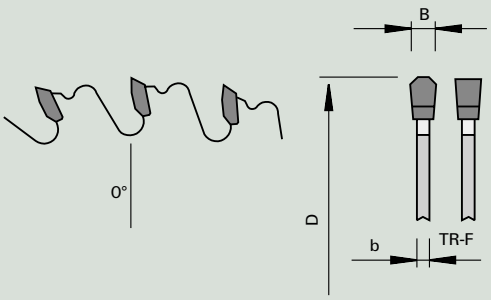
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HT HKS - Mega Steel - cordless portable saws

Chop Saw Blades HT for metal - neutral hook angle

Product

Drawing



Machine

Application

Design

3-0-1

HW
TCx03

TR-
F

Machine / Application

- dry-cuter machines
- universal metal-cut machines
- for dividing and miter cuts in composite materials, metal sheets, stainless steel, plastics, NF-metals, cable ducts, profiles, SML-tubes, etc.

Design

- tooth configuration: triple-chip - flat "TR-F"
- cutting material: HT TCx03

Advantages

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

Notes

- suitable for cordless machines
- alt. Parat - Negativ (HKS) and Unisteel (HKS)
- rec. rpm:
- Ø160 = 2750 rpm
- Ø190 = 2350 rpm
- Ø216 = 2050 rpm
- Ø230 = 1950 rpm

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]		PU [pc.]	L	Order-No.
160	1,8	1.4	20	40	▲▲	0		1		58458784
190	1,8	1.4	30	48	▲▲	0		1		58458785
216	1,8	1.4	30	56	▲▲	0		1		58458786
230	1,8	1.4	30	60	▲▲	0		1		58805879

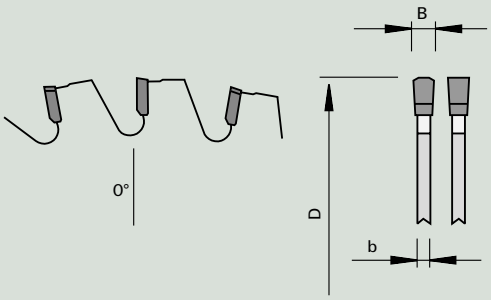
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - Unisteel - cordless portable saws

Portable Saw Blades HW - triple chip / flat

Product

Drawing



Machine

Application

Design

2-0-6

HW **TCm13**

TR-F

Machine / Application

- cordless portable saws
- for dividing cuts in metals and NF-metals (zinc) plates, cast iron, etc.

Design

- tooth configuration: triple chip with flat tooth "TR-F"
- cutting material: HW TCm13

Advantages

- low power consumption thanks to reduced kerf

Notes

- suitable for cordless machines

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]		PU [pc.]	L	Order-No.
136	1,6	1.2	20	36	▲▲	Dewalt	0		1		58116400 NEW
160	1,6	1.2	20	40	▲▲	Mafell, Festool	0		1	o	58116402 NEW
165	1,6	1.2	20	40	▲▲	Makita, Dewalt	0		1		58116401 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

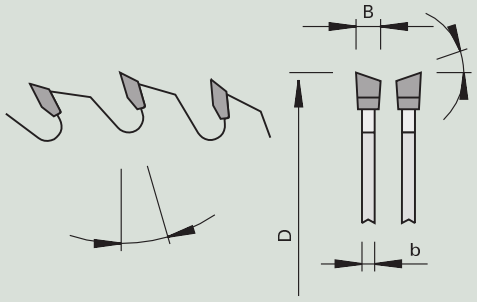
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - solid

Portable Saw Blades HW - alternate top bevel

Product

Drawing



Machine

Application

Design

1-0-1

HW
TC10

WS

Machine / Application

- portable saws
- clipping and miter saws
- for ripping and cross cuts in solid woods

Design

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

Advantages

Notes

- for larger dimensions see ZQW

Product features | **Order information**

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

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
225	2,8	1.8	30	34	▲▲▲	2/7/42	15		1		50110228
230	2,8	1.8	30	36	▲▲▲	2/7/42	15		1		50110113
230	2,8	1.8	30	24	▲▲	2/7/42	15		1		50110168
230	2,8	1.8	30	18	▲	2/7/42	20		1		50110255
240	3,0	2.0	30	64	▲▲▲	2/7/42	20		1	o	50687903

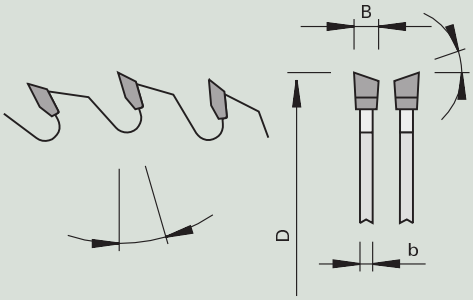
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - Board

Portable Saw Blades HW - alternate top bevel

Product

Drawing



Machine

Application

Design

HW
TC10

WS

Machine / Application

- portable saws
- clipping and miter saws
- for ripping and cross cuts in wood-based panels

Design

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

Advantages

Notes

- for larger dimensions see ZWS
- 58110356 vario group Z= 4x12, vario = uneven tooth pitch

Product features

Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	Order-No.
100	2,4	1.4	12	30	▲▲▲		10		1	50110001
100	2,4	1.4	22	30	▲▲▲		10		1	50110003
105	2,4	1.4	22	30	▲▲▲		10		1	50110006
125	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		1	50110012
130	2,4	1.6	20	36	▲▲	2/6/32,5	10		1	50110018
140	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		1	50110029
150	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		1	50110040
150	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	50110041
160	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		1	50110053
160	2,2	1.6	20	36	▲▲▲	2/6/32,5	15		1	50110055
160	2,2	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	50110056
160	2,2	1.6	20	48 Vario	▲▲▲▲	2/6/32,5	5		1	58110356
160	2,6	1.6	30	36	▲▲▲	2/7/42	15		1	50110058
160	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	50110059
165	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		1	50110061
165	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	50110062
170	2,6	1.6	30	36	▲▲▲	2/7/42	15		1	50110070
170	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	50110071
180	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		1	50110183
180	2,6	1.6	20	40	▲▲▲	2/6/32,5	15		1	50110076
180	2,6	1.6	30	40	▲▲▲	2/7/42	15		1	50110079
180	2,6	1.6	30	54	▲▲▲▲	2/7/42	10		1	50110080
180	2,6	1.6	20	54	▲▲▲▲		10		1	50110077
190	2,6	1.6	16	30	▲▲▲	2/6/32,5	15		1	50110083
190	2,6	1.6	16	42	▲▲▲▲	2/6/32,5	10		1	50110084
190	2,6	1.6	20	30	▲▲▲	2/6/32,5	15		1	50110086
190	2,6	2.0	20FX	32	▲▲▲	Fast-Fix	10		1	50110266
190	2,6	2.0	20FX	48	▲▲▲▲	Fast-Fix	10		1	50110267
190	2,6	2.0	20FX	60	▲▲▲	Fast-Fix	10		1	50110268 NEW
190	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	50110087
190	2,6	1.6	30	30	▲▲▲	2/7/42	15		1	50110089
190	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	50110090
190	2,6	1.6	30	60	▲▲▲▲	2/7/42	10		1	50110091
200	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110096
200	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		1	50110097
210	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110105
210	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		1	50110106
216	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110108
216	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		1	50110109

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

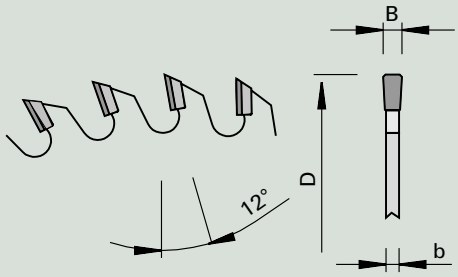
Product features								Order information		
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	Order-No.
220	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110111
220	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	50110112
225	2,8	1.8	30	48	▲▲▲▲	2/7/42	10		1	50110237
225	2,6	1.8	30	64	▲▲▲▲	2/7/42	10		1	50687902
230	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	50110114
230	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	50110115

DP HKS - LR

Portable Saw Blades DP - flat tooth

Product

Drawing



Machine

Application

Design

1-0-1

F

Machine / Application

- portable saws
- for sizing cuts in cement-bound boards

Design

- tooth configuration: flat "F"
- cutting material: DP
- coated saw blade body

Advantages

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

Notes

- not for stone, glass and nails

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
160	2,2	1.6	20	4	▲	2/6/32,5	12		1		50457997
190	2,2	1.6	30	4	▲	2/7/42	12		1		50457994
230	2,2	1.6	30	4	▲	Combi3	12		1		50457992

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

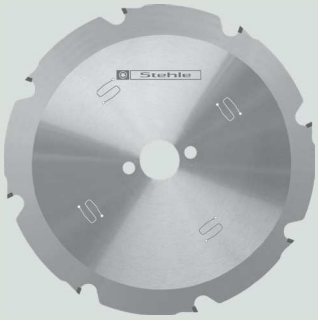
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

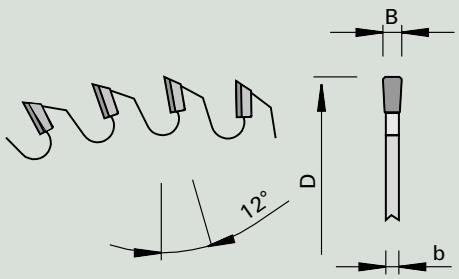
DP HKS - L

Portable Saw Blades DP - flat tooth

Product



Drawing



Machine

Application

Design

1,0 mm

1-0-1

F

Machine / Application

- portable saws
- for trimming and finish cuts in laminate®, MDF, particle boards, cement-bound boards, Corian®, thermosetting plastics, gypsum boards and melamine

Design

- tooth configuration: flat "F"
- cutting material: DP
- resharpening area 1.0 mm
- coated saw blade body

Advantages

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

Notes

- lower numbers of teeth for trimming cuts
- higher numbers of teeth for sizing cuts
- not for stone, glass and nails

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

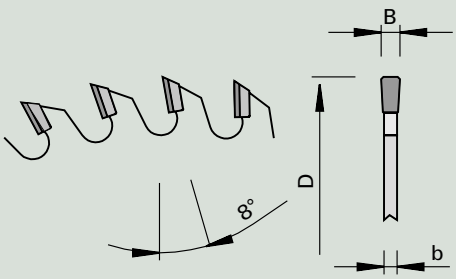
Appropriate **reducing rings** can be found at the end of the chapter

DP HKS - L2

Portable Saw Blades DP - flat tooth with chamfer

Product

Drawing



Machine

Application

Design

2,5 mm

2-0-6

F-FA

Machine / Application

- portable saws
- for trimming cuts in laminate®, MDF, particle boards, cement-bound boards, Corian®, thermosetting plastics, gypsum boards and melamine

Design

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

Advantages

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

Notes

- lower numbers of teeth for trimming cuts
- higher numbers of teeth for sizing cuts
- not for stone, glass and nails

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
160	3,0	2.2	20	4	▲	2/6/32,5	8		1	o	58458790
180	2,6	2.0	30	4	▲	2/6/32,5	8		1	o	58458799
190	2,6	2.2	20	4	▲	Fast-Fix	8		1	o	58458800
190	3,0	2.2	30	4	▲	2/7/42	8		1	o	58458791
216	3,0	2.2	30	4	▲	Combi3	8		1	o	58458792
230	3,0	2.2	30	6	▲▲	Combi3	8		1	o	58458793
250	3,0	2.2	30	6	▲▲	Combi3	8		1	o	58458794
260	2,5	1.8	30	8	▲▲	Combi3	8		1	o	58458797
305	3,0	2.2	30	8	▲▲	Combi3	5		1	o	58458795 NEW
315	3,0	2.2	30	10	▲▲	Combi3	8		1	o	58458801 NEW
350	3,4	2.4	30	12	▲▲	Combi3	8		1	o	58458802 NEW
400	3,4	2.4	30	15	▲▲▲	Combi3	8		1	o	58458798

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

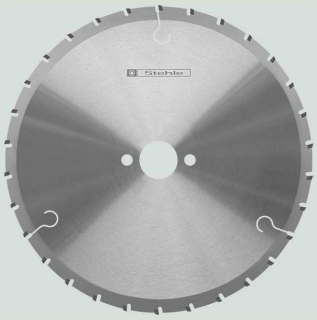
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

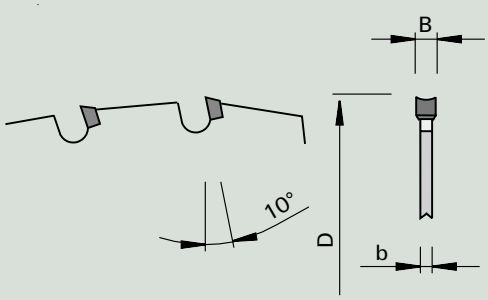
DP HKS - nn-System DP flex

Portable Saw Blades DP hollow back tooth

Product



Drawing



Machine

Application

Design

3-0-1

HR

Machine / Application

- portable saws
- clipping saws
- for precise cutting in all common wood-based panels and ledges
- for ripping and cross cuts in solid woods
- suitable for many materials, e.g. for façade boards

Design

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

Advantages

- highest economic efficiency and productivity thanks to extremely long edge life
- reduced cutting pressure thanks to hollow back tooth geometry
- the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body

Notes

- clean your "nn-System DP flex" circular saw blades on a regular basis. you will profit from a long-lasting and precise cutting quality and maximize the edge lives of your innovative saw blades many times over.

Product features / **Order information**

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

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

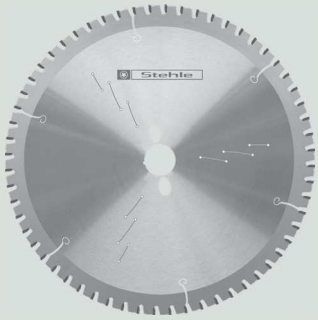
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

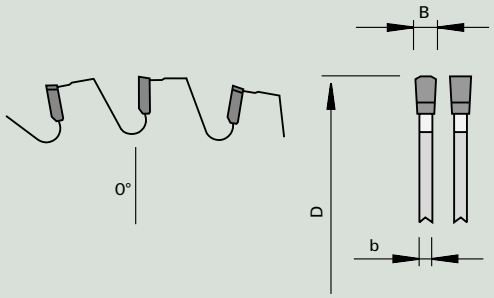
HW Unisteel (HKS)

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

Product



Drawing



Machine

Application

Design

2-0-6

HW TCm13

TR-F

Machine / Application

- clipping and miter saws
- for dividing and miter cuts in metals and NF-metals (zinc) plates, cast iron, etc.

Design

- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW TCm13

Advantages

- improved cutting quality thanks to special cutting geometry

Notes

- for wood-based panels and plastics see ZWS and Parat - negative (HKS)
- reduced edge lives in the case of stainless steel

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

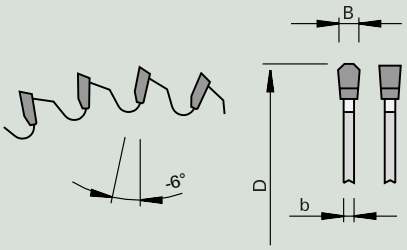
Appropriate **reducing rings** can be found at the end of the chapter

HW Parat - negative (HKS)

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

Product

Drawing



Machine

Application

Design

1-0-1

HW **TC10**

TR-F

Machine / Application

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

Design

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

Advantages

- negative hook angle for high cutting quality and safe handling

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
130	2,8	2.2	20	36	▲▲		-6		1	o	58115027
150	2,8	2.2	20	42	▲▲	2/6/32,5	-6		1		58115002
160	2,2	1.6	20	42	▲▲	2/6/32,5	-6		1		58115004
160	2,2	1.6	20	56	▲▲▲	2/6/32,5	-6		1		58115042
160	2,8	2.2	30	42	▲▲	2/7/42	-6		1		58115026
165	2,4	1.6	20	48	▲▲	2/6/32,5	-6		1	o	58115044
180	2,8	2.2	20	48	▲▲	2/6/32,5	-6		1		58115007
180	2,8	2.2	30	48	▲▲	2/7/42	-6		1		58115008
190	2,8	2.2	20	54	▲▲	2/6/32,5	-6		1		58115009
190	2,6	2.0	20FX	58	▲▲	Fast-Fix	-6		1	o	58115033
190	2,8	2.2	30	54	▲▲	2/7/42	-6		1		58115010
200	2,8	2.2	30	54	▲▲	2/7/42	-6		1		58115011
210	2,8	2.2	30	54	▲▲	2/7/42	-6		1		58115012
216	2,8	2.2	30	60	▲▲	2/7/42	-6		1		58115024
216	2,8	2.2	30	80	▲▲▲	2/7/42	-6		1		58115034
220	2,8	2.2	30	54	▲▲	2/7/42	-6		1		58115021
225	2,8	2.2	30	60	▲▲	Combi3	-6		1		58115039
230	2,8	2.2	30	64	▲▲	2/7/42	-6		1		58115014

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

HW Saw Blade Set HW

3 piece set in wood box

Product	Drawing	Machine	Application	Design
		 	  	2-0-6 HW **TC10** TR-F WS

Machine / Application	Design	Advantages	Notes
• portable saws • clipping and miter saws • for ripping and cross cuts in solid woods	• tooth configuration: alternate top bevel "WS" • tooth configuration: triple chip / flat "TR-F" • cutting material: HW TC10		

Product features — **Order information**

	Dimension [mm]								PU [pc.]	L	Order-No.
Saw Blades - Set 1	160x20								1		50111160
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
HKS - Massiv	160	2,2	1.6	20	24	WS	2/6/32,5		1		50110054
HKS - Board	160	2,2	1.6	20	48	WS	2/6/32,5		1		50110056
Parat - negative (HKS)	160	2,2	1.6	20	42	TR-F	2/6/32,5		1		58115004
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 2	160x20								1		50111163
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
HKS - Massiv	160	2,2	1.6	20	24	WS	2/6/32,5		1		50110054
HKS - Board	160	2,2	1.6	20	36	WS	2/6/32,5		1		50110055
HKS - Board	160	2,2	1.6	20	48	WS	2/6/32,5		1		50110056
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 3	190x30								1		50111193
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
HKS - Massiv	190	2,6	1.6	30	24	WS	2/7/42		1		50110155
HKS - Board	190	2,6	1.6	30	30	WS	2/7/42		1		50110089
HKS - Board	190	2,6	1.6	30	48	WS	2/7/42		1		50110090
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 4	190x30								1		50111190
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
HKS - Massiv	190	2,6	1.6	30	24	WS	2/7/42		1		50110155
HKS - Board	190	2,6	1.6	30	48	WS	2/7/42		1		50110090
Parat - negative (HKS)	190	2,8	2.2	30	54	TR-F	2/7/42		1		58115010
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 5	216x30								1		50111216
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
Parat - negative (HKS)	216	2,8	2.2	30	60	TR-F	2/7/42		1		58115024

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
K + G - negative	216	2,8	1.8	30	48	WS	2/7/42		1		58110181
K + G - negative	216	2,8	1.8	30	24	WS	2/7/42		1		58110180
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 6	235x30								1		50111235
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
ZQW	235	2,8	1.8	30	24	WS	2/7/42		1		50110170
ZWS	235	2,8	1.8	30	48	WS	2/7/42		1		58110121
NF - negative	235	2,8	2.2	30	64	TR-F	2/7/42		1		58115018
	Dimension [mm]								PU [pc.]	L	
Saw Blades - Set 7	250x30								1		50111250
	Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Tooth geometry	NL		PU [pc.]	L	
ZQW	250	3,2	2.2	30	24	WS	2/7/42 + 2/9,5/46,5 + 2/10/60		1		58120060
ZWS	250	3,2	2.2	30	40	WS	2/7/42 + 2/9,5/46,5 + 2/10/60		1		58100018
NF - negative	250	3,2	2.5	30	80	TR-F	2/7/42 + 2/9,5/46,5 + 2/10/60		1		58808203

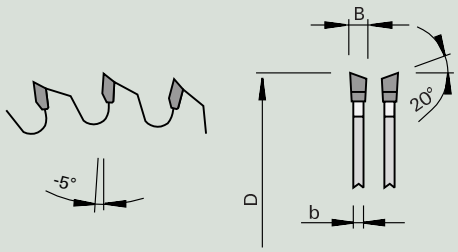
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW K + G - negative

Clipping and Miter Saw Blades HW - alternate bevel

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC06

WS

Machine / Application

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

Design

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

Advantages

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

Notes

Product features / Order information

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

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

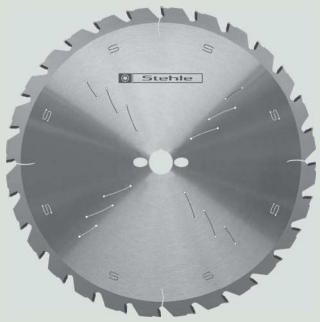
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

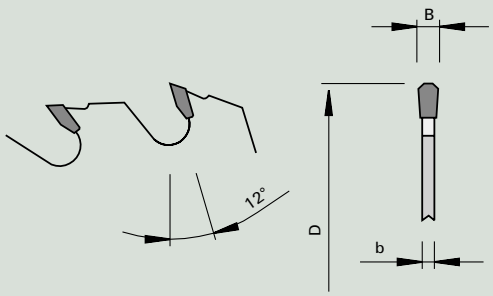
HW BKS (nail proof)

Construction Saw Blades HW - flat with two-sided chamfer

Product



Drawing



Machine

Application

Design

2-0-6

HW
TC25

F-
FA

Machine / Application

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

Design

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

Advantages

- nail-proof

Notes

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

Product features | **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
190	3,0	2.0	30	14	▲	2/7/42	12		1		58112011
210	3,2	2.2	30	14	▲	2/7/42	12		1	o	50112013
235	2,8	1.8	30	16	▲	Combi3	12		1		58112015
250	3,2	2.2	30	16	▲	Combi3	12		1		58120220
300	3,2	2.2	30	20	▲	Combi3	12		1		58120041
315	3,2	2.2	30	20	▲	Combi3	12		1		58120046
350	3,5	2.5	30	24	▲	Combi3	12		1		58120042
400	3,5	2.5	30	28	▲	Combi3	12		1		58120043
450	3,8	2.8	30	30	▲	Combi3	12		1		58120044
500	3,8	2.8	30	34	▲	Combi3	12		1		58120045
600	4,4	3.2	30	36	▲	Combi3	12		1		58120227
700	4,6	3.2	30	42	▲	Combi3	12		1		58120228

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

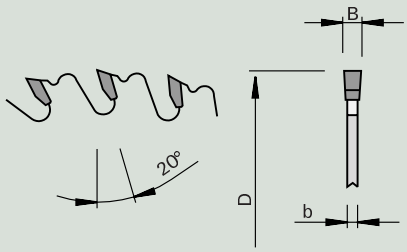
Appropriate **reducing rings** can be found at the end of the chapter

HW ZFL

Trimming Saw Blades HW - flat tooth

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC10

F

Machine / Application

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

Design

- tooth configuration: flat "F"
- cutting material: HW TC10

Advantages

- no chipped edges from knots thanks to chip limiter

Notes

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

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

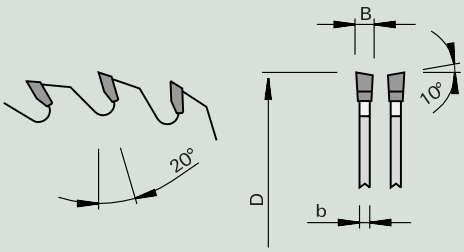
Appropriate **reducing rings** can be found at the end of the chapter

HW ZWZ

Trimming saw blades HW - alternate top bevel

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC20

WS

Machine / Application

- Table saws
- Special machines
- for longitudinal cuts in soft solid woods
- for separating, cross-cutting or miter cutting of beams, gluelam construction timber or plastic panels

Design

- Tooth configuration: alternate top bevel "WS"
- Cutting material: HW TC20

Advantages

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

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
400	4,4	2.8	30	28	▲	Combi3	20		1		58100183 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

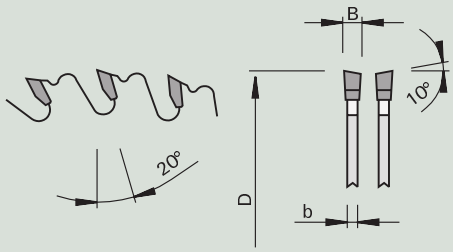
Appropriate **reducing rings** can be found at the end of the chapter

HW ZW

Trimming Saw Blades HW - alternate bevel tooth

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC10

WS

Machine / Application

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

Design

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

Advantages

- no chipped edges from knots thanks to chip limiter

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
250	3,2	2.2	30	24	▲	Combi3	20		1		58102001
300	3,2	2.2	30	28	▲	Combi3	20		1		58102002
315	3,2	2.2	30	28	▲	Combi3	20		1		58102003
350	3,5	2.5	30	32	▲	Combi3	20		1		58101004
400	3,5	2.5	30	36	▲	Combi3	20		1		58101005
450	4,2	2.8	30	20	▲	Combi3	25		1		58101020
450	3,8	2.8	30	40	▲	Combi3	20		1		58101006
500	3,8	2.8	30	44	▲	Combi3	20		1		58102007
600	4,2	3.2	30	54	▲	Combi3	20		1		58101018
700	4,2	3.2	30	60	▲	Combi3	20		1		58101019

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

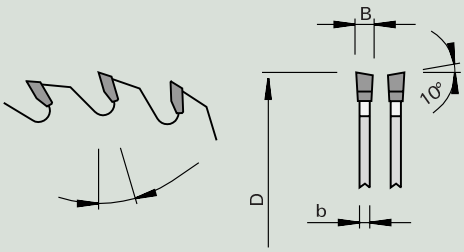
Appropriate **reducing rings** can be found at the end of the chapter

HW ZQW

Trimming Saw Blades HW - alternate bevel tooth

Product

Drawing



Machine

Application

Design

2-0-6

HW **TC06**

HW **TC10**

WS

Machine / Application

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

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC10/HW TC06

Advantages

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

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
150	3,2	2.2	30	24	▲	2/7/42	15		1		58100096
180	3,2	2.2	30	30	▲▲	2/7/42	15		1		58100016
200	3,2	2.2	30	34	▲▲	2/7/42	15		1		58100017
235	2,8	1.8	30	18	▲	2/7/42	20		1		50110256
235	2,8	1.8	30	24	▲▲	2/7/42	15		1		50110170
235	3,2	2.2	30	24	▲	Combi3	10		1		58100191
240	2,8	1.8	30	24	▲▲	2/7/42	20		1		50110174
250	2,8	1.8	30	40	▲▲	Combi3	15		1		58120020
250	3,2	2.2	30	24	▲▲	Combi3	20		1		58120060
250	3,2	2.2	30	30	▲▲	Combi3	20		1		58120061
260	3,2	2.2	30	32	▲▲	Combi3	20		1		58110185
270	3,2	2.2	30	24	▲▲	Combi3	20		1		58110176
300	3,2	2.2	30	24	▲	Combi3	20		1		58120002
300	3,2	2.2	30	36	▲	Combi3	20		1		58120013
315	3,2	2.2	30	28	▲	Combi3	20		1		58120062
315	3,2	2.2	30	36	▲	Combi3	20		1		58100255
330	3,2	2.2	30	24	▲	Combi3	25		1		58120018
335	3,2	2.2	30	36	▲	Combi3	20		1		58120063
350	3,5	2.5	30	24	▲	Combi3	20		1		58120005
350	3,5	2.5	30	32	▲▲	Combi3	20		1		58100011
350	3,5	2.5	30	36	▲	Combi3	20		1		58120014
350	3,5	2.5	30	42	▲	Combi3	20		1		58120015
400	3,5	2.5	30	28	▲	Combi3	20		1		58100005
400	3,5	2.5	30	32	▲	Combi3	20		1		58120008
400	3,5	2.5	30	36	▲▲	Combi3	20		1		58100012
400	3,5	2.5	30	48	▲▲	Combi3	20		1		58120017
410	3,8	2.8	30	28	▲	Combi3	20		1		58120019
450	3,8	2.8	30	40	▲▲	Combi3	20		1		58100013
500	3,8	2.8	30	44	▲▲	Combi3	20		1		58100014

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

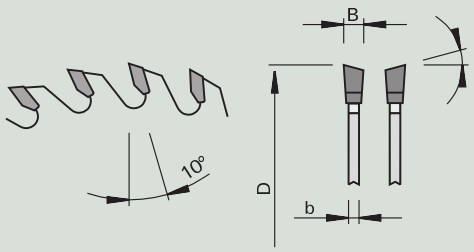
Appropriate **reducing rings** can be found at the end of the chapter

HW ZWS

Trimming and Finish Cut Saw Blades HW - alternate bevel

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC06

WS

Machine / Application

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

Design

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

Advantages

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

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
150	3,2	2.2	30	36	▲▲	2/7/42	10		1		58100099
150	3,2	2.2	30	48	▲▲▲	2/7/42	10		1		58100101
180	3,2	2.2	30	54	▲▲▲	2/7/42	10		1		58100015
200	3,2	2.2	30	48	▲▲▲	2/7/42	10		1		58100091
200	3,2	2.2	30	64	▲▲▲	2/7/42	10		1		58100025
235	2,8	1.8	30	36	▲▲▲	2/7/42	15		1		50110117
235	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1		58110121
235	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1		58110118
235	3,2	2.2	30	34	▲▲		10		1	o	50100193
240	2,8	1.8	30	36	▲▲▲	2/7/42	15		1		50110123
240	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1		50110124
250	3,2	2.2	30	40	▲▲▲	Combi3	10		1		58100018
250	3,2	2.2	30	48	▲▲▲▲	Combi3	10		1		58100026
250	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1		58100031
250	3,2	2.2	30	80	▲▲▲▲	Combi3	10		1		58100038
254	3,0	2.2	20/30	40	▲▲▲		10		1		58114108
254	3,2	2.2	30	40	▲▲▲	Combi3	10		1		58120067
254	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1		58120068
260	3,2	2.2	30	40	▲▲▲	Combi3	10		1		58110175
260	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1		58100254
270	3,2	2.2	30	42	▲▲▲		10		1	o	50110064
270	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1		58110182
280	3,2	2.2	30	48	▲▲▲▲	Combi3	10		1		58110136
300	3,2	2.2	30	48	▲	Combi3	10		1		58100250
300	3,2	2.2	30	60	▲▲	Combi3	10		1		58100027
300	3,2	2.2	30	72	▲▲	Combi3	10		1		58100032
300	3,2	2.2	30	96	▲▲▲	Combi3	10		1		58100251
305	3,2	2.2	30	48	▲	Combi3	10		1		58120065
305	3,2	2.2	30	60	▲▲	Combi3	10		1		58120066
315	3,2	2.2	30	48	▲	Combi3	10		1		58100252
315	3,2	2.2	30	60	▲▲	Combi3	10		1		58100253
350	3,5	2.5	30	54	▲▲	Combi3	10		1		58100021
350	3,5	2.5	30	72	▲▲	Combi3	10		1		58100028
350	3,5	2.5	30	84	▲▲	Combi3	10		1		58100033
350	3,5	2.5	30	108	▲▲▲	Combi3	10		1		58100040
400	3,5	2.5	30	60	▲▲	Combi3	10		1		58100022
400	3,5	2.5	30	84	▲▲▲	Combi3	10		1		58100029
400	3,5	2.5	30	96	▲▲▲	Combi3	10		1		58100034
400	3,5	2.5	30	120	▲▲▲	Combi3	10		1		58100041

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

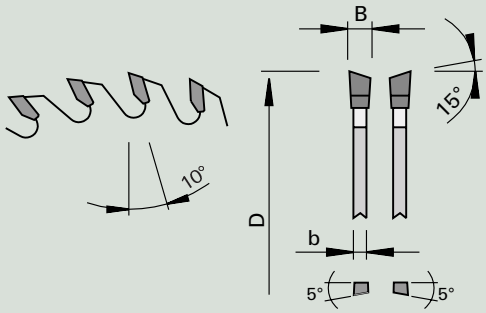
Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
450	3,8	2.8	30	66	▲▲	Combi3	10		1		58100023
450	3,8	2.8	30	108	▲▲▲	Combi3	10		1		58100060
500	3,8	2.8	30	72	▲▲	Combi3	10		1		58100024
550	4,0	3.0	30	64	▲	Combi3	10		1		58120070

HW ZWS-1

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC06**

WSA

Machine / Application

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

Design

- tooth configuration: alternate top bevel with shear angle "WSA"
- cutting material: HW TC06

Advantages

- optimum cutting quality, feed rate and adjustment for material thickness thanks to various numbers of teeth
- reduced cutting pressure thanks to alternating shear angle
- long edge lives provide for the necessary productivity and economic efficiency

Notes

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

Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
250	3,2	2.2	30	40	▲▲	Combi3	10		1		58100700
250	3,2	2.2	30	60	▲▲▲	Combi3	10		1		58100701
300	3,2	2.2	30	48	▲▲	Combi3	10		1		58100702
300	3,2	2.2	30	96	▲▲▲▲	Combi3	10		1		58100703
350	3,5	2.5	30	54	▲▲	Combi3	10		1		58100704

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

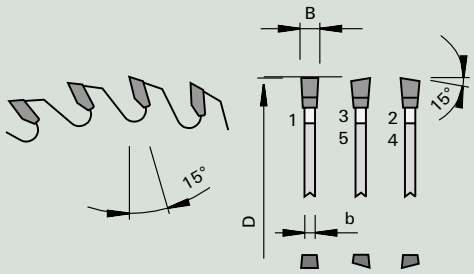
Appropriate **reducing rings** can be found at the end of the chapter

HW Matador 5

Sizing Saw Blades HW - flat-ATB-ATB

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

F-WS-WS

Machine / Application

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

Design

- tooth configuration: flat - ATB - ATB "F-WS-WS"
- cutting material: HW TC04 plus

Advantages

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

Notes

- pay attention to nmax!!!

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]						PU [pc.]	L	Order-No.	
180	3,0	2.2	30	60	▲▲▲▲	4/6/52	15						1		58808701	
200	3,0	2.2	30	65	▲▲▲▲	Combi3	15						1		58808702	
220	3,0	2.2	30	70	▲▲▲▲	8/6/52	15						1	&	58808712	
220	3,0	2.2	40	70	▲▲▲▲	8/6/52	15						1	&	58808703	
240	3,0	2.2	30	75	▲▲▲▲	8/6/52	15						1	&	58808704	
250	3,0	2.2	30	80	▲▲▲▲	Combi3	15						1		58808706	
280	3,0	2.2	30	85	▲▲▲▲	Combi3	15						1		58808705	
300	3,0	2.2	30	100	▲▲▲▲	Combi3	15						1		58808708	
300	4,0	3.2	30	100	▲▲▲▲	Combi3	15	Fimal					1		58808713	NEW
303	3,2	2.2	30	100	▲▲▲▲	Combi3	15						1		58808707	
350	3,0	2.2	30	100	▲▲▲▲	Combi3	15						1		58808709	
500	3,6	2.8	30	145	▲▲▲▲	Combi3	15						1		58808710	
550	4,0	3.2	30	160	▲▲▲▲	Combi3	15						1		58808711	

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

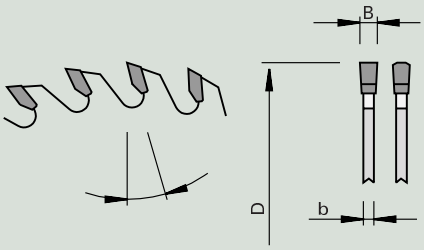
Appropriate **reducing rings** can be found at the end of the chapter

HW TRF

Sizing Saw Blades HW - triple chip / flat

Product

Drawing



Machine	Application	Design
		2-0-6
		HW **TC06**
		TR-F

Machine / Application

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

Design

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

Advantages

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
120	1,8	1.2	20	40	▲▲		5		1		58104063
160	2,2	1.6	20	48	▲▲	2/7/32	5		1		58110161
160	2,2	1.6	20	56	▲▲▲	2/7/32	5		1		58110142
190	2,2	1.6	30	56	▲▲▲		5		1		58458779
190	2,6	2.0	20FX	54	▲▲▲	Fast-Fix	5		1	o	58110229 NEW
216	3,2	2.2	30	60	▲▲▲		5		1		58458780
220	3,2	2.2	30	64	▲▲▲	2/7/42	5		1		58100399
232	3,2	2.2	30	64	▲▲▲		5		1		58458781
250	3,2	2.2	30	60	▲▲	Combi3	5		1		58100385
250	3,2	2.2	30	80	▲▲▲	Combi3	5		1		58100386
300	3,2	2.2	30	72	▲▲	Combi3	5		1		58100387
300	3,2	2.2	30	96	▲▲▲	Combi3	5		1		58100388
350	3,5	2.5	30	72	▲▲	Combi3	10		1		58100300
350	3,5	2.5	30	108	▲▲▲	Combi3	10		1		58100389

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

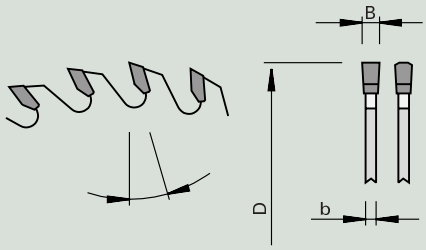
Appropriate **reducing rings** can be found at the end of the chapter

HW TRF - 1

Sizing Saw Blades HW - triple chip / flat

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

TR-F

Machine / Application

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

Design

- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW TC04 plus

Advantages

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

Notes

- especially for plastic-laminated wood-based panels and high-pressure laminated boards

Product features / Order information

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

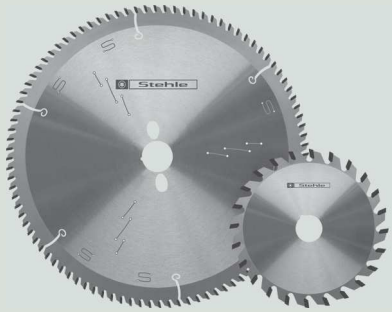
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

HW 3 piece saw blade set in wood box

Set = main and scoring saw blade HW set in wood box

Product	Drawing	Machine	Application	Design
		 		2-0-6 HW **TC06** TR-F

Machine / Application	Design	Advantages	Notes
• table saws with scoring device • panel sizing saw blades with scoring device • for finish cuts in plastic-laminated wood-based panels	• saw blade set consisting of main saw blade and scoring saw blade plus reducing ring • cutting material: HW TC06	• set tools are perfectly matched and guarantee excellent cutting quality for finish cuts • quick and simple adjustment of scoring saw blade and main saw blade • long edge lives thanks to special tungsten carbide • noise-reduction thanks to laser ornaments	

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

Product features			Order information	PU [pc.]	L	Order-No.
Circular Saw Blade Set		Altendorf		1		58804304 NEW
Accessories	**Dimension [mm]**			**PU [pc.]**	**L**	**Order-No.**
main saw blade	350x3,5x2,4x30 Z=72 TR-F			1		58807830
scoring saw blade	180x3,6x2,4x22 Z=36 F			1		58806210
Reducing Rings	22x2,0x20			1		161887

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

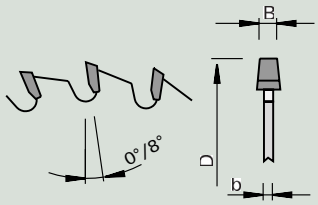
Appropriate **reducing rings** can be found at the end of the chapter

HW RSK - nn-System

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

KO-F

Machine / Application

- table saws
- for scoring of plastic-laminated panels

Design

- special NoNoise gullet geometry
- tooth configuration: conical-flat "KO-F"
- cutting material: HW TC04 plus

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = .0.21 mm wider than main saw kerf
- optimum scoring depth 1.0 - 2.0 mm

Product features | **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]			PU [pc.]	L	Order-No.
100	3,2-4,0	2.5	20	20	▲▲▲▲	8	Schelling	●	1		58807950
120	3,2-4,0	2.5	20	24	▲▲▲▲	8	Altendorf, SCM	●	1		58807951
120	3,2-4,0	2.5	22	24	▲▲▲▲	8	Altendorf, Martin	●	1		58807952
125	3,1-4,0	2.5	20	24	▲▲▲▲	8	Panhans, Paolini	●	1		58807953

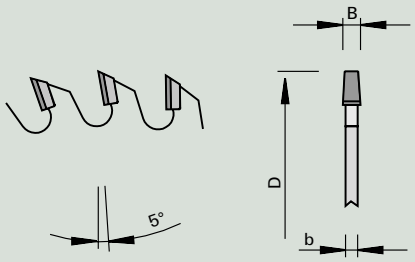
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

DP RSK

Scoring Saw Blades DP - conical-flat

Product

Drawing



Machine

Application

Design

4,5 mm

3-0-1

KO-F

Machine / Application

- table saws
- for scoring of laminated panels

Design

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

Advantages

- short delivery times

Notes

- application with feed

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]			PU [pc.]	L	Order-No.
120	3,1-3,9	2.5	22	16	▲▲▲▲	5	Altendorf, Martin	●	1	s	58750101

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

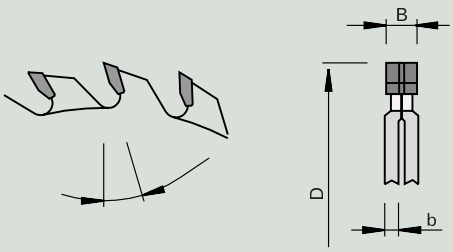
Appropriate **reducing rings** can be found at the end of the chapter

HW RS2

Scoring Saw Blades HW - adjustable flat tooth

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC03

F

Machine / Application

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

Design

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

Advantages

- universally applicable

Notes

- split version - cutting width adjustable with spacers

Product features / Order information

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

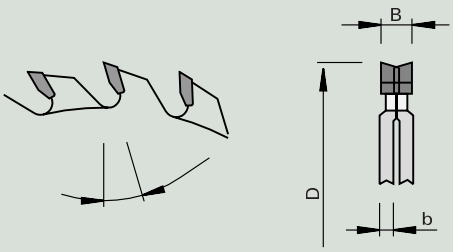
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW RSVS

Scoring Saw Blades HW - adjustable alternate bevel tooth

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC03

WS

Machine / Application

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

Design

- tooth configuration: alternate top bevel "WS"
- cutting material: HW TC03

Advantages

- low motor output thanks to tooth configuration "WS"

Notes

- 58807910: split version - cutting width adjustable with spacers

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]			PU [pc.]	L	Order-No.
120	2,8-3,8	2.2	22	2x12	▲▲▲▲	12		Martin NC adjustment unit	1		50807854
120	2,8-3,8	2.2	50	2x12	▲▲▲▲	12		Altendorf, Martin	1		50807902
140	2,8-3,8	2.0	36	2x12	▲▲▲▲	12		Martin T75 PreX	1		50807909
160	2,8-3,6	2.2	20	2x16	▲▲▲▲	12		CSM	1	o	58807910

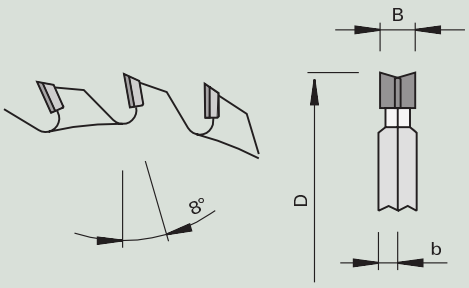
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Countersunk Screws - with Torx	M5x6,8 T15	mounting screw for interior flange	10		180839
Countersunk Screws - with Torx	M5x10,8 T15	mounting screw for exterior flange	10		180840

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

DP RSVS
Scoring Saw Blades DP - adjustable alternate bevel

Product

Drawing



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

Design
- tooth configuration: alternate top bevel "WS"
- cutting material: DP
- resharpening area 4,5 mm
- coated saw blade body

Advantages

Notes
- split version - cutting width adjustable with spacersapplication with feed

Machine / Application / Design: 4,5 mm; 3-0-1; WS

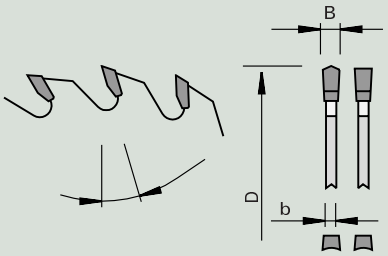
Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]			PU [pc.]	L	Order-No.
120	2,8-3,8	2.2	22	2x12	▲▲▲▲	2/3,8/42	8	Altendorf, Martin		1		50750102
120	2,8-3,8	2.2	50	2x12	▲▲▲▲	4/6,2/62	8	Altendorf adjustment unit		1	o	50750105

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

Product

Drawing



Machine / Application / Design: 3-0-1; HW TC06; DA-F DU

Machine / Application
- clipping and miter saws
- table saws
- vertical panel sizing saws
- for sizing cuts in plastic and solid wood profile ledges

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

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

Notes

Product features / **Order information**

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

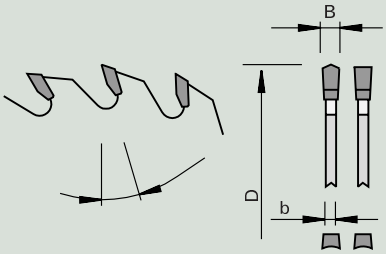
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

HW KDF - Industry

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC06**

DA-F DU

Machine / Application

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

Design

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

Advantages

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

Notes

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

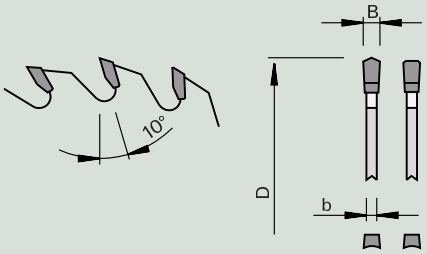
Appropriate **reducing rings** can be found at the end of the chapter

HW KDF - Industry Plus

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

Product

Drawing



Machine

Application

Design

LONG LIFE

LOW noise

3-0-1

DA-F-FA DU

Machine / Application

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

Design

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

Advantages

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

Notes

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

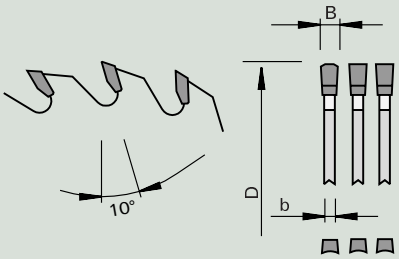
Appropriate **reducing rings** can be found at the end of the chapter

HW KDF - Industry Professionell

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC03**

TR-F-F DU

Machine / Application

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

Design

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

Advantages

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

Notes

Product features

Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

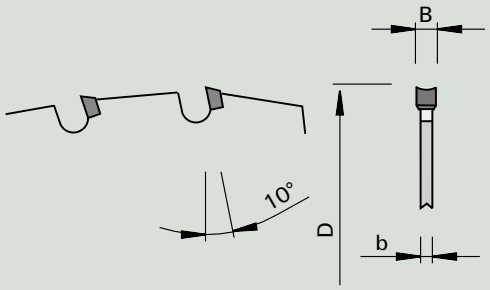
Appropriate **reducing rings** can be found at the end of the chapter

DP HRP - nn-System DP flex

Sizing Saw Blades DP hollow back tooth

Product

Drawing



Machine

Application

Design

3-0-1

HR

Machine / Application

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

Design

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

Advantages

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

Notes

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

Product features / **Order information**

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

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

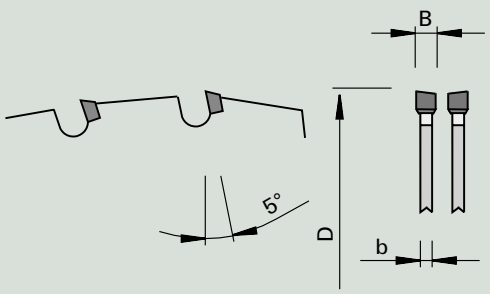
Appropriate **reducing rings** can be found at the end of the chapter

DP RSK - nn-System DP flex

Scoring Saw Blades DP - alternate top bevel

Product

Drawing



Machine

Application

Design

3-0-1

WS

Machine / Application

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

Design

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

Advantages

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

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]			PU [pc.]	L	Order-No.
120	2,6	2.0	20	24	▲▲▲▲		5			1		58459419
120	2,6	2.0	22	24	▲▲▲▲		5			1		58459365
125	2,6	2.0	20	24	▲▲▲▲		5			1		58459436
180	2,6	2.0	22	36	▲▲▲▲		5	Altendorf		1		58192964 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

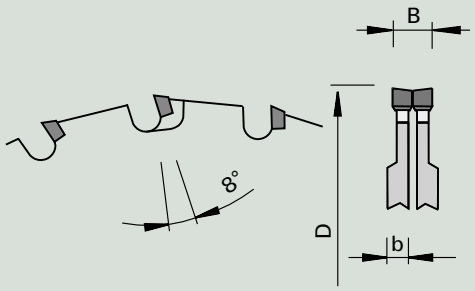
Appropriate **reducing rings** can be found at the end of the chapter

DP RSK - nn-System DP flex - adjustable

Scoring Saw Blades DP „WS“ - adjustable

Product

Drawing



Machine

Application

Design

3-0-1

WS

Machine / Application

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

Design

- tooth configuration: alternate top bevel “WS”
- cutting material: DP
- resharpenable 2 times
- smallest gullets
- coated saw blade body

Advantages

- Hardly perceivable noise
- highest economic efficiency and productivity thanks to extremely long edge life
- the coating protects the body against corrosion and adhesion of particles and reduces the friction on the tool body

Notes

- Altendorf RAPIDO / adjustable

Product features | **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]		PU [pc.]	L	Order-No.
120	2,4-3,2	2.2	50	12+12	▲▲▲▲	8		1		58459461

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

Main/scoring saw combination for panel sizing saws

Machine	Tool type		ØD	B	b	Ød	Z	Tooth configuration	Hook angle	Stehle pin hole	Stehle
SCM - Gabbiani											
Galaxy 115	main saw blade	HW	400	4,4	3,2	80	72	TR-F	15	Combi5	58807809
	main saw blade	DP	400	4,4	3,2	80	72	TR-F-FA	15	Combi5	50750134
Galaxy3 110, 110A	main saw blade	HW	400	4,4	3,2	80	72	TR-F	15	Combi5	58807809
	main saw blade	DP	400	4,4	3,2	80	72	TR-F-FA	15	Combi5	50750134
Galaxy3 130, 130A	main saw blade	HW	430	4,4	3,2	80	72	TR-F	15	Combi5	58806479
Galaxy3 145	main saw blade	HW	430	4,4	3,2	80	72	TR-F	15	Combi5	58806479
Giben											
G 2000 Starmatic	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
MK,Gamma,N,ST, SE, Trend	main saw blade	HW	355	4,4	3,0	75	72	TR-F	10	4/15/105	58807888
	scoring saw blade	HW	125	4,3-5,5	3,2	45	24	CON	0		
Prismatic 101	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
	scoring saw blade	DP	160	4,4-5,2	3,2	45	30	KO-F	5	3/11/70	50750121
Prismatic 201	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
Haisung Woodworking Machinery											
HSWWMC-2600III/3200III	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
Hansol Maschine											
NCNC-2600H10/2600H13/3660H13	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
Holz-Her											
Cut 110	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
Cut 85 82	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

Machine type	Tool type		ØD	B	b	Ød	Z	Tooth configuration	Hook angle	Stehle pin hole	Stehle
Holzma											
22	scoring saw blade	HW	200	4,85-5,65	3,5	45	36	KO-F	8		58806134
	scoring saw blade	DP	200	4,8-5,6	3,5	45	30	KO-F	5		50750127
HPP180	main saw blade	HW	380	4,8	3,5	60	72	TR-F	15	Combi7	58806065
	main saw blade	DP	380	4,8	3,5	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750131
	main saw blade	DP	380	4,4	3,2	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750130
	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	HW	200	4,4-5,2	3,5	45	36	KO-F	8		58803074
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
HPP350	main saw blade	HW	350	4,4	3,2	60	72	TR-F	10	Combi7	58807955
	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
HPP380, 82	main saw blade	HW	380	4,8	3,5	60	72	TR-F	15	Combi7	58806065
	main saw blade	DP	380	4,8	3,5	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750131
	main saw blade	DP	380	4,4	3,2	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750130
	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	HW	180	4,85-5,65	3,5	45	36	KO-F	8		58807862
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
	scoring saw blade	DP	180	4,8-5,6	3,5	45	30	KO-F	5		50750124
HPL410	main saw blade	HW	420	4,8	3,5	60	72	TR-F	15	Combi7	58807956
	main saw blade	DP	420	4,8	3,5	60	60	Tr-F-FA	15	2/10/80 + 2/14/125	50750135
	scoring saw blade	HW	180	4,85-5,65	3,5	45	36	KO-F	8		58807862
	scoring saw blade	DP	180	4,8-5,6	3,5	45	30	KO-F	5		50750124
HPL550	scoring saw blade	HW	200	4,85-5,65	3,5	45	36	KO-F	8		58806134
	scoring saw blade	DP	200	4,8-5,6	3,5	45	30	KO-F	5		50750127
HPL570	scoring saw blade	HW	200	4,85-5,65	3,5	45	36	KO-F	8		58806134
	scoring saw blade	DP	200	4,8-5,6	3,5	45	30	KO-F	5		50750127
HPP230,250 (vor 06/2014)	main saw blade	HW	350	4,4	3,2	60	72	TR-F	10	Combi7	58807955
	scoring saw blade	HW	200	4,4-5,2	3,5	45	36	KO-F	8		58803074
	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
HPP130	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
HPP430,510,11	main saw blade	HW	450	4,8	3,5	60	72	TR-F	15	Combi7	58807817
	main saw blade	DP	450	4,8	3,5	60	72	TR-F-FA	15	Combi7	50750136
	scoring saw blade	HW	180	4,85-5,65	3,5	45	36	KO-F	8		58807862
	scoring saw blade	DP	180	4,8-5,6	3,5	45	30	KO-F	5		50750124
Homag											
CH 04	scoring saw blade	HW	180	4,4-5,2	3,2	45	36	KO-F	8		58803104
	scoring saw blade	DP	180	4,4-5,2	3,2	45	30	KO-F	5		50750123
CH 08/12	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
Hyundai Sangi											
CNC 740SD/CNC-740LSD	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
	scoring saw blade	HW	200	4,4-5,2	3,5	45	36	KO-F	8		58803074
	scoring saw blade	HW	200	4,4-5,2	3,5	45	36	KO-F	8		58803074
KDT											
KS-226, 232	main saw blade	HW	355	4,4	3,2	75	72	TR-F	15	4/15/105	58808888
	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
KS-829P, 829CP	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
KS-823P, 832CP	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133
KS-838CP	main saw blade	HW	400	4,4	3,2	75	72	TR-F	15	4/15/105 + 2/7/110	58806071
	main saw blade	DP	400	4,4	3,2	75	72	TR-F-FA	15	4/15/105 + 2/7/110	50750133

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

Machine type	Tool type		ØD	B	b	Ød	Z	Tooth configuration	Hook angle	Stehle pin hole	Stehle
Nanxing											
NZH3318, NPD380	main saw blade	HW	450	4,8	3,5	60	72	TR-F	15	Combi7	58807817
	main saw blade	DP	450	4,8	3,5	60	72	TR-F-FA	15	Combi7	50750136
	scoring saw blade	HW	180	4,85-5,65	3,5	45	36	KO-F	8		58807862
	scoring saw blade	DP	180	4,8-5,6	3,5	45	30	KO-F	5		50750124
NPL330HG, NP330H, NP330HG	main saw blade	HW	450	4,8	3,5	60	72	TR-F	15	Combi7	58807817
	main saw blade	DP	450	4,8	3,5	60	72	TR-F-FA	15	Combi7	50750136
	scoring saw blade	HW	180	4,85-5,65	3,5	45	36	KO-F	8		58807862
	scoring saw blade	DP	180	4,8-5,6	3,5	45	30	KO-F	5		50750124
NPC330	main saw blade	HW	380	4,8	3,5	60	72	TR-F	15	Combi7	58806065
	main saw blade	DP	380	4,8	3,5	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750131
	main saw blade	DP	380	4,4	3,2	60	72	TR-F-FA	10	2/14/100 + 2/14/125	50750130
	main saw blade	HW	350	4,4	3,2	60	72	TR-F	10	Combi7	58807955
	scoring saw blade	HW	200	4,4-5,2	3,5	45	36	KO-F	8		58803074
NP380FG, NP330FG, NP330F	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
NP280FG, NP280F	main saw blade	HW	350	4,4	3,2	60	72	TR-F	10	Combi7	58807955
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Panhans											
693/SH 110	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Euro 10 SF	main saw blade	HW	300	4,4	3	30	60	TR-F	10	Combi3	58806053
Euro 12 SF	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
Euro 12,30	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Euro 32	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Euro 5 (SF,Compact, Ecopan	main saw blade	HW	300	4,4	3	30	60	TR-F	10	Combi3	58806053
Euro10, 693/SH 70	main saw blade	HW	300	4,4	3	30	60	TR-F	10	Combi3	58806053
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Eurostar 2 XL,Polystar	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Eurostar 2 XXL	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Polypan 47	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
S 45	main saw blade	HW	300	4,4	3	30	60	TR-F	10	Combi3	58806053
	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
	scoring saw blade	HW	180	4,4-5,2	3,2	30	30	KO-F	8	2/10/60	58807858
	scoring saw blade	DP	180	4,4-5,2	3,2	30	30	KO-F	5	2/10/60	50750122
Scheer											
PA 6000, 5500	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

Machine Type	Tool Type		ØD	B	b	Ød	Z	Tooth configuration	Hook angle	Stehle pin hole	Stehle
Schelling											
FH4 (bis 06/2015)	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
FH4 07/2015-07/2017	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
FH5	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
FH5 ab 07/2015	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
FH6,AH6,CH6 bis 06/2015	main saw blade	DP	460	4,4	3,2	30	72	TR-F-FA	15	3/13/94	50750146
	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
FH6,AH6CH6 ab 07/2015	main saw blade	DP	480	4,8	3,5	30	72	TR-F-FA	15	2/10/60 + 2/13/94	50750139
FK4 bis 06/2015	main saw blade	HW	350	4,4	3,0	30	72	TR-F	10	Combi3 + 2/13/94	58808803
	main saw blade	DP	350	4,4	3,2	30	72	TR-F-FA	10	Combi 1	50750128
	main saw blade	DP	350	4,4	3,0	30	72	TR-F-FA	10	Combi2 + 2/13/94	50750129
FK4 ab 07/2015	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
FK4 ab 07/2017	main saw blade	HW	400	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58806069
	main saw blade	DP	400	4,4	3,2	30	72	TR-F-FA	15	Combi3 + 2/13/94	50750132
FK6,FP6, FM6	main saw blade	DP	460	4,4	3,2	30	72	TR-F-FA	15	3/13/94	50750146
	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
AL	main saw blade	HW	450	4,4	3,2	30	72	TR-F	15	Combi3 + 2/13/94	58458789
	scoring saw blade	HW	200	4,4-5,2	3,5	20	36	KO-F	8		58803073
	scoring saw blade	DP	200	4,4-5,2	3,2	20	30	KO-F	5		50750125
	scoring saw blade	DP	200	4,4-5,2	3,2	20	36	KO-F	5		50750147
SCM											
Prima 50	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Prima 67	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Impact 105 C/D, PlusC/D/	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Impact 85 K	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Impact 90	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Impact 110	main saw blade	HW	400	4,4	3,2	80	72	TR-F	15	Combi5	58807809
	main saw blade	DP	400	4,4	3,2	80	72	TR-F-FA	15	Combi5	50750134
	scoring saw blade	HW	160	4,4-5,2	3,2	55	36	KO-F	8	3/7/66	58803072
Selco											
EB 70 (kit80), 75 (Sector 430) 80 Sector 450)	main saw blade	DP	320	4,4	3,2	65	60	TR-F-FA	10	2/9/110	50750120
	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130
WNZ	main saw blade	DP	320	4,4	3,2	65	60	TR-F-FA	10	2/9/110	50750120
	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130
EB 70(L)	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 2/9/110	58806130
EB 95, Sector 470,SK470	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 2/9/110	58806130
EB108, EB110, EB120	main saw blade	HW	400	4,4	3,2	80	72	TR-F	15	Combi5	58807809
	main saw blade	DP	400	4,4	3,2	80	72	TR-F-FA	15	Combi5	50750134
	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130
EB/EBT 120, WN125	main saw blade	HW	430	4,4	3,2	80	72	TR-F	15	Combi5	58806479
	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130
EB100	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130
WN 600/132, WN200	main saw blade	DP	450	4,8	3,5	80	72	TR-F-FA	15	4/19/120 + 2/8,4/130	50750137
	scoring saw blade	DP	200	4,8-5,6	3,5	65	30	KO-F	5	2/8,4/110	50750126
WNA 600/162	scoring saw blade	DP	200	4,8-5,6	3,5	65	30	KO-F	5	2/8,4/110	50750126
WNA 600/145, WN 512	scoring saw blade	DP	200	4,8-5,6	3,5	65	30	KO-F	5	2/8,4/110	50750126
WN 610, WN 630 (PFS)	scoring saw blade	HW	200	4,45-5,25	3,2	65	36	KO-F	8	4/9/100 + 4/9/110	58806130

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

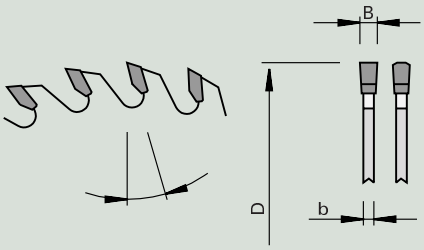
Appropriate **reducing rings** can be found at the end of the chapter

HW TFP

Panel Sizing Saw Blades HW - triple-chip - flat

Product

Drawing



Machine	Application	Design
		3-0-1
		HW **TC04 plus**
		TR-F

Machine / Application

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

Design

- tooth configuration: triple chip / flat "TR-F"
- cutting material: HW TC04 plus

Advantages

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

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]			PU [pc.]	L	Order-No.
300	4,4	3.0	30	60	▲▲▲	Combi3	10	Panhans	●	1		58806053
350	4,4	3.0	30	72	▲▲▲	Combi3 + 2/13/94	10	SCM, Panhans, Mayer, Schelling, HOLZ-HER	●	1		58807803
350	4,4	3.2	60	72	▲▲▲	Combi7	10	Holzma 72 HPP 350	●	1		58807955
355	4,4	3.0	75	72	▲▲▲	4/15/105	10	Gibben	●	1		58807888
380	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1		58806065
400	4,4	3.2	30	72	▲▲▲	Combi3 + 2/13/94	15	Schelling, Mayer, Irion, Scheer, HOLZ-HER	●	1		58806069
400	4,4	3.2	75	72	▲▲▲	4/15/105 + 2/7/110	15	Giben, Homag	●	1		58806071
400	4,4	3.2	80	72	▲▲▲	Combi5	15	Selco, Irion	●	1		58807809
420	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1		58807956
430	4,4	3.2	80	72	▲▲▲	Combi5	15	Selco	●	1		58806479
450	4,4	3.2	30	72	▲▲	Combi3 + 2/13/94	15	Irion, Schelling	●	1		58458789
450	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1		58807817

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

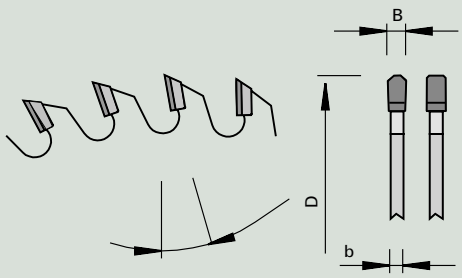
Appropriate **reducing rings** can be found at the end of the chapter

DP TFP

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

Product

Drawing



Machine

Application

Design

4,5 mm

3-0-1

TR-F-FA

Machine / Application

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

Design

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

Advantages

- short delivery times

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]			PU [pc.]	L	Order-No.
320	4,4	3.2	65	60	▲▲▲	2/9/110	10		●	1	o	50750120
350	4,4	3.2	30	72	▲▲▲	Combi1	10	SCM, Panhans, Mayer, Schelling, Scheer	●	1	o	50750128
350	4,4	3.0	30	72	▲▲▲	Combi2	10	SCM, Panhans, Mayer, Schelling, Scheer	●	1	o	50750129
380	4,4	3.2	60	72	▲▲▲	2/14/100 + 2/14/125	10	Holzma	●	1	o	50750130
380	4,8	3.5	60	72	▲▲▲	2/14/100 + 2/14/125	10	Holzma	●	1	o	50750131
400	4,4	3.2	30	72	▲▲▲	Combi3 + 3/13/94	15	Schelling, Mayer, Scheer, Irion	●	1	o	50750132
400	4,4	3.2	75	72	▲▲▲	4/15/105 + 2/7/110	15	Giben, Homag	●	1	o	50750133
400	4,4	3.2	80	72	▲▲▲	Combi5	15	Schelling, Mayer, Scheer, Irion	●	1	o	50750134
420	4,8	3.5	60	60	▲▲	2/10/80 + 2/14/125	15	Holzma	●	1	o	50750135
450	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1	o	50750136
450	4,8	3.5	80	72	▲▲▲	4/19/120 + 2/8,4/130	15	Selco	●	1	o	50750137
450	4,4	3.2	30	72	▲▲▲		15	Selco	●	1	o	50750138
460	4,4	3.2	30	72	▲▲▲	3/13/94	15	Schelling	●	1	o	50750146
480	4,8	3.5	30	72	▲▲▲	2/10/60 + 2/13/94	15	Schelling	●	1	o	50750139
480	4,8	3.5	60	72	▲▲▲	2/19/120	15	Holzma	●	1	o	50750140

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

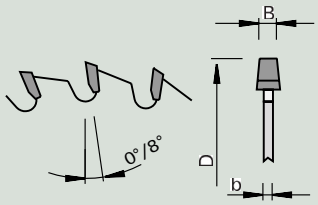
Appropriate **reducing rings** can be found at the end of the chapter

HW RSK - nn-System

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

Product

Drawing



Machine

Application

Design

3-0-1

KO-F

Machine / Application

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

Design

- special NoNoise gullet geometry
- tooth configuration: conical-flat "KO-F"
- cutting material: HW TC03

Advantages

- quick adjustment
- universally applicable
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth
- especially low noise level
- noise reduction by approx. 6 dB(A) when idling
- excellent cutting quality in all common coatings
- long edge lives provide for the necessary productivity and economic efficiency

Notes

- height adjustable to kerf of main saw blade
- 1 mm scoring depth = 0.2 1 mm wider than main saw kerf
- optimum scoring depth 1.0 - 2.0 mm

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

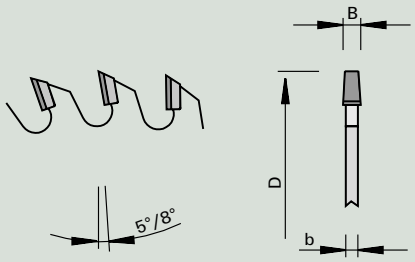
Appropriate **reducing rings** can be found at the end of the chapter

DP RSK

Scoring Saw Blades DP - conical-flat

Product

Drawing



Machine

Application

Design

3-0-1

KO-F

Machine / Application

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

Design

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

Advantages

- short delivery times

Notes

- application with feed

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

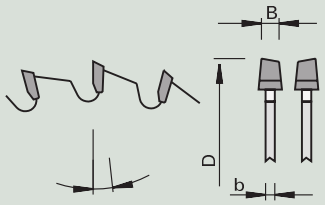
Appropriate **reducing rings** can be found at the end of the chapter

HW RSK-WS

Scoring Saw Blades HW - conical / alternate top bevel

Product

Drawing



Machine	Application	Design
		3-0-1 HW **TC04 plus**

Machine / Application

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

Design

- tooth configuration: conical / alternate top bevel "KO-WS"
- cutting material: HW TC04 plus

Advantages

- low motor output thanks to tooth configuration "KO-WS"
- for longer edge lives compared to TC03 plus
- optimum cutting quality thanks to improved runout accuracy
- reduction of the scoring depth

Notes

- height adjustable to kerf of main saw blade
- optimum scoring depth 1.0 - 2.0 mm

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]	PU [pc.]	L	Order-No.
180	4,45-5,25	3.2	30	30	▲▲▲	8	1		58807970 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

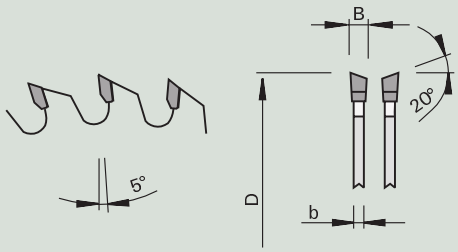
Appropriate **reducing rings** can be found at the end of the chapter

HW OKW

Optimizing Chop Saw Blades HW - alternate top bevel

Product

Drawing



Machine

Application

Design

3-0-1

HW TCw15

WS

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**

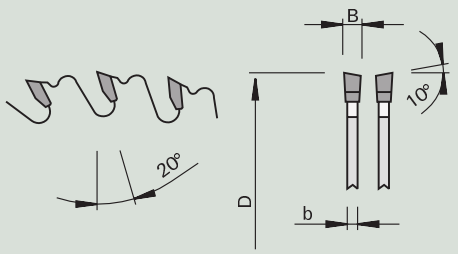
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
500	4,6	3.5	30	144	▲▲▲	2/15/63 + 2/10/60	5	○	1		50807842

HW Planet

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

Product

Drawing



Machine

Application

Design

3-0-1

HW TC20

WS

Machine / Application

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

Design

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

Advantages

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

Notes

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

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Number of rakers [pc.]		PU [pc.]	L	Order-No.
350	3,8	2.5	30	24	▲	Combi2	2+2	○	1		50804422
400	4,2	3,0	30	28	▲	Combi2	2+2	○	1		50804423
450	4,2	3.0	30	36	▲	Combi2	2+2	○	1		50804425

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

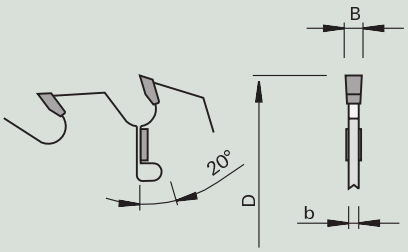
Appropriate **reducing rings** can be found at the end of the chapter

HW LWR

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

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC25

F

Machine / Application

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

Design

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

Advantages

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

Notes

- for cutting height > 50 mm

Product features / Order information

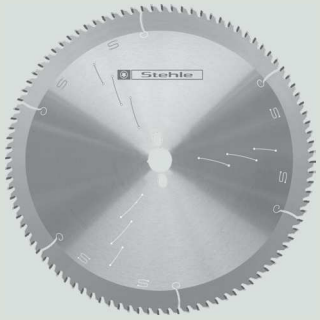
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	DKN [mm]	Number of rakers [pc.]		PU [pc.]	L	Order-No.
250	3,2	2.2	70	20	▲	2 x 20x5	2+2		1		50457841
300	3,4	2.2	70	22	▲	2 x 20x5	2+2		1		50100525
350	3,6	2.5	70	20	▲	2 x 20x5	2+2		1		50100528
350	3,6	2.4	70	28	▲	2 x 20x5	2+2		1		50457843

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

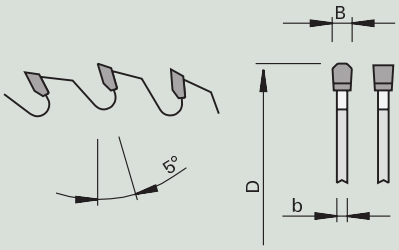
HW NF - positive

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

Product



Drawing



Machine

Application

Design

2-0-6

3-0-1

TR-F

Machine / Application

- table saws
- clipping and miter saws
- for dividing and miter cuts in aluminum and plastic profiles, aluminum sheets on machines with workpiece clamping as well as wood-based panels (Corian®, Noblan, Varicor® and HPL)

Design

- positive hook angle
- tooth configuration: triple chip / flat "TR-F"
- quality 3-0-1 from Ø 301 upwards
- cutting material: HW TCm10 from Ø 301 TC06

Advantages

- noise-reduction thanks to laser ornaments

Notes

- tight workpiece clamping required

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Cutting material		PU [pc.]	L	Order-No.
250	3,2	2.5	30	80	▲▲	Combi3	5	TC10		1		58808102
300	3,2	2.5	30	72	▲▲	Combi3	5	TC10		1		58808104
300	3,2	2.5	30	96	▲▲▲	Combi3	5	TC10		1		58808107
300	3,2	2.5	32	96	▲▲▲	4/12/64 + Combi3	5	TC10		1	o	58808125
350	3,2	2.5	30	108	▲▲▲	Combi3	5	TC06		1		58808111
400	3,8	3.2	30	96	▲▲	Combi3	5	TC06		1		58808113
420	3,8	3.2	30	96	▲▲	Combi3	5	TC06		1		58808115
450	3,8	3.2	40	108	▲▲▲	4/12/64 + 2/10/60	5	TC06		1		58808117
500	4,0	3.4	30	120	▲▲▲	4/12/64 + 2/10/60	5	TC06		1		58808118

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

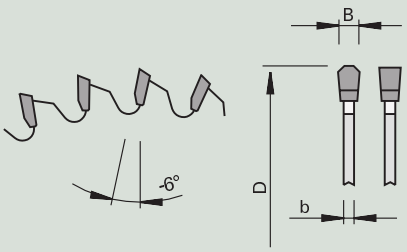
Appropriate **reducing rings** can be found at the end of the chapter

HW NF - negative

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

Product

Drawing



Machine / Application

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

Design

- negative hook angle
- tooth configuration: triple chip / flat "TR-F"
- quality 3-0-1 from Ø 301 upwards
- cutting material: HW TCm10 from Ø 301 TC06

Advantages

- noise-reduction thanks to laser ornaments

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
235	2,8	2.2	30	64	▲▲	2/7/42	-6		1		58115018
250	3,2	2.5	30	60	▲▲	Combi3	-6		1		58808201
250	2,8	2.2	30	80	▲▲▲	Combi3	-6		1		58808200
250	3,2	2.5	30	80	▲▲▲	Combi3	-6		1		58808203
250	3,2	2.5	32	60	▲▲	Combi3	-6		1	o	58808202
250	3,2	2.5	32	80	▲▲▲	Combi3	-6		1	o	58808204
250	3,2	2.5	40	80	▲▲▲	4/12/64 + 2/9/55 + Combi3	-6		1	o	58808205
254	3,2	2.5	30	80	▲▲▲	Combi3	-6		1	o	58808246
260	3,2	2.5	30	72	▲▲	Combi3	-6		1		58808206
300	3,2	2.5	30	72	▲▲	Combi3	-6		1		58808209
300	3,2	2.5	30	84	▲▲▲	Combi3	-6		1	o	58808244
300	2,8	2.2	30	96	▲▲▲	Combi3	-6		1		58808213
300	3,2	2.5	30	96	▲▲▲	Combi3	-6		1		58808214
300	3,2	2.5	32	96	▲▲▲	4/12/64	-6		1		58808215
300	3,3	2.5	40	96	▲▲▲	4/12/64 + 2/9/55	-6		1		58808216
305	3,2	2.5	30	96	▲▲▲	Combi3	-6		1		58808245
305	3,2	2.5	30	60	▲▲	Combi3	-6		1		58808241
330	3,2	2.5	30	96	▲▲▲	Combi3	-6		1		58808217
330	3,2	2.5	32	96	▲▲▲	Combi3	-6		1	o	58808218
350	3,2	2.5	30	90	▲▲	Combi3	-6		1		58808222
350	3,2	2.5	30	108	▲▲▲	Combi3	-6		1		58808225
350	3,2	2.5	32	108	▲▲▲	4/12/64	-6		1		58808226
350	3,2	2.5	40	108	▲▲	4/12/64 + 2/9/55	-6		1	o	58808227
380	3,8	3.2	32	110	▲▲▲	4/12/64	-6		1		58808243
400	3,8	3.2	30	96	▲▲	Combi3	-6		1		58808232
420	4,0	3.2	30	96	▲▲	Combi3	-6		1		58808234
420	3,8	3.2	40	100	▲▲▲	4/12/64 + 2/9/55	-6		1		58808236
450	3,8	3.2	30	96	▲▲	4/12/64 + 2/12/80 + Combi3	-6		1		58808235
500	4,0	3.4	30	120	▲▲▲	4/12/64 + 2/10/60	-6		1		58808239

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

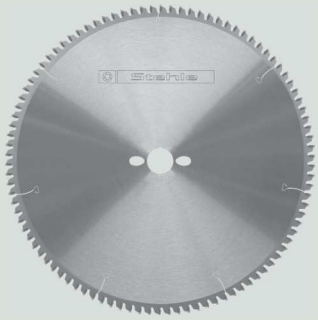
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

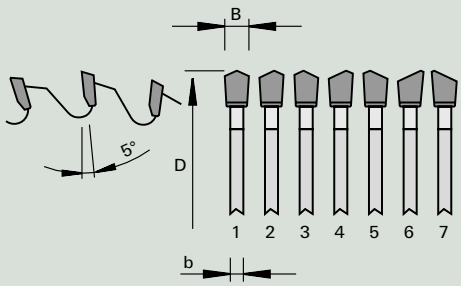
HW NF- Positive - Profiles "G7"

NF circular saw blades HW - positive hook angle - profile "G7"

Product



Drawing



Machine

Application

Design

3-0-1

HW **TC06**

G7

Machine / Application

- table saws
- for burr-free and smooth cuts in thin-walled aluminum window and façade profiles and PVC profiles

Design

- positive hook angle
- tooth configuration: "G7"
- cutting material: HW TC06

Advantages

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

Notes

- secure workpiece clamping required
- max. wall thickness 5 mm

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL	Hook angle [°]		PU [pc.]	L	Order-No.
300	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70	5		1		58192663
350	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60	5		1		58192662
400	3,8	3.2	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64	5		1		58192659
420	3,8	3.2	30	98	▲▲▲▲		5		1		58192660
500	4,0	3.4	30	126	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64	5		1		58192661

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

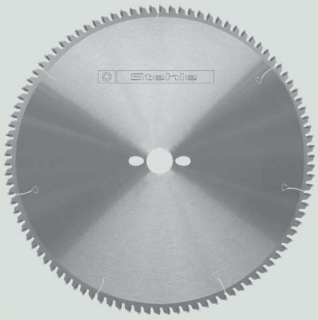
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

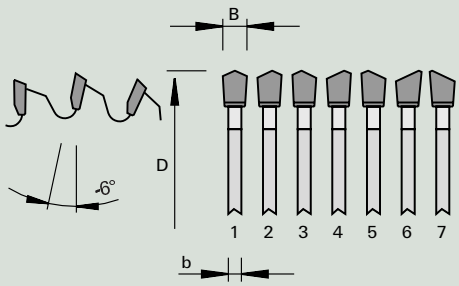
HW NF-Chop - Negative - Profiles “G7”

NF chop saw blades HW - negative hook angle - profile “G7”

Product



Drawing



Machine	Application	Design
		
		3-0-1
		HW **TC06**
		G7

Machine / Application

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

Design

- negative hook angle
- tooth configuration: “G7”
- cutting material: HW TC06

Advantages

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

Notes

- secure workpiece clamping required
- max. wall thickness 5 mm

Product features | **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL	Hook angle [°]			PU [pc.]	L	Order-No.
250	3,2	2.5	30	84	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6			1		58192965
300	3,2	2.5	30	98	▲▲▲▲	2/11/70	-6			1		58192568
350	3,2	2.5	30	112	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6			1		58192275
350	3,5	2.8	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6	DeWALT, Haffner, Pfeiffer, Rotox		1		58192274
350	3,8	3.2	40	84	▲▲▲▲	4/12/64 + 2/9/55	-6	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann		1		58192273
380	3,8	3.2	32	112	▲▲▲▲		-6	Elumatec		1		58192567
400	3,8	3.2	30	98	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6	DeWALT, Haffner		1		58192276
420	4,0	3.2	30	98	▲▲▲▲	2/10/60 + 2/11/70	-6	Rapid, ELU		1		58192277
450	3,8	3.2	30	112	▲▲▲▲	2/10/60+2/12/64 +4/15/80	-6	DeWALT, Haffner		1		58192278
500	4,0	3.4	30	126	▲▲▲▲	2/11/70 + 2/10/60	-6	Pfeiffer, Rapid		1		58192279
550	4,0	3.4	30	133	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6	Pfeiffer, Rapid		1		58192392

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

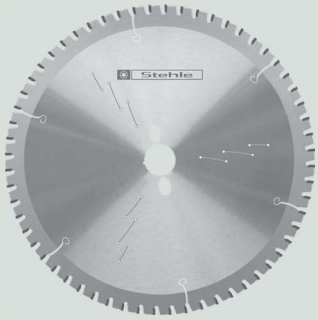
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

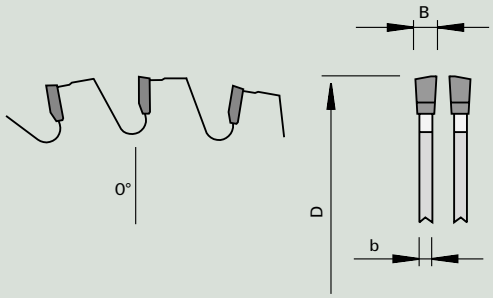
HW Unisteel

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

Product



Drawing



Machine

Application

Design

3-0-1

HW **TCm13**

F-WFA

Machine / Application

- table saws
- clipping and miter saws
- for dividing and miter cuts in metals and NF-metals (zinc) plates, cast iron, etc.

Design

- tooth configuration: flat with alternating chamfer "F-WFA"
- cutting material: HW TCm13

Advantages

- improved cutting quality thanks to special cutting geometry

Notes

- for wood-based panels and plastics see ZWS and Parat - negative (HSK)
- reduced edge lives in the case of stainless steel

Product features / Order information

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

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

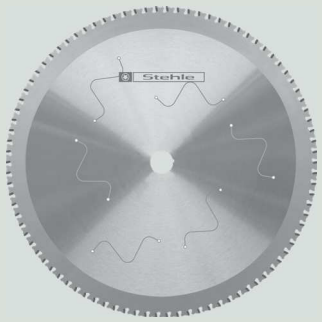
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

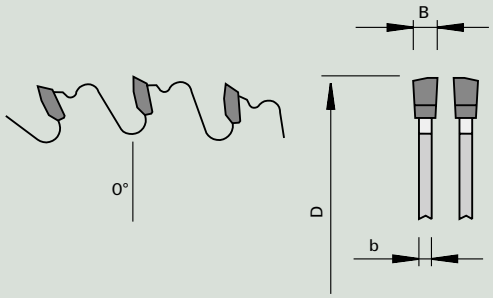
HW Steel

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

Product



Drawing



Machine

Application

Design

3-0-1

HW **TCm13**

F-WFA

Machine / Application

- dry-cut machines
- universal metal-cut machines
- for dividing and miter cuts in composite materials, metal sheets, plastics, NF-metals, cable ducts, profiles, SML-tubes, etc.

Design

- tooth configuration: flat with alternating chamfer "F-WFA"
- cutting material: HW TCm13

Advantages

- dry cut
- excellent cutting qualtiy

Notes

- recommended RPM:
- Ø254 = 1750 min-1
- Ø305 = 1500 min-1
- Ø330 = 1350 min-1
- Ø355 = 1250 min-1

Product features / Order information

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

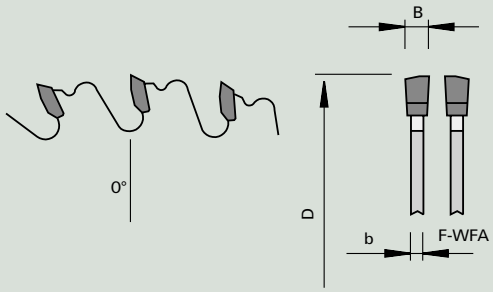
Appropriate **reducing rings** can be found at the end of the chapter

HT Mega-Steel

Chop Saw Blades HT for metal - neutral hook angle

Product

Drawing



Machine

Application

Design

3-0-1

HW
TCx03

F-
WFA

Machine / Application

- dry-cuter machines
- universal metal-cut machines
- for dividing and miter cuts in composite materials, metal sheets, stainless steel, plastics, NF-metals, cable ducts, profiles, SML-tubes, etc.

Design

- tooth configuration: flat with alternating chamfer "F-WFA"
- cutting material: HT TCx03

Advantages

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

Notes

- for smaller dimensions we recommend our HKS Parat - Negativ, HKS Unisteel and HKS Mega Steel
- rec. rpm:
- Ø250 = 1750 rpm
- Ø305 = 1500 rpm
- Ø355 = 1250 rpm

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Tooth geom-etry		PU [pc.]	L	Order-No.
254	2,2	1.8	25,4	72	▲▲		0	F-WFA		1		58805870
254	2,2	1.8	30	72	▲▲	Combi3	0	F-WFA		1		58805871
305	2,2	1.8	25,4	60	▲▲		0	F-WFA		1		50805872
305	2,2	1.8	25,4	80	▲▲▲		0	F-WFA		1		50805873
330	2,2	1.8	30	90	▲▲▲		0	F-WFA		1	o	50805875
305	2,2	1.8	30	80	▲▲▲	Combi3	0	F-WFA		1		50805874
355	2,2	1.8	25,4	80	▲▲▲		0	F-WFA		1		50805876
355	2,2	1.8	25,4	90	▲▲▲		0	F-WFA		1		50805878
355	2,2	1.8	30	90	▲▲▲	Combi3	0	F-WFA		1		50805877

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

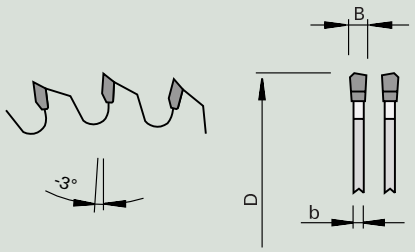
Appropriate **reducing rings** can be found at the end of the chapter

HW KKS - plastic

Chop Saw Blades HW for plastic profiles - alternate top bevel with chamfer

Product

Drawing



Machine

Application

Design

2-0-6

WS-FA

Machine / Application

- clipping and miter saws
- table saws
- for dividing and miter cuts in plastic profiles made from PVC, acrylics, plexiglass, thermosetting plastics, PE, PA, PU, etc.

Design

- tooth configuration: alternate top bevel - with chamfer "WS-FA"
- cutting material: HW TC10 from Ø 250 TC06

Advantages

- noise-reduction thanks to laser ornaments

Notes

Product features / **Order information**

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

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

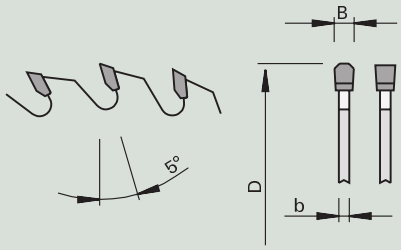
Appropriate **reducing rings** can be found at the end of the chapter

HW KKS - hard plastic positive

Chop Saw Blades HW for extremely hard plastic profiles - triple chip / flat

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC06

TR-
F

Machine / Application

- table saws
- for dividing and miter cuts in plastic profiles made from Corian®, Varicor®, Trespa®, laminate®, etc.

Design

- Hook angle: positive
- Tooth configuration: triple chip / flat tooth "TR-F"
- Cutting material: HW TC06

Advantages

- noise-reduction thanks to laser ornaments

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
250	2,8	1.8	30	80	▲▲▲	Combi3	5		1		58808620 NEW
300	3,2	2.5	30	96	▲▲▲	Combi3	5		1		58808621 NEW
350	3,5	2.8	30	108	▲▲▲	Combi3	5		1		58808622 NEW
400	3,5	2.8	30	108	▲▲▲	Combi3	5		1		58808623 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

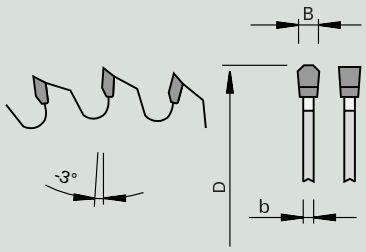
Appropriate **reducing rings** can be found at the end of the chapter

HW KKS - hard plastic negatif

Chop Saw Blades HW for extremely hard plastic profiles - triple chip / flat

Product

Drawing



Machine	Application	Design
		
		3-0-1
		HW **TC06**
		TR-F
		TR-F-FA

Machine / Application

- chop and miter saws
- for dividing and miter cuts in plastic profiles made from Corian®, Varicor®, Trespa®, laminate®, etc.

Design

- Negative hook angle
- Tooth configuration: triple chip / flat tooth with two-sided chamfer "TR-F-FA"
- Cutting material: HW TC06
- Ident. 50808601/ 50808600:
- Neutral hook angle

Advantages

- noise-reduction thanks to laser ornaments

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
210	2,8	1.8	30	54	▲▲▲	2/7/42	0		1	#	50808601
210	2,8	1.8	30	54	▲▲▲	2/7/42	-3		1		58808610 NEW
216	2,8	1.8	30	60	▲▲▲	2/7/42	-3		1		58808611 NEW
250	3,2	2.5	30	72	▲▲▲	Combi3	0		1	#	50808600
254	2,8	1.8	30	80	▲▲▲	Combi3	-3		1		58808612 NEW
260	2,5	1.8	30	80	▲▲▲	Combi3	-3		1		58808613 NEW
305	3,2	2.5	30	96	▲▲▲	Combi3	-3		1		58808614 NEW

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

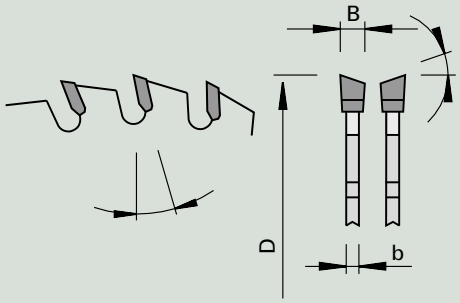
Appropriate **reducing rings** can be found at the end of the chapter

HW KKO

Chop Saw Blades HW for edge trimming without countersink - alternate top bevel

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC06

WS

Machine / Application

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

Design

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

Advantages

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

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner◁ [°]	Shear◁ [°]				PU [pc.]	L	Order-No.
90	3,0	2.0	30	20	▲▲		8	10	0	Reich			1		58808800
100	2,4	1.6	22	12	▲		15	10	5	HOLZ-HER			1		58808801
100	2,4	1.6	22	20	▲▲	2/4/30	-8	10	5	EBM			1		58808802
100	3,2	2.2	22	20	▲▲▲		8	15	0	Felder, Lohmeyer			1		58808836
100	2,6	1.6	32	30	▲▲		10	15	5	Brandt			1		58808804
110	3,6	2.5	22	20	▲▲		8	30	5	Reich			1		58808805
110	3,6	2.5	32	20	▲▲		8	30	5	Homag			1		58808806
120	3,2	2.2	32	20	▲▲		10	10	5	Homag			1		58808808
125	2,4	1.6	32	24	▲▲		15	30	0	Brandt			1		58808835
140	3,2	2.2	16	36	▲▲▲		10	15	5	Ott			1		58808809
140	3,2	2.2	22	36	▲▲▲		10	15	5	HOLZ-HER			1		58808810
150	3,2	2.2	22	48	▲▲▲		10	10	5	IMA			1		58808811
160	3,0	2.5	22	36	▲▲▲		-5	15	5	IMA			1		58808843
160	3,5	2.5	22	36	▲▲▲		-5	15	5	IMA			1		58808813 NEW
160	3,2	2.2	20	48	▲▲▲	2/5/32	10	10	5	HOLZ-HER			1		58808812
160	3,2	2.2	22	48	▲▲▲		-8	10	5	IMA			1		58808814
160	3,2	2.2	30	24	▲▲	2/7/42	15	10	5	HOLZ-HER			1		58808815
160	3,2	2.2	40	30	▲▲	4/5,5/52	-8	20	10	HOLZ-HER			1		58808816
170	3,2	2.2	30	36	▲▲▲	4/5,5/52	10	20	0	Homag			1		58808817
200	3,2	2.2	30	64	▲▲▲	4/6,6/60 + 2/6,2/42	10	15	0	IMA			1		58808818

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

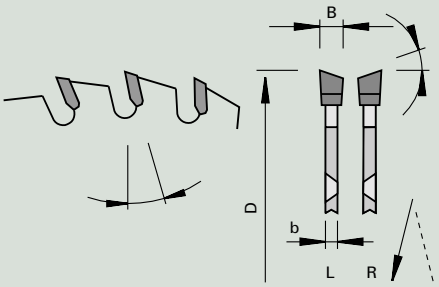
Appropriate **reducing rings** can be found at the end of the chapter

HW KKM

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC06**

WS

Machine / Application

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

Design

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

Advantages

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

Notes

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

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner◁ [°]	Shear◁ [°]		L/R		PU [pc.]	L	Order-No.
110	3,2	2.5	40	20	▲▲▲	4/5,5/52	10	45	5	Homag	N		1		58808837
110	3,2	2.5	40	20	▲▲▲	4/5,5/52	10	30	5	Homag	R		1		58808838
120	3,2	2.5	40	36	▲▲▲	2x4/5,5/52	10	45	5	Homag	N		1		58808839
120	3,6	2.8	40	24	▲▲	2x4/6/52	8	30	0	Homag	N		1		58808819
125	2,4	1.6	30	36	▲▲▲	2x4/6,5/48	10	30	0	Homag BAZ	N		1		58808820
140	3,2	2.2	30	36	▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800	L		1	&	58808821
140	3,2	2.2	30	36	▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800	R		1	&	58808822
150	3,2	2.2	30	48	▲▲▲	4/6/48 + Δ4/5,5/52	10	15	0	Homag BAZ	R		1		58808823
180	3,2	2.2	30	54	▲▲▲	4/6/52	10	30	5	Homag BAZ	L		1		58808824
150	3,6	2.8	40	30	▲▲▲	4/6/52	8	30	0	Biesse Akron 600/800	N		1		58808840

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

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

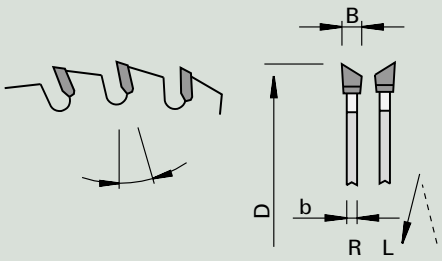
Appropriate **reducing rings** can be found at the end of the chapter

HW KKE

Chop Saw Blades HW for edge trimming without countersink - top bevel

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC06

ES

Machine / Application

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

Design

- special NoNoise gullet geometry
- positive or negative hook angle
- with and without shear angle
- tooth configuration: top bevel "ES (right + left)"
- cutting material: HW TC06

Advantages

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

Notes

- sense of rotation see drawing

Product features / Order information

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

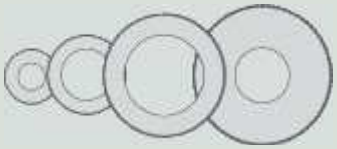
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut

** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

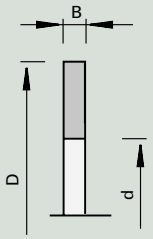
Appropriate **reducing rings** can be found at the end of the chapter

Reducing Rings - knurled
for Circular Saw Blades

Product



Drawing



Machine

Application

Design

Machine / Application

- portable saws
- for reduction of the saw blade bore

Design

- ground bore
- knurled on the outside

Advantages

Notes

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

Product features | **Order information**

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

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

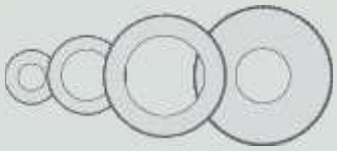
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

Appropriate **reducing rings** can be found at the end of the chapter

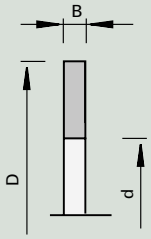
Description	Composed of		PU [pc.]	L	Order-No.
packing unit (50 pieces)	5 x 20/13,0/1,4	50880029	1	#	50881001
	5 x 20/16,0/1,6	50880050			
	5 x 30/16,0/1,4	50880031			
	5 x 30/16,0/2,0	50880044			
	5 x 30/20,0/1,4	50880026			
	5 x 30/20,0/2,0	50880045			
	5 x 30/25,0/1,4	50880008			
	5 x 30/25,0/2,0	50880042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

Reducing Rings - smooth
for Circular Saw Blades

Product



Drawing



Machine

Application

Design

Machine / Application
- portable saws
- for reduction of the saw blade bore

Design
- ground bore
- smooth on the outside

Advantages

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

Product features / **Order information**

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

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

Product features								Order information		
Ø D [mm]	B [mm]	Ø d [mm]	Ø d [inch]					PU [pc.]	L	Order-No.
35	1,0	30						1		000145
35	1,4	30						1	s	000146
35	1,9	30						1		000147
35	2,2	20						1		000138
35	2,2	24						1	s	000139
35	2,2	25						1		000142
35	2,2	30						1		000148
40	2,0	32						1		161962
40	2,2	20						1		000151
40	2,2	30						1		000153
40	2,2	35						1	s	000154
45	2,5	30						1		161831
50	2,2	30						1		000156
55	2,2	30						1		000159
60	2,2	30						1		000161
60	2,2	35						1		000162
60	2,2	40						1	s	000163
60	2,2	50						1		000164
60	2,8	30						1		010577
70	2,2	30						1	s	000166
80	2,2	30						1		000171
80	2,2	35						1	s	000172
80	2,2	50						1	s	000175
80	2,2	60						1	s	000177
80	2,2	70						1	s	000179
80	2,8	60						1	s	000178

* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120
Appropriate **reducing rings** can be found at the end of the chapter

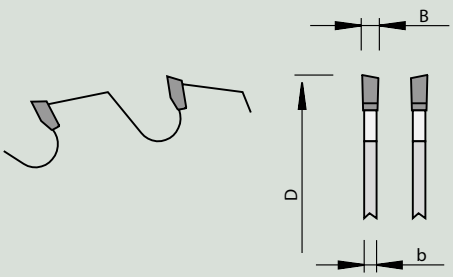
MILLING TOOLS WITH BORE

CONTENTS

HW 1103L Grooving Cutters - for Lamello®

Product

Drawing



Machine

Application

Design

HW TC06

HW TC10

WS

WS-DU

Machine / Application

- machines Lamello®, ELU
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

- Tooth configuration: alternate top bevel "WS"
- Tooth configuration for 50660300: alternate top bevel - hollow-ground tooth "WS-DU"
- Cutting material: HW TC06
- Cutting material for 50110178: HW TC10

Advantages

Notes

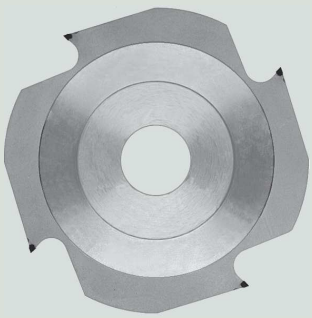
- application against feed with and across the grain

Product features / **Order information**

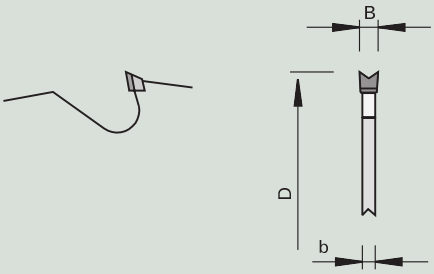
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	NL**	nmin-nmax [min-1]			PU [pc.]	L	Order-No.
100	4,0	3.45	22	6	4/4,5/36	7600-13000	Lamello®		1		50660300
100	3,97	2.8	22	12		7500-13100	Lamello®		1		50110178
102	3,85	3.0	22	12		7500-13100	ELU DS 140		1		50660301

DP 3013L Grooving Cutters - for Lamello®

Product



Drawing



Machine

Application

Design

Machine / Application

- machines Lamello®
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

- reduced resharpening area
- tooth configuration: concave
- n = 7,700 - 13,300 min-1

Advantages

Notes

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

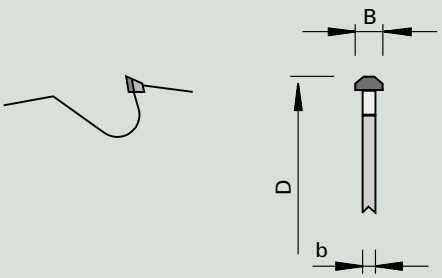
Product features / **Order information**

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

DP 3104L Grooving Cutters DP - for Lamello Clamex P®

Product

Drawing



Machine

Application

Design

MAN

MEC

Machine / Application

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

Design

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

Advantages

Notes

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

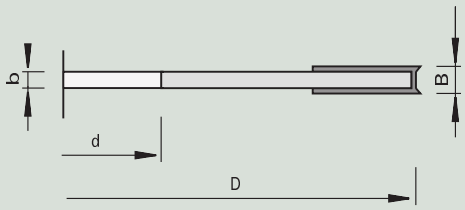
Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z				PU [pc.]	L	Order-No.
100.4	7,0	4	22	3		MAN		1		50660347 NEW
100.4	7,0	4	30	3				1		50660346 NEW

HW 1568 Grooving Cutterheads - Silverline - for Lamello®

Product

Drawing



Machine

Application

Design

HW TCw15

HW TCw30

MAN

Machine / Application

- machines Lamello®
- for chip-free grooving of Lamello® wood joints in solid woods and in wood-based panels

Design

- n = 7,900 - 11,400 min-1

Advantages

- 4 cutting edges

Notes

- application against feed with and across the grain
- pin holes: countersink on one side ø 9 mm

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	NL**					PU [pc.]	L	Order-No.
100	3,97	3.97	22	4 V4	4/4,5/36					1	o	69470022

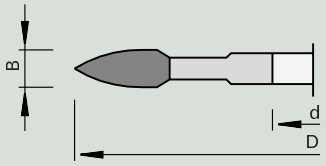
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			18	18	1.95	TCw20		10		50450220
Spurs			14	14	1.2	TCw30		10		50450182

Spare parts		Dimension [mm]		PU [pc.]	L	Order-No.
Countersunk Screws		M4x0,5x3,2 T9		10		163925
Special Nuts	for profile knives	M4x0,5x2,2		10		163703
Screwdrivers		T9		1		164344
Special Nuts	for spurs	M4x0,5x1,6		10		163704

HW 1103G Cutter for removing resin pockets

Product

Drawing



Machine

Application

Design

Machine / Application

- Mini-Spot machines
- for cutting out defects in solid woods

Design

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

Advantages

Notes

- for patch sizes 1-4

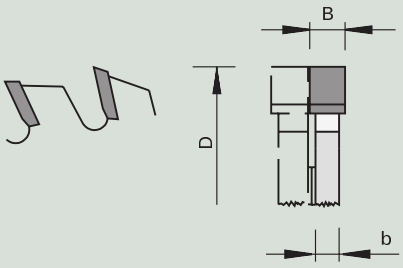
Product features / Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	NL**				PU [pc.]	L	Order-No.
100	8,0	22	4	4/4,3/36				1		50621077

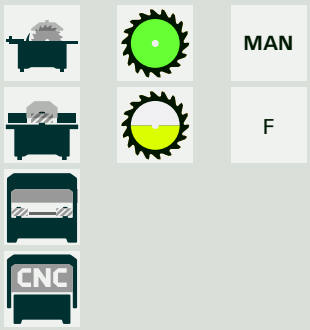
HW 1101 Grooving Cutters

Product

Drawing



Machine



Application

Design

MAN

F

Machine / Application

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

Design

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

Advantages

Notes

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

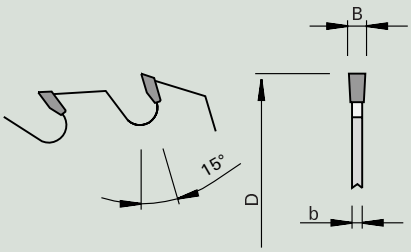
Product features / Order information

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

HW NK
Grooving Saw Blades HW - flat tooth

Product

Drawing



Machine

Application

Design

HW
TC06

MEC

F

Machine / Application

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

Design

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

Advantages

Notes

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

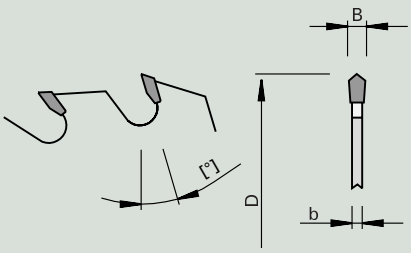
Product features — **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]		PU [pc.]	L	Order-No.
180	4,0	3.0	30	18	▲▲▲	MEC	15		1		50169685
180	5,0	4.0	30	18	▲▲▲	MEC	15		1		50169684
180	8,0	5.0	30	18	▲▲▲	MEC	15		1		50169683
180	10	6.0	30	18	▲▲▲	MEC	15		1		50169682

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

Product

Drawing



Machine

Application

Design

HW
TC10

Machine / Application

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

Design

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

Advantages

Notes

- application against feed with the grain (solid wood)

Product features — **Order information**

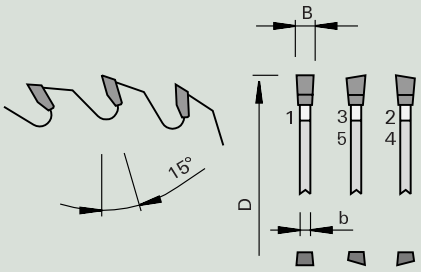
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z		nmin-nmax [min-1]		PU [pc.]	L	Order-No.
100	7,0	5.0	22	6	MAN	7600-13000		1	o	50660303
160	6,0	3.0	20	12	MAN	7600-13000		1	o	50660304

HW RNK-Matador 5

Rear Board Grooving Cutter HW

Product

Drawing



Machine

CNC

Application

Design

LOW noise

3-0-1

HW **TC03**

F-WS-WS

Machine / Application

- Weeke BHX series
- CNC machining centers and aggregates
- for chip-free grooving in solid woods, raw and laminated wood-based panels and plastics

Design

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

Advantages

- excellent cutting qualtiy
- especially low noise level
- long edge lives also thanks to highly wear-resistant cutting material

Notes

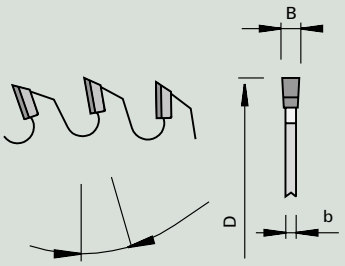
Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**		Hook angle [°]		PU [pc.]	L	Order-No.
100	4,0	2.8	30	35	▲▲▲		Weeke BHX	15		1		50806250
100	5,0	4.0	30	35	▲▲▲		Weeke BHX	15		1		50806252
120	4,0	2.8	20	35	▲▲▲		Weeke BHX	15		1		50806258
120	5,0	4.0	20	35	▲▲▲		Weeke BHX	15		1		50806259
120	4,0	2.8	20	35	▲▲▲	3/4,5/35	SCM / Morbidelli	15		1	&	50806254
120	5,0	4.0	20	35	▲▲▲	3/4,5/35	SCM / Morbidelli	15		1	&	50806255
120	4,0	2.8	35	35	▲▲▲	4/6,3/50	Biesse	15		1	&	50806256
120	5,0	4.0	35	35	▲▲▲	4/6,3/50	Biesse	15		1	&	50806257
125	4,0	2.8	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	Weeke BHX	15		1		50806251
125	5,0	4.0	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	Weeke BHX	15		1		50806253

DP RNK
Rear Board Grooving Cutter DP

Product

Drawing



Machine

Application

Design

3-0-1

F

Machine / Application

- table shapers
- for grooving of wood-based panels, square particle and MDF boards, raw or laminated, multiplex and plywood boards

Design

- tooth configuration: flat "F"
- cutting material: DP
- resharpening area 4,0 mm

Advantages

Notes

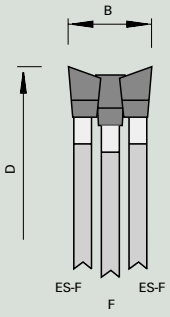
Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	DKN [mm]		PU [pc.]	L	Order-No.
100	4,0	2.5	30	12	▲▲	4/5,5/48R + 4/5,5/48L	8			1	s	50750144
125	4,0	2.5	30	12	▲▲	4/5,5/48R + 4/5,5/48L	8			1	s	50750145
160	5,0	4.0	30	8	▲		8	6x3		1	s	50750148
160	8,0	7.0	30	8	▲		8	6x3		1	s	50750149

HW NK3VS
Grooving Saw Blades HW - adjustable - top bevel-flat + flat + top bevel-flat

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC06**

ES-F
F
ES-F

Machine / Application

- table saws
- clipping saws
- for precise grooving in solid wood along and accross the grain as well as in wood-based panels such as particle boards, MDF, etc.

Design

- 3 parts, adjustableby means of spacers
- additional expansion slots
- tooth configuration: scoring saw blade top bevel-flat "ES-F", main saw blade flat "F"
- cutting material: HW TC06

Advantages

- precise grooving thanks to special tooth geometry

Notes

- adjustable in steps of 0.1 mm

Product features / **Order information**

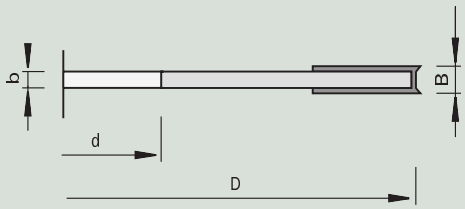
Ø D [mm]	B [mm]	Ø d [mm]	Z	Cutting quality*	NL**					PU [pc.]	L	Order-No.
250	5,0-13	30	30	▲▲▲	Combi2					1		50459024

HW 1503 Grooving Cutterheads

with HW turnover knife

Product

Drawing



Machine

Application

Design

HW TCw15

HW TCw30

MAN

Machine / Application

- spindle moulder
- for chip-free grooving in solid woods and in wood-based panels

Design

- n = 6,500 - 11,000 min-1

Advantages

Notes

- application against feed with and across the grain

Product features — **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Ø dmax [mm]	Z			PU [pc.]	L	Order-No.
125	4,0	3.0	30	40	4 V4			1		50660318
125	5,0	4.0	30	40	4 V4			1	s	50660319

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Spurs			14	14	1.2	TCw30	10		50450182
Turnover Knives	for B = 4		18	18	1.95	TCw20	10		50450220

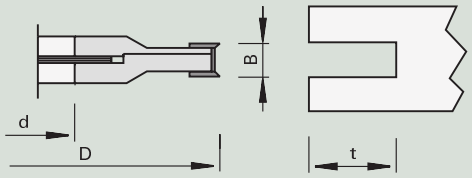
Spare parts	Dimension [mm]	Suitable for	PU [pc.]	L	Order-No.
Countersunk Screws	M4x0,5x3,2 T9	50660318	10		163925
Special Nuts	M4x0,5x1,6	For all	10		163704
Special Nuts	M4x0,5x2,2	50660318	10		163703
Screwdrivers	T9	For all	1		164344

HW 5561 Grooving Cutterheads - Silverline

adjustable by means of HW turnover knife

Product

Drawing



Machine

Application

Design

STAHL

HW TCw15

HW TCw40

MAN

Machine / Application

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

Design

- tool body made from steel
- with chip limiter
- preferably manual feed

Advantages

Notes

- application against feed with and across the grain
- cutting width 4 - 7.5 mm two-piece
- cutting width 4 - 15 mm three-piece
- cutting width adjustable with shims in 0.1 mm increments

Product features — **Order information**

Ø D [mm]	B [mm]	Ø d [mm]	Tmax [mm]	Z				PU [pc.]	L	Order-No.
160	4,0-7,5	30	35	8 V8				1	o	68370033
160	4,0-7,5	40	35	8 V8				1	o	68370034
200	4,0-7,5	30	55	8 V8				1	o	68370053
200	4,0-7,5	40	55	8 V8				1	o	68370054
200	4,0-7,5	50	55	8 V8				1	o	68370055

Product features of intermediate cutters — **Order information**

Ø D [mm]	B [mm]	Ø d [mm]	Tmax [mm]	Z				PU [pc.]	L	Order-No.
160	7,6	30	35	2				1	o	68370083
160	7,6	40	35	2				1	o	68370084
200	7,6	30	55	2				1	o	68370103
200	7,6	40	55	2				1	o	68370104
200	7,6	50	55	2				1	o	68370105

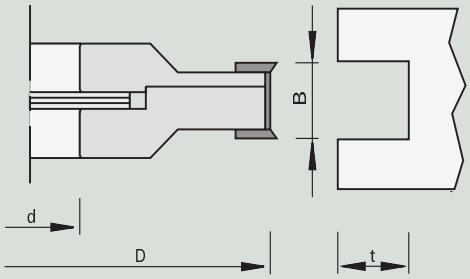
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			18	18	1.95	TCw20		10		50450220
Spurs			14	14	2.0	TCw30		10		50820014

HW 5562 Grooving Cutterheads - Silverline

adjustable by means of HW turnover knife

Product

Drawing



Machine

Application

Design

STAHL

HW TCw05

HW TCw40

MAN

Machine / Application

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

Design

- tool body made from steel

Advantages

- optimum cutting quality

Notes

- application against feed with and across the grain
- cutting width adjustable with shims in 0.1 mm increments
- groove width extension by using intermediate cutters

Product features — **Order information**

Ø D [mm]	B [mm]	Ø d [mm]	Tmax [mm]	Z			PU [pc.]	L	Order-No.
160	8,0-15,5	30	35	4 V4			1	o	68380023
160	8,0-15,5	40	35	4 V4			1	o	68380024
160	12,5-24,0	30	32	4 V4			1	o	68390023
160	12,5-24,0	40	32	4 V4			1	o	68390024
160	15,0-30,0	30	32	4 V4			1	o	68400063
160	15,0-30,0	40	32	4 V4			1	o	68400064
200	8,0-15,5	30	50	4 V4			1	o	68380033
200	8,0-15,5	40	50	4 V4			1	o	68380034
200	8,0-15,5	50	50	4 V4			1	o	68380035
200	12,5-24,0	30	45	4 V4			1	o	68390033
200	12,5-24,0	40	45	4 V4			1	o	68390034
200	12,5-24,0	50	45	4 V4			1	o	68390035
200	15,0-30,0	30	50	4 V4			1	o	68400033
200	15,0-30,0	40	50	4 V4			1	o	68400034
200	15,0-30,0	50	50	4 V4			1	o	68400035
250	8,0-15,0	30	52	8 V8			1	o	68380043
250	8,0-15,0	40	52	8 V8			1	o	68380044
250	8,0-15,0	50	52	8 V8			1	o	68380045

Product features of intermediate cutters — **Order information**

Ø D [mm]	B [mm]	Ø d [mm]	Tmax [mm]	Z			PU [pc.]	L	Order-No.
200	12,0	30	45	2			1	o	68390073
200	12,0	40	45	2			1	o	68390074
200	12,0	50	45	2			1	o	68390075
200	15,0	30	45	2			1	o	68380083
200	15,0	40	45	2			1	o	68380084
200	15,0	50	45	2			1	o	68380085

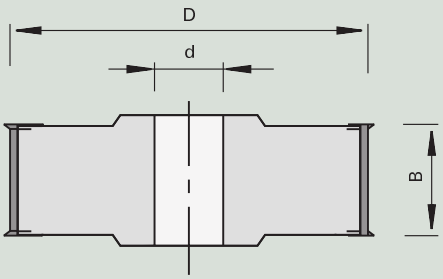
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			12	12	1.5	TC05		10		50820012
Raker Turnover Knives			15	12	1.5	TC05		10		50820015
Spurs			14	14	2.0	TCw30		10		50820014
Turnover Knives			7,5	12	1.5	TC05		10		50820007
Turnover Knives			50	12	1.5	TC05		10		50820050
Turnover Knives			30	12	1.5	TC05		10		50820030

HW 1586 Jointing and Rabbeting Cutterheads - Silverline

scoring cut

Product

Drawing



Machine

Application

Design

HW TC05

MAN

Machine / Application

- spindle moulder
- for chip-free jointing and rabbeting in solid woods and wood-based panels
- laminated, uncoated and glued solid wood and strongly wearing wood

Design

- with face shear angles from above and below
- cutting material: HW TC05
- tool body made from steel
- 4x rakers
- with 2 upper and 2 lower spurs each
- scoring cut

Advantages

- optimum cutting quality

Notes

- application against feed

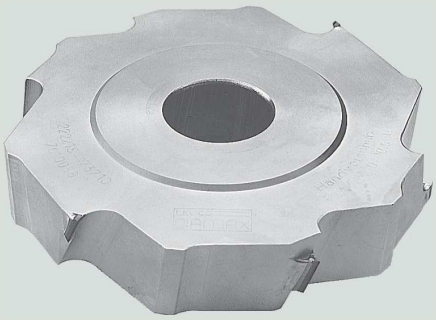
Product features / Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	nmin-nmax [min-1]		PU [pc.]	L	Order-No.
125	30	30	4 V4	9000		1	o	68010013
125	30	40	4 V4	9000		1	o	68010014
125	30	50	4 V4	9000		1	o	68010015
125	50	30	4 V4	9000		1	o	68010023
125	50	40	4 V4	9000		1	o	68010024
125	50	50	4 V4	9000		1	o	68010025
140	50	30	4 V4	9000		1	o	68010043
140	50	40	4 V4	9000		1	o	68010044
140	50	50	4 V4	9000		1	o	68010045

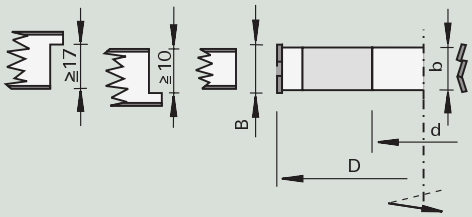
Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Spurs	14	14	2.0	TCw30		10		50820014
Turnover Knives	50	12	1.5	TC05		10		50820050
Turnover Knives	30	12	1.5	TC05		10		50820030

DP 3584 Jointing / Rabbeting Cutters
MAN

Product



Drawing



Machine

Application

Design

MAN

Machine / Application
- spindle moulder
- for chip-free jointing and rabbeting of melamine-, paper-, HPL-laminated and veneered panels

Design
- spiral cutting layout
- resharpenable area 1.5 mm

Advantages
- optimum glueing of edges

Notes
- sense of rotation according to DIN-EN 50144

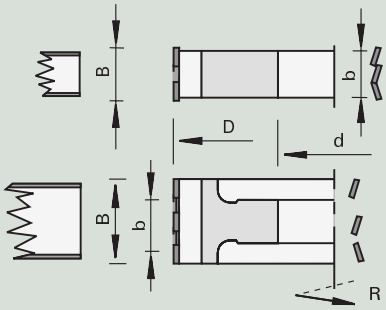
Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	nmin-nmax [min-1]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
125	25	26	30	2+2	8x3	6100-10500		1		50811729		50811729
125	43	44	30	2+2	8x3	6100-10500		1	s	50811300	s	50811300

DP 3585 Jointing Cutters DP airFace

Product

Drawing



Machine

Application

Design

MEC

Machine / Application

- through feed machines
- edge banding machines
- for very quiet and chip-free jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of noise

Design

- steel body with airFace surface
- integrated balance screws
- reinforced DP cutting edges
- reduced gullet volume
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- compared to the LowNoise version, additional noise reduction by -1 dB(A) through airFace design and reduced gullet volume
- good durability and high cutting quality thanks to large shear angle
- machining of 8-mm panels is possible without adjustment

Notes

- sense of rotation according to DIN-EN 50144

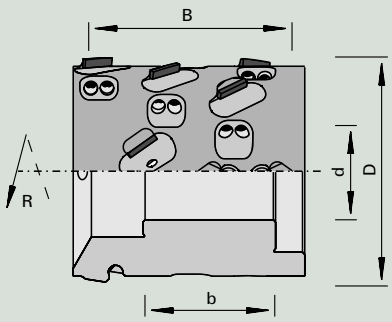
Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	nmax [min-1]				PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
60	64,5	62	25	2+2	8x3,3	31000	Felder/Format 4		●	1		58186382		58186381 NEW
85	43,2	50	30	3+3	8x3,3	22000	Ott	asymmetrical	●	1		58186408		58186409 NEW
100	43,2	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani		●	1		58186385		58186386 NEW
100	43,2	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	●	1		58186373		58186374 NEW
100	43,2	60.6	30	3+3	8x3,3	19000	SCM-Stefani	asymmetrical	●	1		58186414		58186415 NEW
100	43,2	61	30	2+2	8x3,3	19000	EBM / Hebrock	asymmetrical	●	1		58186378		58186377 NEW
100	64,5	40.6	30	3+3	8x3,3	19000	Brandt	asymmetrical	●	1		58186371		58186372 NEW
100	64,5	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani, EBM		●	1		58186387		58186388 NEW
125	29	34	30	3+3	8x3,3	15000	Homag		●	1		58186401		58186401 NEW
125	43,2	40	30	3+3	8x3,3	15000	Homag		●	1		58186399		58186399 NEW
125	64	40	30	3+3	8x3,3	15000	Homag		●	1		58186400		58186400 NEW

DP 3585-2 Jointing Cutters DP - HOLZ-HER - AirStream-System

Product

Drawing



Machine

Application

Design

LOW noise

max. **18.000** U/min

1,5 mm

MEC

Machine / Application

- through-feed machines HOLZ-HER aggregate 1801 / 1802 / 1804
- for extremely noise-reduced, chip-free jointing of melamine-, paper-, HPL-laminated, foiled and veneered wood-based materials

Design

- with patented AirStream-System
- symmetrical and asymmetrical
- design 35°
- shear angle resharpening area 1.5 mm

Advantages

- optimal glueing of edges
- extremely noise and flow-optimized thanks to AirStream-System
- considerably increased chip caption degree thanks to AirStream-System
- increase of edge life thanks to reduction of multiple hogging
- less chips remain inside the machine
- high cutting quality thanks to large shear angle

Notes

- compatible with Pro Lock clamping on older aggregates
- sense of rotation according to DIN-EN 50144

Product features / Order information

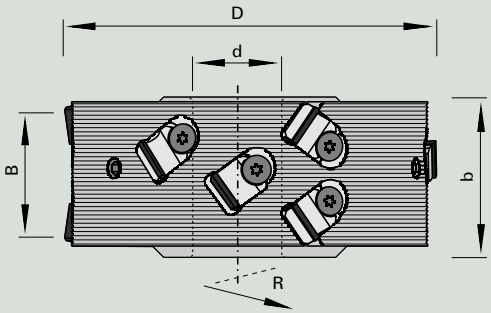
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	nmax [min-1]			PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
70	48	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802		1		50811780		50811781
70	64	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802		1		50811782		50811783
100	63	40	30	3+3	8x3,3	18500	HOLZ-HER aggregate 1804		1		50811784		50811785

DP 3588-2 Jointing Cutterheads airFace

with exchangeable DP cutting edges

Product

Drawing



Machine

Application

Design

Machine / Application

- edge banding machines
- for jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on the reduction of unbalance and noise

Design

- aluminum body with airFace surface
- with exchangeable stainless steel DP cutting edges with integrated stainless steel gullet
- shear angle 35°
- resharpening area 1.5 mm

Advantages

- additional noise reduction by up to -3 dB (A) thanks to the airFace design
- reduced power consumption thanks to low-weight design with aluminum body
- easy on spindle bearing thanks to less unbalance
- exchangeable DP cutting edges incl. wear-resistant exchangeable gullet
- excellent cutting quality thanks to large shear angle
- corrosion protection of the entire tool by stainless steel segments

Notes

- Attention: when changing the cutting edges please observe operating instructions
- DP cutting edges packing unit 4 pieces
- plug insert packing unit 2 pieces
- sense of rotation according to DIN-EN 50144

Jointing Cutterheads airFace Ø D=70 / 35°

Product features								Order information						
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
70	43	61	25	2+2	8x3,3	asymmetrical	EBM	8		1		50186037		50186038 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=70 / 35°	17,2x8,9x14,2		4		186076

Jointing Cutterheads airFace Ø D=80 / 35°

Product features								Order information						
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
80	43	53	30	2+2	8x3,3	symmetrical	Biesse Jade	8		1		50186031		50186031 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=80 / 35°	17,2x8,9x14,2		4		186077

Jointing Cutterheads airFace Ø D=85 / 35°

Product features								Order information						
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
85	48	50	30	3+3	8x3,3	asymmetrical	Ott	15		1		50186058		50186057 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=85 / 35°	17,2x8,9x14,2		4		186078

Jointing cutterheads airFace Ø D=100 / 35°

Product features									Order information					
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
100	43	40.6	25	2+2	8x3,3	asymmetrical	Brandt 1110F, 1120 FC	8		1		50186071		50186072 NEW
100	43	40.6	30	3+3	8x3,3	asymmetrical	Brandt	12		1		50186065		50186066 NEW
100	64	40.6	30	3+3	8x3,3	asymmetrical	Brandt, SCM	18		1		50186073		50186074 NEW
100	43	60.6	30	3+3	8x3,3	asymmetrical	SCM	12		1		50186063		50186064 NEW
100	64	60.6	30	3+3	8x3,3	asymmetrical	SCM	18		1		50186062		50186061 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=100 / 35°	17,2x8,9x14,2	4	185250

Jointing Cutterheads airFace Ø D=125 / 35°

Product features									Order information					
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
125	43	40	30	3+3	8x3,3	symmetrical	Homag	12		1		50186047		50186047 NEW
125	64	40	30	3+3	8x3,3	symmetrical	Homag	18		1		50186048		50186048 NEW
125	32,5	54	30	3+3	8x3,3	asymmetrical	Homag	9		1		58186307		58186306 NEW
125	43,2	54	30	3+3	8x3,3	asymmetrical	Homag	12		1		50185971		50185970 NEW
125	64,4	54	30	3+3	8x3,3	asymmetrical	Homag	18		1		50185973		50185972 NEW
125	43,2	72	30	3+3	8x3,3	asymmetrical	IMA 08.378	12		1		50186051		50186052 NEW
125	64,4	72	30	3+3	8x3,3	asymmetrical	IMA 08.378	18		1		50186049		50186050 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=125 / 35°	17,2x8,9x14,2	4	185974

Jointing Cutterheads airFace Ø D=125 / 43°

Product features									Order information					
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]			Number of cutting edges [pc.]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
125	63	57	30	3+3	8x3,3	asymmetrical	IMA 08.379	21		1		50186055		50186056 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=125 / 43°	17,2x8,9x14,2	4	186075

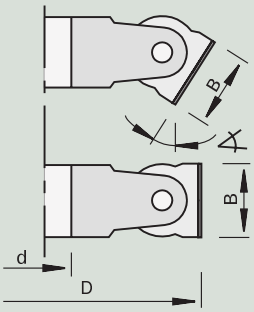
Spare parts / Accessories	Dimension [mm]	PU [pc.]	L	Order-No.
Torque Screwdrivers	5,0 Nm	1		185292
Plug Insert Torx	T20	2		185293

HW 1580 Pivoting Cutterheads

with HW turnover knife

Product

Drawing



Machine

Application

Design

HW
TC05

MAN

Machine / Application

- spindle moulder
- for chamfering, jointing and rabbeting with adjustable chamfer angle in solid woods and in veneered and plastic-coated panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW TC05

Advantages

- simplified adjustment thanks to serrated washer

Notes

- application against feed
- pivot range up to 90 degree
- chamfer angle adjustable from 1 degree to 1 degree

Product features — **Order information**

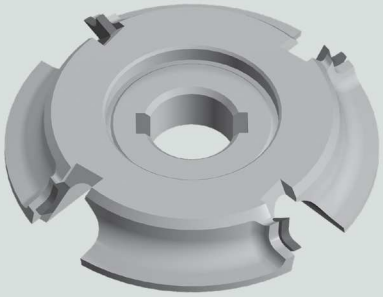
Ø D [mm]	B [mm]	Ø d [mm]	Z	nmin-nmax [min-1]	PU [pc.]	L	Order-No.
167	50	30	2	4600-7800	1		50663009

Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
	50	12	1.5	TC05	10		50820050

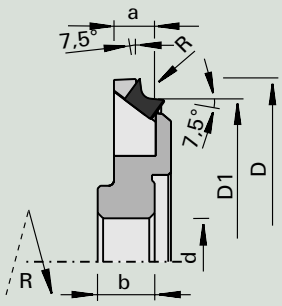
Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Set Screws	M6x16 SW3	10		001617
Screwdrivers	SW3x100	1		166090
Cranked Wrench Keys	SW6 DIN ISO 2936	1		009675
Pressure Bars	B=50	2		50930124

DP 3565 Edge Rounding Cutters

Product



Drawing



Machine

Application

Design

MEC

Machine / Application

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

Design

- polished face
- high-finish clearance angle
- with shear angle
- n max = 24,000 min-1

Advantages

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

Notes

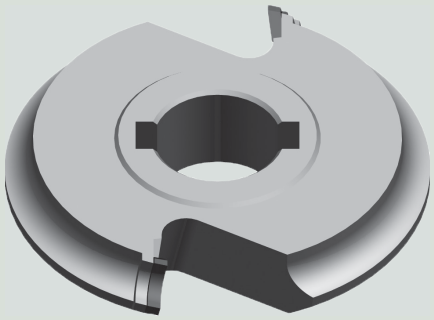
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Product features / Order information

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
2,0	69	61	9,72	10,5	16	4	5x2,3		1		50811738		50811737

DP 3565-1 Edge Rounding Cutters

Product



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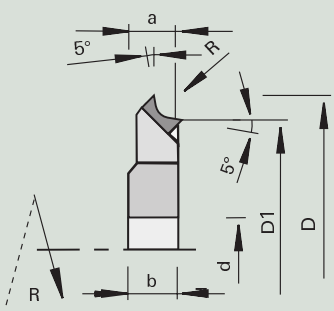


Machine

Application

Design

MEC

Machine / Application

- edge banding machines HOLZ-HER
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- n max = 24,000 min-1

Advantages

Notes

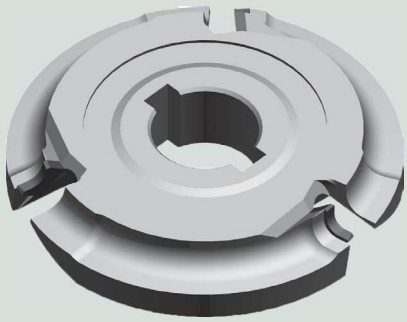
- constant basic dimensions a and D1
- sense of rotation according to DIN-EN 50144

Product features / Order information

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
2,0	57	50	8.5	12.5	16	2	5x2,3		1		50811740		50811739

DP 3565-2 Edge Rounding Cutters CM

Product



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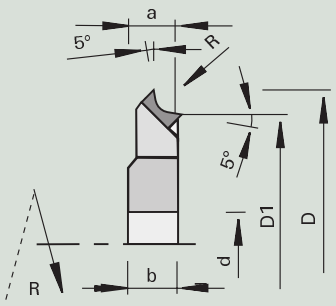


Machine

Application

Design

MEC

Machine / Application

- edge banding machines HOLZ-HER aggregate 1832
- for rounding of solid wood, veneer and plastic edge bands

Design

- with shear angle
- polished face and high-finish clearance angle
- n max = 24,000 min-1

Advantages

- optimized chip removal
- less chips remain inside of the machine
- no malfunctions due to chips
- reduction of suction power
- low noise level

Notes

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

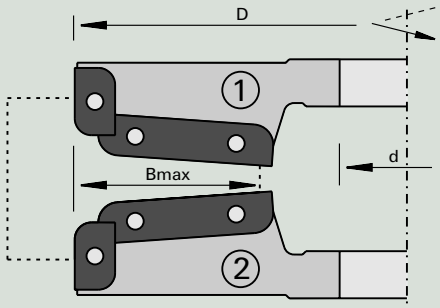
Product features / Order information

R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]		PU [pc.]	L	Order-No.
2,0	58.7	50	8.5	12	16	3	5x2,3		1		50811743
3,0	58.7	50	8.5	12	16	3	5x2,3		1		50182686 NEW

HW 5540 Panel Raising Cutterheads - Silverline

Product

Drawing



Machine

Application

Design

STAHL

HW TC05

MAN

Machine / Application

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

Design

- tool body made from steel
- cutting edges parallel to cutter axis
- cutting material: HW TC05

Advantages

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

Notes

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

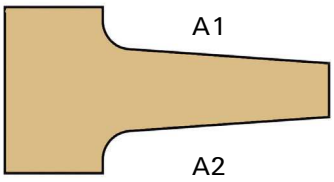
Product features / Order information

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

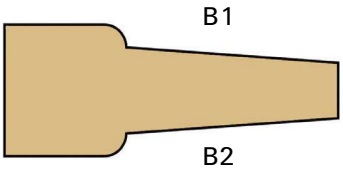
Knives	Dimension [mm]	suitable for	L/R	PU [pc.]	L	Order-No.
Profile Panel Raising Cutting Edges A1	60x12x1,5	68255130, 68255140, 68255150	L	6	o	62556011
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255240, 68255250	R	6	o	62556012
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130, 68255140, 68255150	L	6	o	62556021
Profile Panel Raising Cutting Edges B2	60x12x1,5	68255230, 68255240, 68255250	R	6	o	62556022
Profile Panel Raising Cutting Edges C1	60x12x1,5	68255130, 68255140, 68255150	L	6	o	62556031
Profile Panel Raising Cutting Edges C2	60x12x1,5	68255230, 68255240, 68255250	R	6	o	62556032
Profile Peripheral Cutting Edges T1	20x12x1,5	68255130, 68255140, 68255150	L	6	o	62556023
Profile Panel Raising Cutting Edges T2	20x12x1,5	68255230, 68255240, 68255250	R	6	o	62556024
Profile Peripheral Cutting Edges V1	20x12x1,5	68255130, 68255140, 68255150	L	6	o	62556013
Profile Panel Raising Cutting Edges V2	20x12x1,5	68255230, 68255240, 68255250	R	6	o	62556014

5540 Panel Raising Cutterheads Silverline - Drawing

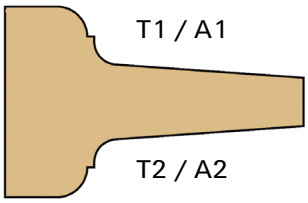
Profile combinations



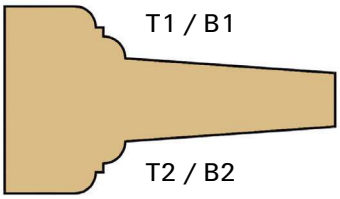
A



B



A/T



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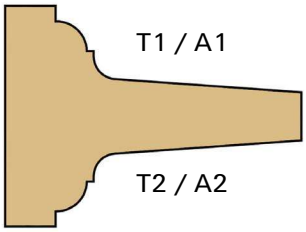

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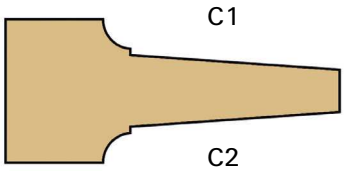

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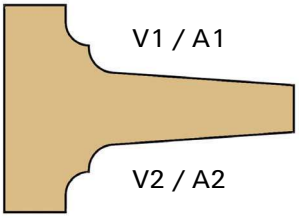
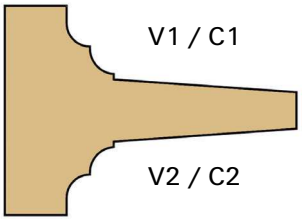
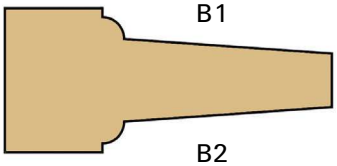


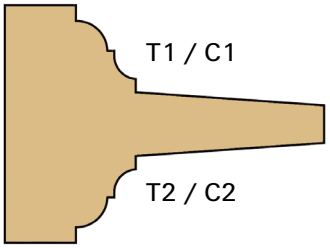
A/V



CV



B



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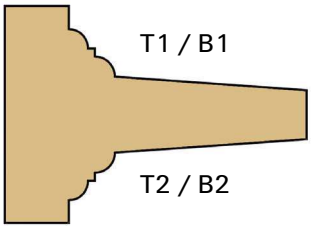
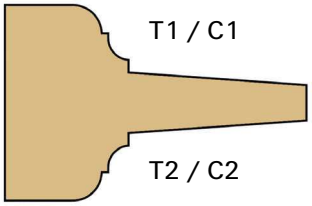


B/T



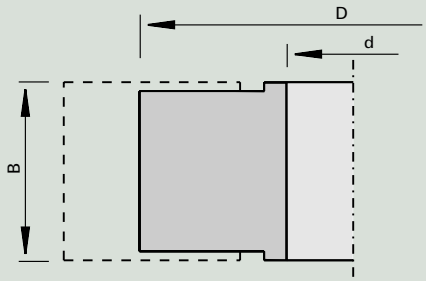
CT

HW 1547 Universal Cutterheads Euro - Silverline

for knife widths 40 mm and 50 mm

Product

Drawing



Machine

Application

Design

STAHL

HW
TCw25

MAN

Machine / Application

- table shapers (manual feed)
- for profiling of soft and hard woods (solid wood, not glued)

Design

- tool body made from steel
- interlocking connection between knife and deflector
- with chip limiter and minimum kickback
- knives made of SP steel
- cutterhead B= 40 mm, only the knife width 40 mm can be used
- cutterhead B= 40 / 50 mm suitable for knife widths 40 mm and 50 mm

Advantages

Notes

- use the profile knives with the respective deflector blanks always in pairs
- max. profile depth 15 mm
- thickness of knife and deflector 4 mm, other thicknesses are not permitted
- knife and deflector not included in delivery. You will find them on our homepage: www.stehle-int.com/ Universal Euro-Messerkopf-Katalog

Product features

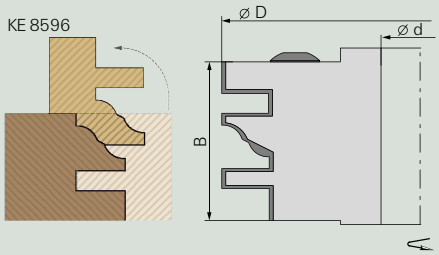
Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	nmin-nmax [min-1]				PU [pc.]	L	Order-No.
96	40	30	2	7800-10000			●	1	o	69563162
116	40/50	30	2	5000-8000			●	1	o	69563160
116	40/50	40	2+2	5000-8000			●	1	o	69563163
116	40/50	50	2	5000-8000			●	1	o	69563161

HW 5567 Counter Profile Cutterheads

Product

Drawing



Machine / Application

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

Design

- body made from high-strength aluminium
- cutting edges parallel to cutter axis
- cutting material: HW TC06
- chip limiter design

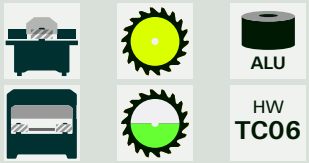
Advantages

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

Notes

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

Machine / Application / Design



Product features

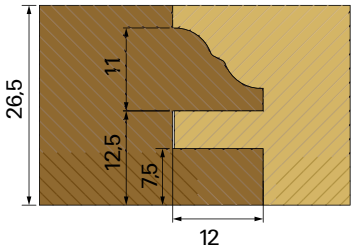
Order information

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

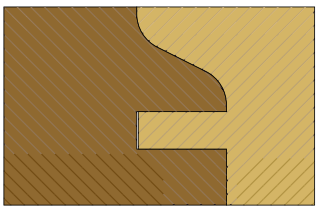
Turnover Knives	Cutting material	PU [pc.]	L	Order-No.
Profile Knives KE7826	TC06	2		50687826
Profile Knives KE7828	TC06	6	s	50687828
Profile Knives KE7824	TC06	6	s	50687824
Profile Knives KE8598	TC06	6	s	50688598
Profile Knives KE8596	TC06	6	s	50688596

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Pressure Bars	B=36	2	#	50773906
Set Screws	M6x16 SW3	10		001617
Screwdrivers	SW3x100	1		166090

KE 8596



KE 7824



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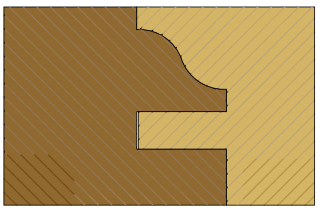
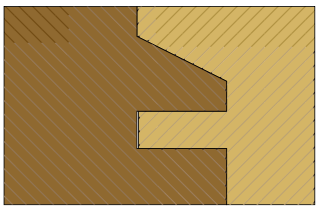
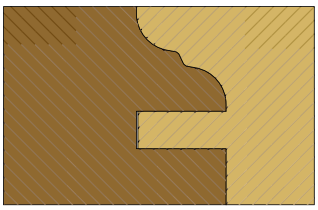


KE 7828



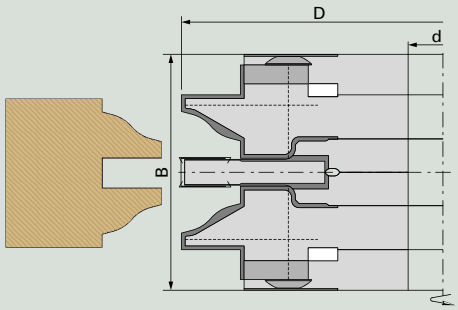
KE 8598



HW 5554 Counter Profile Set

Product

Drawing



Machine / Application

- spindle moulder
- for cutting of profile and counter profile in solid woods and wood-based panels

Design

- cutting edges parallel to cutter axis
- cutting material: HW
- modular combination tool

Advantages

- cutterhead for mounting of several profile knives
- universal application with low expenses

Notes

- counter profile set with profile A
- alternative profiles not included in delivery

Machine / Application / Design

HW TC05

HW TC06

HW TCw30

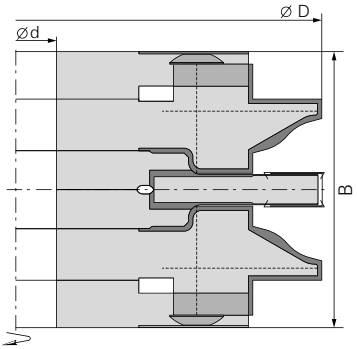
MAN

Product features — Order information

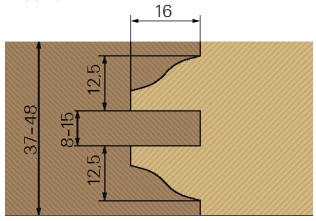
Ø D [mm]	B [mm]	Ø d [mm]	Z		Profile	nmin-nmax [min-1]		PU [pc.]	L	Order-No.
160	37-48	30	2		A	4800-8200		1		50664655

Turnover Knives		Profile	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Raker Turnover Knives			7,5	12	1.5	TC05	10		50820007
Turnover Knives			14	14	2.0	TCw30	10		50820014

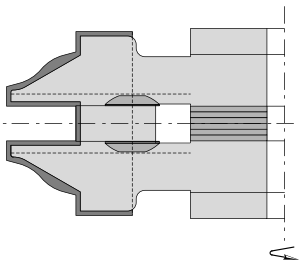
Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Set Screws	M6x16 SW3	10		001617
Countersunk Screws	M5x6 T20	10		176199
Screwdrivers	SW3x100	1		166090
Screwdrivers	T20x100	1		166092



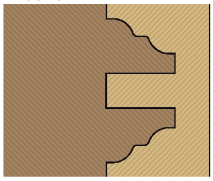
KE 8620



KE 8621

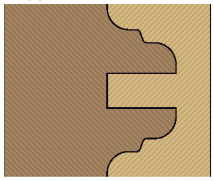


KE 8628



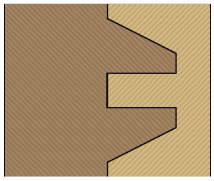
KE 8629

KE 8624



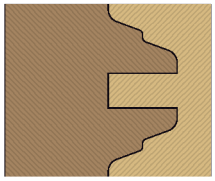
KE 8626

KE 8626



KE 8627

KE 8622

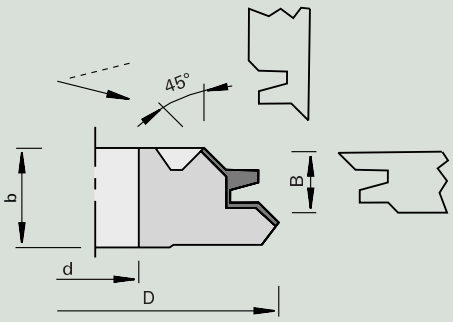


KE 8623

HW 5556 Miter Glue Joint Profile Cutterheads

Product

Drawing



Machine

Application

Design

ALU

HW
TCw25

MAN

Machine / Application

- molders
- spindle moulder
- for cutting of miter lock joints in solid woods and wood-based panels

Design

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

Advantages

- continuous high profile accuracy thanks to profile knives
- profile play adjustable by means of shims underneath the grooving/ chamfering knives

Notes

- application against feed
- wood thickness approx. 15 mm to max. 28 mm

Product features — **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	nmin-nmax [min-1]		PU [pc.]	L	Order-No.
174	26	49	30	2+2	4600-7800		1		50664636

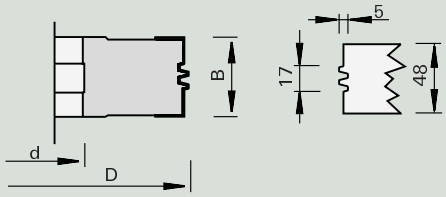
Turnover Knives	[mm]	Cutting material	PU [pc.]	L	Order-No.
Grooving / Chamfering Knife HW	16x34x5	TCw30	5		184275 NEW
Miter Glue Joint Profile Knives HW	39,5x12x1,5	TCw20	10		165916 NEW

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Clamping Pieces	12x8,5/M8L	2		180357
Clamping Set Screws	M8x26 SW4	10		180340
Countersunk Screws	M5x10,8 T15	10		180840
Screwdrivers	SW4x100	1		166091
Screwdrivers	T15x100	1		180470

HW 1534-2 Glue Joint Profile Cutterheads

Product

Drawing



Machine

Application

Design

HW TC05

MAN

Machine / Application

- molders
- spindle moulder
- for cutting of edge glue joints in solid woods

Design

- cutting edges parallel to cutter axis
- cutting material: HW TC05
- n = 5,700 - 9,800 min-1

Advantages

- continuous high profile accuracy thanks to turnover knives

Notes

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

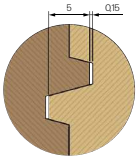
Product features — **Order information**

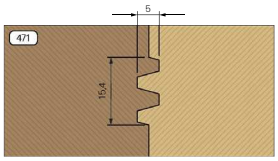
Ø D [mm]	B [mm]	Ø d [mm]	Ø dmax [mm]	Z	H [mm]	Profile		PU [pc.]	L	Order-No.
135	40	30	50	2	9-38	470		1	s	50663047
135	50	30	50	2	17-48	471		1	#	50663025
135	60	30	50	2	25-58	472		1	s	50663026

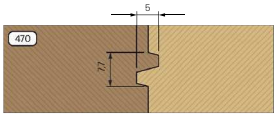
Knives		Profile	B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Profile Knives KB450		470	40	23	2.0	TC05		6	s	50690450
Profile Knives KB374		471	50	23	2.0	TC05		2		50820003
Profile Knives KB372		472	60	23	2.0	TC05		4		50820004

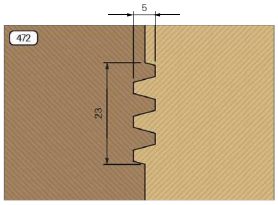
Spare parts	Dimension [mm]	Suitable for		PU [pc.]	L	Order-No.
Pressure Bars	38x11x6	50663047		2		50005542
Pressure Bars	48x11x6	50663025		2		50591365
Pressure Bars	58x11x6	50663026		2		180434
Clamping Pieces	12x8,5/M8L	For all		2		180357
Clamping Set Screws	M8x26 SW4	For all		10		180340
Screwdrivers	SW4x100	For all		1		166091

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







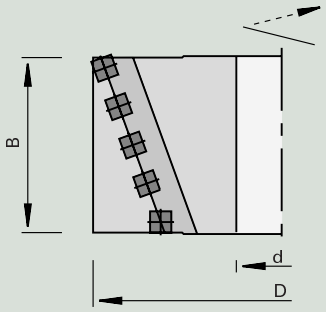


HW 5570 Spiral Cutterheads

with HW turnover knife

Product

Drawing



Machine

Application

Design

HW TCw25

MEC

Machine / Application

- molders
- stationary milling centers
- for milling, rough-planing and finish-planing in solid woods

Design

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

Advantages

- easy hogging, low cutting pressure and low noise level

Notes

- for 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

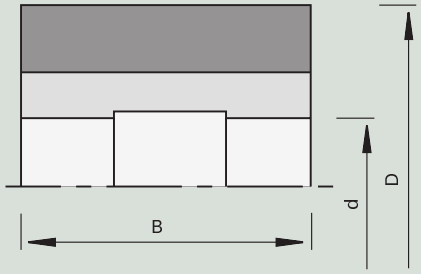
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives (with rounded edges)			15	15	2.5	TCw20		10		50820017

Spare parts	Dimension [mm]					PU [pc.]	L	Order-No.
Countersunk Screws	M5x15,5 T20					10		182112
Screwdrivers	T20x100					1		166092

HS 556-1 Planing Cutterheads

Product

Drawing



Machine

Application

Design

HS

HSLL

HW

MEC

Machine / Application

- multi spindle plunging 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

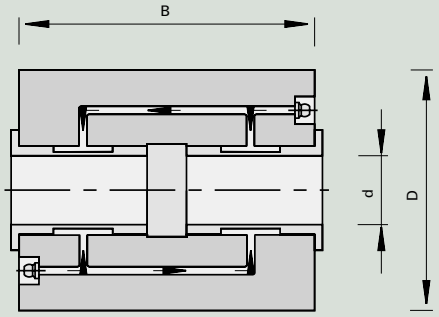
Ø D [mm]	B [mm]	Ø d [mm]	Z						PU [pc.]	L	Order-No.
125	80	40	4					●	1	o	50561046
125	100	40	4					●	1	o	50561038
125	130	40	4					●	1	o	50561035
125	150	40	4					●	1	o	50561036
125	180	40	4					●	1	o	50561037
125	240	40	4					●	1	o	50561054

Spare parts	Dimension [mm]						PU [pc.]	L	Order-No.
Pressure Bars	B=80						2	o	179205
Pressure Bars	B=100						2	o	181191
Pressure Bars	B=130						2	o	179198
Pressure Bars	B=150						2	o	179199
Pressure Bars	B=180						2	o	179200
Set Screws	M10x25 DIN EN ISO 4028						10		168108
Cranked Wrench Keys	SW5 DIN ISO 2936						1		009674
Clamping Bars	B=240						2	o	50562677

HS 520-1 Hydro Planing Cutterheads

Product

Drawing



Machine

Application

Design

HS

HSLL

HW

MEC

Machine / Application

- hydro profile molders
- for planing of solid woods

Design

Advantages

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

Notes

- HS-tipped knives 30 x 3 mm
- alternative cutting material: ST for soft and hard woods; HW for hard and exotic woods
- peripheral application of pressure on request

Product features / Order information

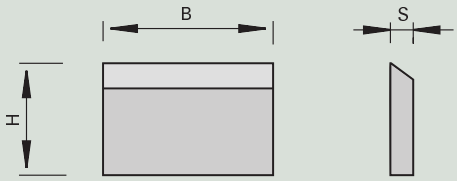
Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min-1]		PU [pc.]	L	Order-No.
143	60	40	4	8500	○	1	s	58562686
143	130	40	4	8500	○	1	s	58562689
143	230	40	4	8500	○	1	s	58562990
163	60	50	4	6000	○	1	s	58562687
163	100	50	4	6000	○	1	s	58562691
163	130	50	4	6000	○	1	s	58562741
163	130	50	4	6000	○	1	s	58562693
163	180	50	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 presses		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**

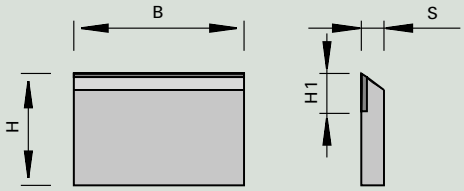
B [mm]	H [mm]	S [mm]		PU [pc.]	L	Order-No.
60	30	3	○	2	s	58400131
80	30	3	○	2	s	58400132
100	30	3	○	2		58400133
120	30	3	○	2	s	58400134
130	30	3	○	2		58400135
150	30	3	○	2		58400136
160	30	3	○	2		58400137
170	30	3	○	2		58400161
180	30	3	○	2		58400138
180	35	3	○	2	s	58400201
210	30	3	○	2	s	58400162
230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

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

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

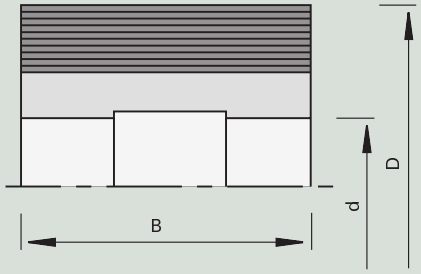
- packing unit: 2 pieces

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

HW 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.
Pressure Bars	B=40						2	o	179221
Pressure Bars	B=230						2	o	179228
Pressure Bars	B=180						2	o	179227
Pressure Bars	B=150						2	o	179226
Pressure Bars	B=130						2	o	179225
Pressure Bars	B=100						2	o	179224
Pressure Bars	B=80						2	o	179223
Pressure Bars	B=60						2	o	179222
Dummy Pieces	B=40						2	o	179229
Dummy Pieces	B=230						2	o	179236
Dummy Pieces	B=180						2	o	179235
Dummy Pieces	B=150						2	o	179234
Dummy Pieces	B=130						2	o	179233
Dummy Pieces	B=100						2	o	179232
Dummy Pieces	B=80						2	o	179231
Dummy Pieces	B=60						2	o	179230
Screwdrivers	SW5x150						1		168703
Set Screws	M10x20 DIN EN ISO 4028						10		815807

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

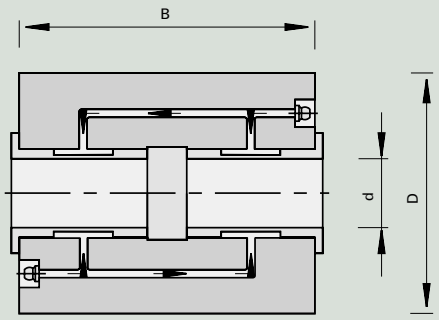
Maximum RPM

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

HW 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]	PU [pc.]	L	Order-No.
Set Screws	M12x25 DIN EN ISO 4028	10		181466
Screwdrivers	SW6x200	1		167817
Grease presses		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

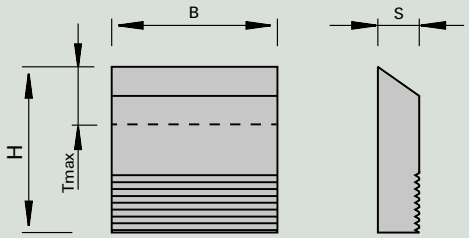
Maximum RPM

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

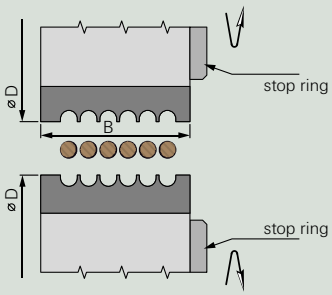
Order information

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	o	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	o	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	o	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

Product

Drawing



Machine

Application

Design

HS

MEC

Machine / Application

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

Design

- body made from steel
- 2 or 4 knife holders

Advantages

- quick knife change
- self-centering knife seat

Notes

- guide-plate for axial adjustment of knives
- further profiles on request

Product features / Order information

Ø D [mm]	B [mm]	Ø d [mm]	Ø dmax [mm]	Z	nmax [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

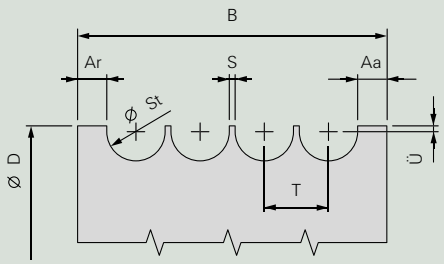
Spare parts	Dimension [mm]			PU [pc.]	L	Order-No.
Head Cap Screws	M8x30			10		180005
Cranked Wrench Keys	SW6x100			1	o	180383
Washers	B=8,4 DIN 125			10	s	50945505

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

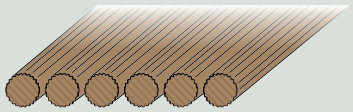
KNIVES

	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
	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

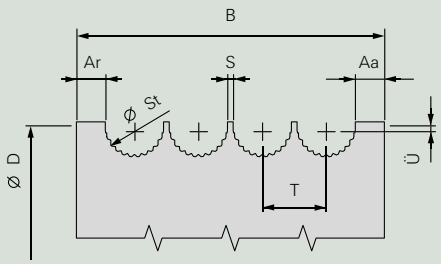
HS 464 HS Knives ripple bars

for fine serration dowels

Product



Drawing



Machine

Application

Design

HS

Machine / Application

Design

Advantages

Notes

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

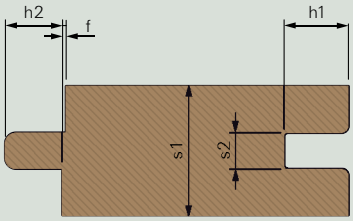
KNIVES

	St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
	No. of serrations	16	16	20	22	22	22	22	22	22	22
	S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
	T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
	D= diameter	127	127	135	135	135	135	135	135	135	135
B=50	No. of bars	6	5	4	3	3	3	3	2	2	2
	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

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

Design

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

Advantages

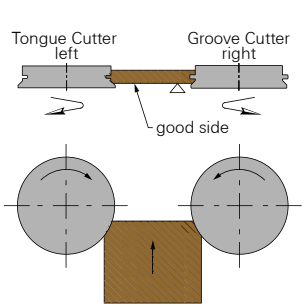
Notes

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

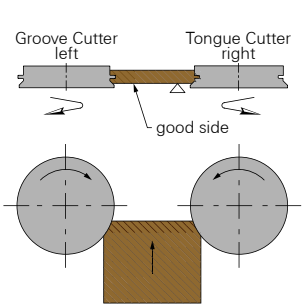
Product features **Order information**

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

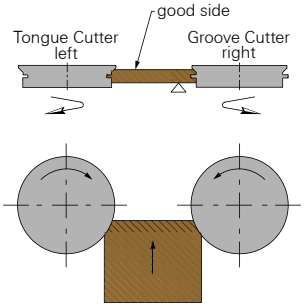
Example I



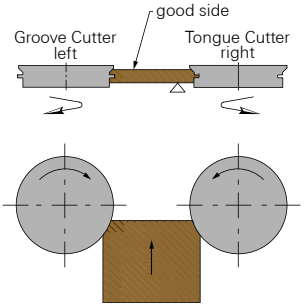
Example II



Example III



Example IV



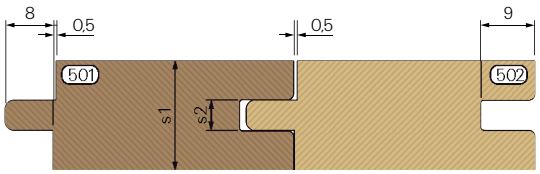
4000 Tongue and Groove Tools

Diagram I

Tongue Cutters

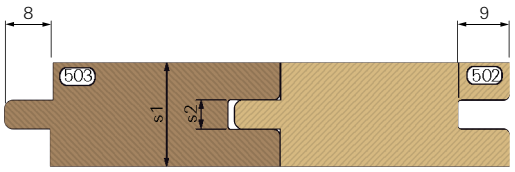
Grooving Cutters

Profile 501



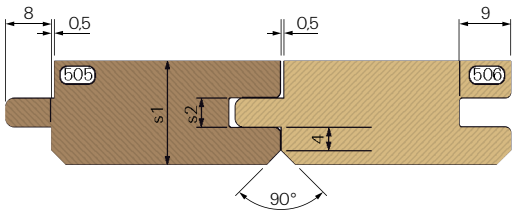
Profile 502

Profile 503



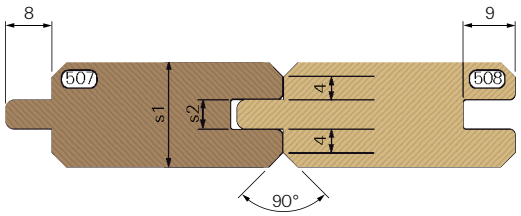
Profile 502

Profile 505



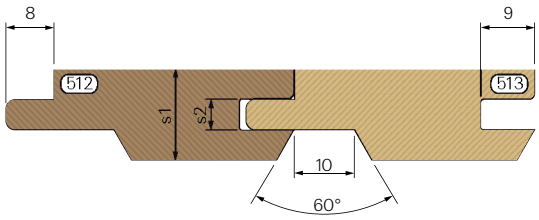
Profile 506

Profile 507



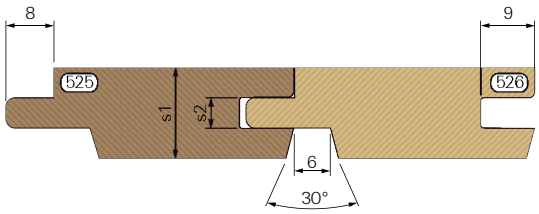
Profile 508

Profile 512



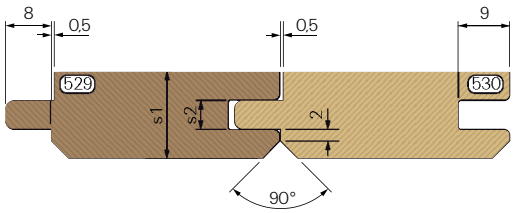
Profile 513

Profile 525



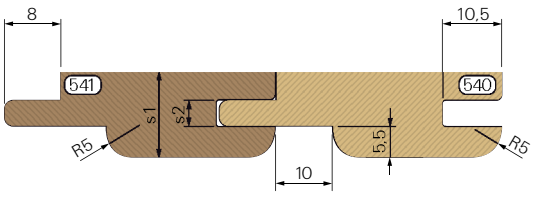
Profile 526

Profile 529



Profile 530

Profile 541

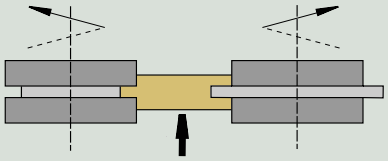


Profile 540

HW 4010 Tongue and Groove Tool Set - Silverline

Product

Drawing



Machine

Application

Design

MAN

MEC

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
- cutting circles after knife change

Notes

- when ordering, specify the spindle diameter (30, 40, 50 mm)!

Product features / Order information

Profile	Ø D [mm]	B [mm]	Ø d [mm]	nmax [min-1]	Z	Cutter-no.		PU [pc.]	L	Order-No.
A	140	13-33	30	8000	2	1, 2, 3, 4, 5	○	1	s	68303301
A	140	13-33	40	8000	2	1, 2, 3, 4, 5	○	1	s	68303401
A	140	13-33	50	8000	2	1, 2, 3, 4, 5	○	1	s	68303501
B	140	13-33	30	8000	2	1, 3, 4, 5, 6	○	1	s	68303302
B	140	13-33	40	8000	2	1, 3, 4, 5, 6	○	1	s	68303402
B	140	13-33	50	8000	2	1, 3, 4, 5, 6	○	1	s	68303502
C	140	13-40	30	8000	2	1, 3, 4, 5, 6, 15, 16	○	1	s	68303303
C	140	13-40	40	8000	2	1, 3, 4, 5, 6, 15, 16	○	1	s	68303403
C	140	13-40	50	8000	2	1, 3, 4, 5, 6, 15, 16	○	1	s	68303503
D	140	13-36	30	8000	2	1, 2, 3, 4, 5, 15, 16	○	1	s	68303304
D	140	13-36	40	8000	2	1, 2, 3, 4, 5, 15, 16	○	1	s	68303404
D	140	13-36	50	8000	2	1, 2, 3, 4, 5, 15, 16	○	1	s	68303504
E	140	13-36	30	8000	2	1, 3, 4, 9, 10	○	1	s	68303305
E	140	13-36	40	8000	2	1, 3, 4, 9, 10	○	1	s	68303405
E	140	13-36	50	8000	2	1, 3, 4, 9, 10	○	1	s	68303505
F	140	13-36	30	8000	2	1, 3, 4, 7, 8	○	1	s	68303306
F	140	13-36	40	8000	2	1, 3, 4, 7, 8	○	1	s	68303406
F	140	13-36	50	8000	2	1, 3, 4, 7, 8	○	1	s	68303506
G	140	13-36	30	8000	2	3, 9, 11, 12, 14	○	1	s	68303307
G	140	13-36	40	8000	2	3, 9, 11, 12, 14	○	1	s	68303407
G	140	13-36	50	8000	2	3, 9, 11, 12, 14	○	1	s	68303507
H	140	13-36	30	8000	2	3, 7, 11, 12, 13	○	1	s	68303308
H	140	13-36	40	8000	2	3, 7, 11, 12, 13	○	1	s	68303408
H	140	13-36	50	8000	2	3, 7, 11, 12, 13	○	1	s	68303508

Product features / Order information

Profile	Ø D [mm]	B [mm]	Ø d [mm]	nmax [min-1]	Z	Cutter-no.		PU [pc.]	L	Order-No.
A	180	13-33	30	8000	4	1, 2, 3, 4, 5	○	1	s	68302301
A	180	13-33	40	8000	4	1, 2, 3, 4, 5	○	1	s	68302401
A	180	13-33	50	8000	4	1, 2, 3, 4, 5	○	1	s	68302501
B	180	13-33	30	8000	4	1, 3, 4, 5, 6	○	1	s	68302302
B	180	13-33	40	8000	4	1, 3, 4, 5, 6	○	1	s	68302402
B	180	13-33	50	8000	4	1, 3, 4, 5, 6	○	1	s	68302502
C	180	13-40	30	8000	4	1, 3, 4, 5, 6, 15, 16	○	1	s	68302303

Product features							Order information			
Profile	Ø D [mm]	B [mm]	Ø d [mm]	nmax [min-1]	Z	Cutter-no.		PU [pc.]	L	Order-No.
C	180	13-40	40	8000	4	1, 3, 4, 5, 6, 15, 16	○	1	s	68302403
C	180	13-40	50	8000	4	1, 3, 4, 5, 6, 15, 16	○	1	s	68302503
D	180	13-36	30	8000	4	1, 2, 3, 4, 5, 15, 16	○	1	s	68302304
D	180	13-36	40	8000	4	1, 2, 3, 4, 5, 15, 16	○	1	s	68302404
D	180	13-36	50	8000	4	1, 2, 3, 4, 5, 15, 16	○	1	s	68302504
E	180	13-36	30	8000	4	1, 3, 4, 9, 10	○	1	s	68302305
E	180	13-36	40	8000	4	1, 3, 4, 9, 10	○	1	s	68302405
E	180	13-36	50	8000	4	1, 3, 4, 9, 10	○	1	s	68302505
F	180	13-36	30	8000	4	1, 3, 4, 7, 8	○	1	s	68302306
F	180	13-36	40	8000	4	1, 3, 4, 7, 8	○	1	s	68302406
F	180	13-36	50	8000	4	1, 3, 4, 7, 8	○	1	s	68302506
G	180	13-36	30	8000	4	3, 9, 11, 12, 14	○	1	s	68302307
G	180	13-36	40	8000	4	3, 9, 11, 12, 14	○	1	s	68302407
G	180	13-36	50	8000	4	3, 9, 11, 12, 14	○	1	s	68302507
H	180	13-36	30	8000	4	3, 7, 11, 12, 13	○	1	s	68302308
H	180	13-36	40	8000	4	3, 7, 11, 12, 13	○	1	s	68302408
H	180	13-36	50	8000	4	3, 7, 11, 12, 13	○	1	s	68302508

Turnover Knives	Dimension [mm]			PU [pc.]	L	Order-No.
Chamfering Turnover Knives	16x22x5,0	For all		10		183668
Grooving Insert	B=4	For all		2	o	68002122
Turnover Knives	12x12x1,5	For all		10		50820012
Raker Turnover Knives	15x12x1,5	For all		10		50820015
Raker Turnover Knives	20x12x1,5	For all		10		50820020
Spurs	14x14x2	For all		10		50820014

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Delivery according to diagram I