Stehle

Tool Program

2023

Tools just a few clicks away - experience the Stehle webshop now

1. Select your tools and accessories from the Stehle catalogue, the advanced search function will help
2. Compare products to find the best solution for your application
3. See availability immediately > most of them directly from stock!
4. Create shopping baskets, e.g. for specific applications or machines

But the shop can do more than that:

5. Delivery tracking > if you want to know where your parcel is right now
6. Search your own order history > what you have bought before
7. Quick purchase with known order no. by "copy & paste"

Stehle

Tool Program

2023

Innovative
Trend-Setting
Reliable

STEHLE IS RELIABLE

The Stehle brand has been known for more than 100 years in the wood processing industry for their high-quality and sophisticated tools which can be used for all standard processing applications

Since the Stehle brand was integrated in the LEUCO group at the end of the 1990s, it has been systematically oriented towards the supply and the needs of specialized dealers.

Our goal is to offer our customers in the specialized trade individual tool solutions in a targeted and comfortable way by means of a good and fast availability, an intuitively usable catalog and a self-explanatory color guidance system.

STEHLE IS RELIABLE ...

RELIABLE

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

We have used the last few years to offer retailers a functional and intuitive digital e-shop and are very pleased with the lively and positive use and acceptance and feedback from our customers.

In addition to expanding our international partnerships, we are continuously working on optimizing our Stehle program and adding further digital services, and we also welcome feedback and suggestions for improvement.

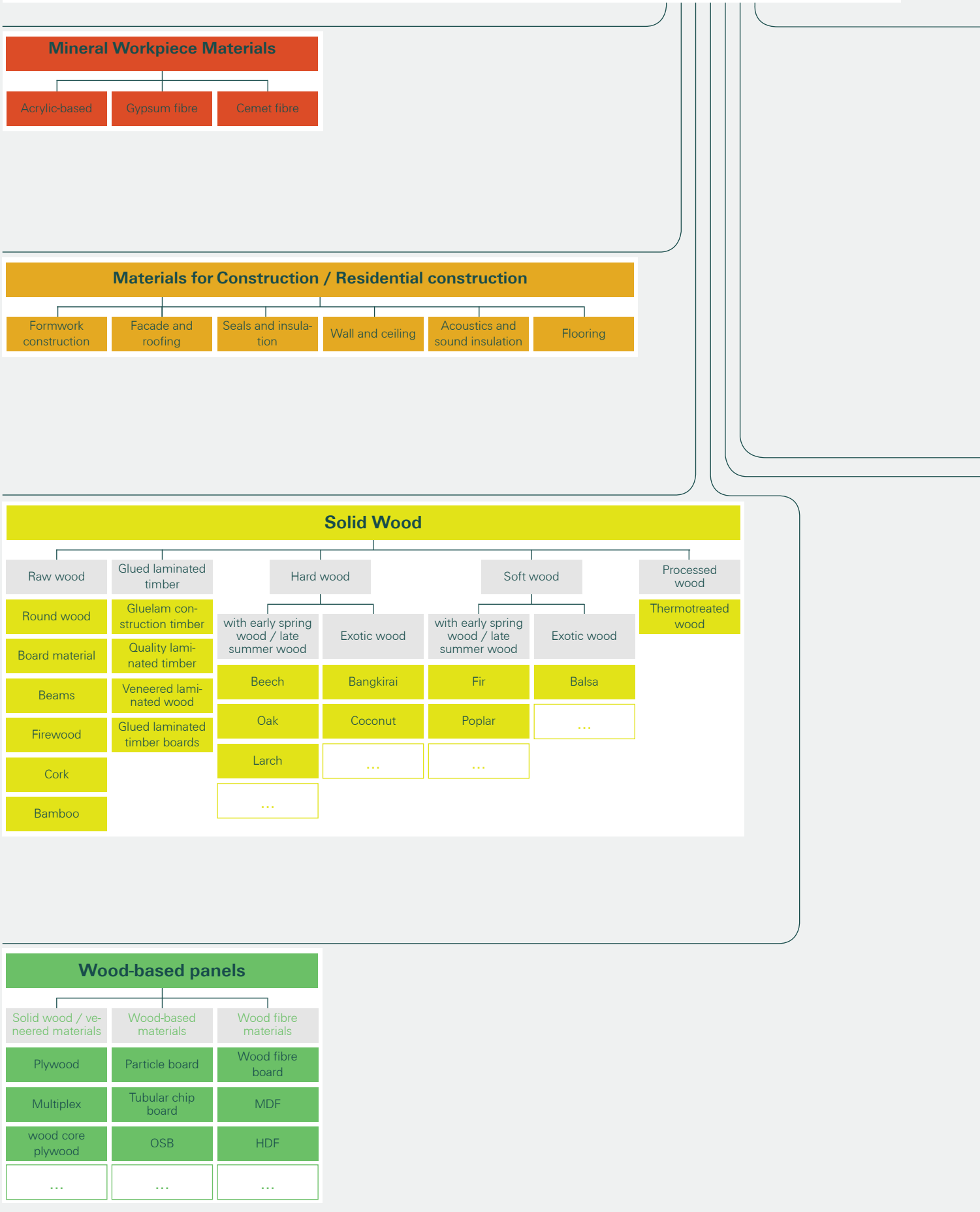
We see the much-cited digitization as an opportunity to make life more pleasant and efficient for you and for us. Let´s continue to walk this path together. You can rely on the Stehle brand as a strong and reliable partner, at home in a powerful and innovative LEUCO Group.

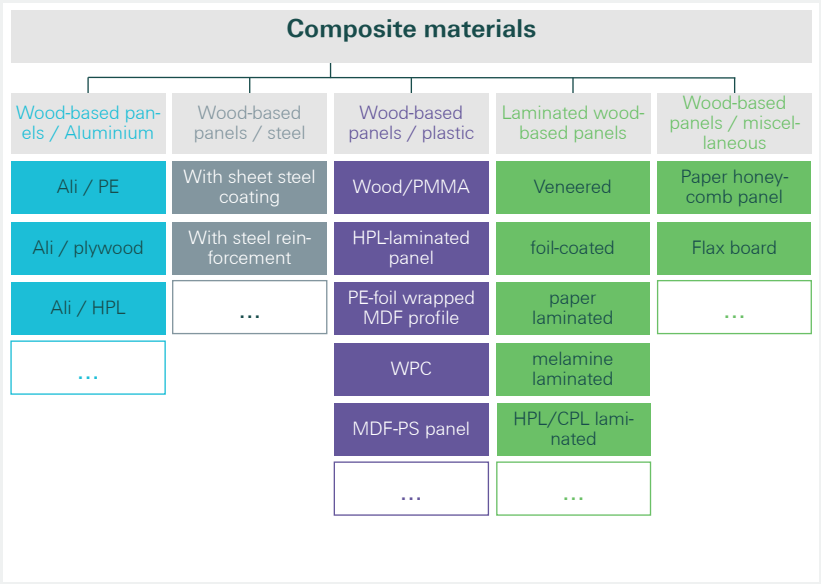
Enjoy and be successful with our new catalog!
Whether in paper form, on your PC or smartphone!

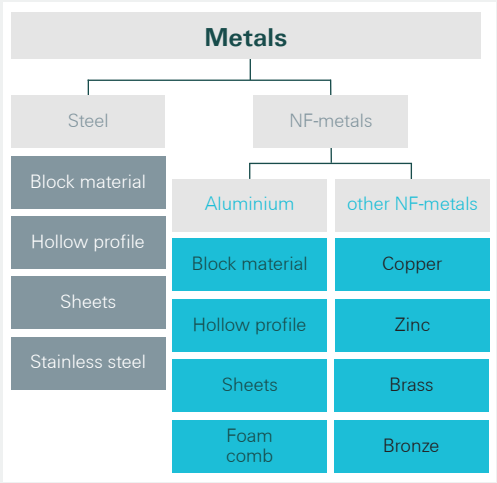
Daniel Schrenk,
CEO

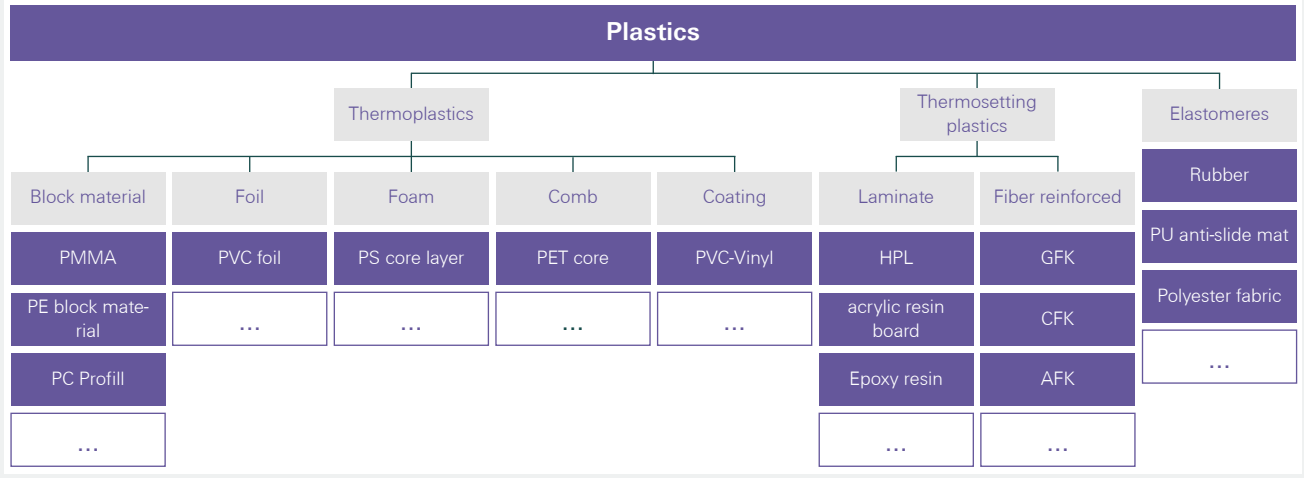
Reiner Bix,
Sales Manager Distribution

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

CIRCULAR SAW BLADES

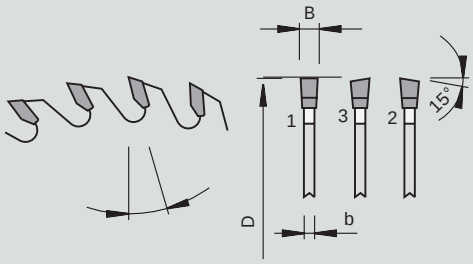
CONTENTS

HW HKS - solid - thin-kerf saw blades

Portable saw blades HW - flat tooth - alternate top bevel, suitable for cordless and corded machines

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC10

F-
WS

Machine / Application

- 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 and corded portable machines
- Attention: consider thickness of the splitting wedge!

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	L	58110400
136	1,5	1.0	20	24	▲▲	Dewalt	20		1	L	58110401
160	1,8	1.2	20	18	▲	Mafell, Festool	20		1	L	58110413
160	1,8	1.2	20	24	▲	Makita, Festool, Bosch	15		1	L	58110423
160	1,8	1.2	20	30	▲▲	Mafell, Festool	15		1	L	58110424 NEW
160	1,8	1.2	20	48	▲▲▲▲	Mafell, Festool	10		1	L	58110419
165	1,8	1.2	20	18	▲	Makita, Dewalt, Bosch	20		1	L	58110402
165	1,8	1.2	20	24	▲	Makita, Dewalt, Bosch	15		1	L	58110403
165	1,8	1.2	20	36	▲▲	Makita, Dewalt, Bosch	15		1	L	58110404
165	1,6	1.2	15,88	24	▲▲▲▲	Milwaukee	15		1	O	58110421
165	1,8	1.2	20	48	▲▲▲▲	Makita, Dewalt, Bosch	10		1	L	58110420
165	1,8	1.2	15,88	40	▲▲▲	Milwaukee	10		1	L	58110405
168	1,8	1.2	20	18	▲	Mafell, Festool	20		1	L	58110427 NEW
168	1,8	1.2	20	30	▲▲▲	Mafell, Festool	15		1	L	58110428 NEW
168	1,8	1.2	20	48	▲▲▲▲	Mafell, Festool	10		1	L	58110429 NEW
184	1,6	1.1	16	54	▲▲▲	Dewalt	10		1	L	58110406
184	1,8	1.2	20	24	▲▲▲	Mafell	20		1	L	58110416
190	1,8	1.2	30	48	▲▲▲▲	Hilti	15		1	O	58110418
190	1,8	1.2	20	48	▲▲▲	Dewalt	15		1	L	58110407
190	1,8	1.2	30	24	▲▲▲	Hilti, Milwaukee, Dewalt	20		1	L	58110417

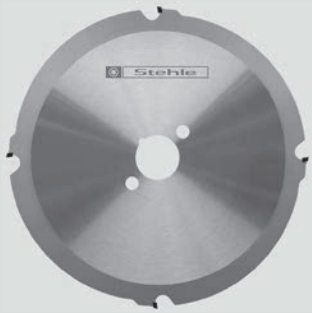
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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*		Hook angle [°]		PU [pc.]	L	Order-No.
210	1,8	1.2	30	60	▲▲▲	Dewalt Extrem	15		1	L	58110408
216	2,0	1.4	30	24	▲	Dewalt	20		1	#	58110409
216	2,0	1.4	30	36	▲▲	Dewalt	15		1	L	58110410
216	2,0	1.4	30	60	▲▲▲	Dewalt	10		1	L	58110411
250	2,2	1.6	30	24	▲	Dewalt	20		1	L	58110412

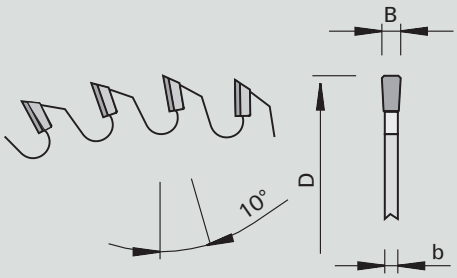
DP HKS - L thin-kerf saw blades

Portable Saw Blades DP - flat tooth, suitable for cordless and corded machines

Product



Drawing



Machine

Application

Design

0,0 mm

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

- low power consumption thanks to reduced kerf

Notes

- cannot be used for stone, glass and nails
- suitable for cordless and corded portable machines
- Attention: consider thickness of the splitting wedge!

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	▲	Dewalt	10		1	O	58460500 NEW
160	1,8	1.2	20	6	▲	Makita, Festool, Bosch	10		1	O	58460479 NEW
165	1,8	1.2	20	6	▲	Makita, Dewalt, Bosch	10		1	O	58460480 NEW
168	1,8	1.2	20	6	▲	Mafell, Festool	6		1	L	50460481 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

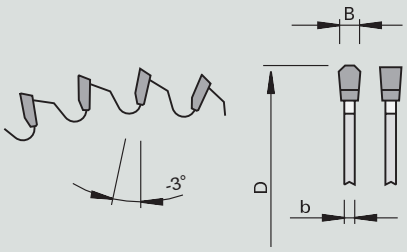
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - Parat - negative - Thin-kerf Saw blades

Universal Saw Blade HW - negative hook angle triple chip / flat, suitable for cordless and corded machines

Product

Drawing



Machine

Application

Design

2-0-6

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

- suitable for cordless and corded portable machines Attention: consider thickness of the splitting wedge!

Product features / **Order information**

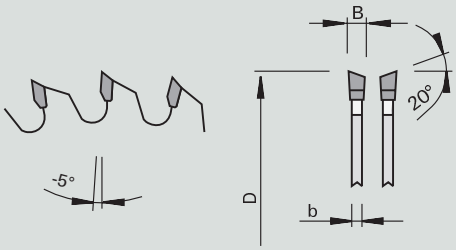
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*		Hook angle [°]		PU [pc.]	L	Order-No.
160	1,8	1.2	20	52	▲▲▲▲	Makita, Mafell, Festool, Bosch	-3		1	L	58115607 NEW
165	1,8	1.2	20	52	▲▲▲▲	Makita, Dewalt, Bosch	-3		1	O	58115608 NEW
168	1,8	1.2	20	52	▲▲▲▲	Mafell, Festool	-3		1	L	58115609 NEW

HW K + G - negative thin-kerf saw blades

Clipping and Miter Saw Blades HW - alternate bevel, suitable for cordless and corded machines

Product

Drawing



Machine

Application

Design

2-0-6

HW **TC10**

F-WS

Machine / Application

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

Design

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

Advantages

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

Notes

- suitable for cordless and corded portable machines

Product features / **Order information**

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
216	1,8	1.2	30	48	▲▲▲		-5		1	L	58110425 NEW
305	2,2	1.6	30	72	▲▲▲		-5		1	L	58110426 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

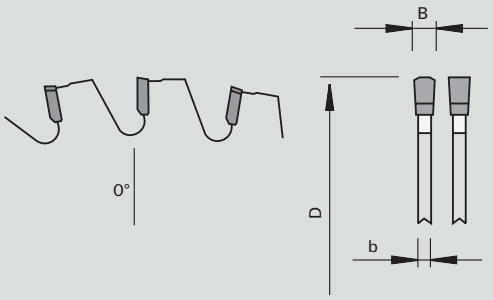
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - Unisteel - Thin-kerf Saw blades

Portable Saw Blades HW - triple chip / flat, suitable for cordless and corded machines

Product

Drawing



Machine

Application

Design

2-0-6

HW **TCm13**

TR-F

Machine / Application

- 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 and corded portable machines
- Attention: consider thickness of the splitting wedge!

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	L	58116400
160	1,8	1.2	20	40	▲▲	Mafell, Festool	0		1	O	58116402
165	1,8	1.2	20	40	▲▲	Makita, Dewalt	0		1	L	58116401

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

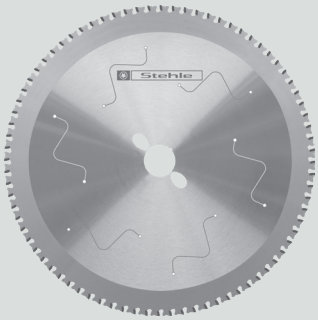
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

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

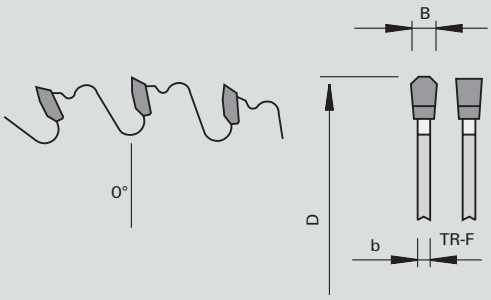
HT HKS - Mega-Steel - Thin-kerf Saw blades

Saw Blades HT for metal - neutral hook angle, suitable for cordless and corded machines

Product



Drawing



Machine

Application

Design

3-0-1

HW
TCx03

TR-F

Machine / Application

- dry-cut 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 and corded portable machines
- Attention: consider thickness of the splitting wedge!
- alt. Parat - Negativ e (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.
150	1,8	1.4	20	32	▲▲	Makita, Bosch, Ryobi	10		1	L	58458810 NEW
160	1,8	1.4	20	40	▲▲	Mafell, Festool	0		1	L	58458784
190	1,8	1.4	30	48	▲▲	Hilti, Milwaukee, Dewalt	10		1	L	58458785
216	1,8	1.4	30	56	▲▲	Dewalt	0		1	L	58458786
230	1,8	1.4	30	60	▲▲		0		1	L	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

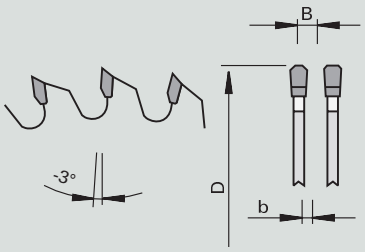
HW

HKS - KKS - hard plastic negative - Thin-kerf Saw blades

Portable Saw Blades HW for extremely hard plastic profiles - triple chip / flat tooth with two-sided chamfer, suitable for cordless and corded machines

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

TR-F-FA

Machine / Application

- portable 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 TC04 plus

Advantages

- noise-reduction thanks to laser ornaments

Notes

- suitable for cordless and corded portable machines
- Attention: consider thickness of the splitting wedge!

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	-3		1	L	58808600
160	1,8	1.2	20	48	▲▲	Mafell, Festool	-3		1	L	58808605
165	1,8	1.2	20	48	▲▲	Makita, Dewalt, Bosch	-3		1	L	58808606
168	1,8	1.2	20	48	▲▲▲▲	Mafell, Festool	-3		1	L	58808603 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

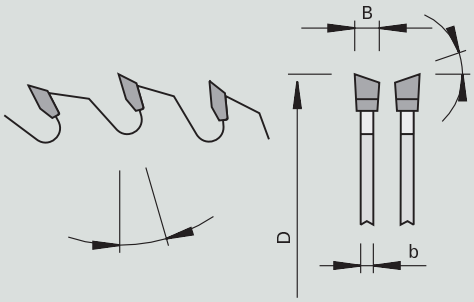
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - solid

Trimming 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	L	50104061
125	2,4	1.6	20	20	▲▲	2/5,5/30	15	1	L	50110011
130	2,4	1.6	20	20	▲▲	2/6/32,5	15	1	L	50110017
140	2,4	1.6	20	20	▲▲	2/6/32,5	15	1	L	50110028
150	2,6	1.6	20	24	▲▲	2/6/32,5	15	1	L	50110039
150	2,6	1.6	20	12	▲	2/6/32,5	20	1	L	50110243
160	2,6	1.6	16	24	▲▲	2/6/32,5	15	1	L	50110051
160	2,2	1.6	20	24	▲▲	2/6/32,5	15	1	L	50110054
160	2,2	1.6	20	12	▲	2/6/32,5	20	1	L	50110244
160	2,6	1.6	30	24	▲▲	2/7/42	15	1	L	50110057
165	2,6	1.6	20	24	▲	2/6/32,5	15	1	L	50110060
165	2,6	1.6	30	24	▲	2/7/42	15	1	L	50110130
170	2,6	1.6	30	24	▲▲	2/7/42	20	1	L	50110069
180	2,6	1.6	16	24	▲▲	2/6/32,5	15	1	L	50110081
180	2,6	1.6	20	24	▲▲	2/6/32,5	20	1	L	50110075
180	2,6	1.6	30	24	▲▲	2/7/42	20	1	L	50110078
180	2,6	1.6	30	14	▲	2/7/42	20	1	L	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	L	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	L	50110154
190	2,6	1.6	30	24	▲▲	2/7/42	20	1	L	50110155
190	2,6	1.6	30	16	▲	2/7/42	20	1	L	50110251
190	2,6	1.6	30	24	▲▲		15	1	L	58114105
200	2,8	1.8	30	30	▲▲▲	2/7/42	15	1	L	50110095
200	2,8	1.8	30	18	▲	2/7/42	20	1	L	50110252
205	2,6	1.8	18	30	▲▲▲		15	1	L	50110286
210	2,8	1.8	30	30	▲▲▲	2/7/42	15	1	L	50110104
210	2,8	1.8	30	18	▲	2/7/42	20	1	L	50110253
216	2,8	1.8	30	30	▲▲▲	2/7/42	20	1	L	50110107
220	2,8	1.8	30	36	▲▲▲	2/7/42	15	1	L	50110110
220	2,8	1.8	30	24	▲▲	2/7/42	15	1	L	50110164
225	2,8	1.8	30	24	▲▲	2/7/42	15	1	L	50110165
225	2,8	1.8	30	34	▲▲▲	2/7/42	15	1	L	50110228
230	2,8	1.8	30	36	▲▲▲	2/7/42	15	1	L	50110113
230	2,8	1.8	30	24	▲▲	2/7/42	15	1	L	50110168
230	2,8	1.8	30	18	▲	2/7/42	20	1	L	50110255

* **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

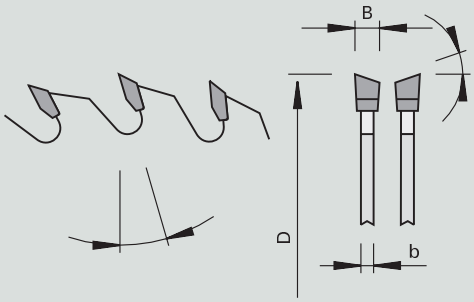
Appropriate **reducing rings** can be found at the end of the chapter

HW HKS - Board

Portable finish cut 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 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.]	L	Order-No.
100	2,4	1.4	12	30	▲▲▲		10		1	L	50110001
100	2,4	1.4	22	30	▲▲▲		10		1	L	50110003
105	2,4	1.4	22	30	▲▲▲		10		1	L	50110006
125	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		1	L	50110012
130	2,4	1.6	20	36	▲▲	2/6/32,5	10		1	L	50110018
140	2,4	1.6	20	36	▲▲▲	2/6/32,5	10		1	L	50110029
150	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		1	L	50110040
150	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	L	50110041
160	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		1	L	50110053
160	2,2	1.6	20	36	▲▲▲	2/6/32,5	15		1	L	50110055
160	2,2	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	L	50110056
160	2,2	1.6	20	48 Vario	▲▲▲▲	2/6/32,5	5		1	L	58110356
160	2,6	1.6	30	36	▲▲▲	2/7/42	15		1	L	50110058
160	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	L	50110059
165	2,6	1.6	20	36	▲▲▲	2/6/32,5	15		1	L	50110061
165	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	L	50110062
170	2,6	1.6	30	36	▲▲▲	2/7/42	15		1	L	50110070
170	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	L	50110071
180	2,6	1.6	16	48	▲▲▲▲	2/6/32,5	10		1	L	50110183
180	2,6	1.6	20	40	▲▲▲	2/6/32,5	15		1	L	50110076
180	2,6	1.6	30	40	▲▲▲	2/7/42	15		1	L	50110079
180	2,6	1.6	30	54	▲▲▲▲	2/7/42	10		1	L	50110080
190	2,6	1.6	16	30	▲▲▲	2/6/32,5	15		1	L	50110083
190	2,6	1.6	16	42	▲▲▲▲	2/6/32,5	10		1	L	50110084
190	2,6	1.6	20	30	▲▲▲	2/6/32,5	15		1	L	50110086
190	2,6	2.0	20FX	32	▲▲▲	Fast-Fix	10		1	L	50110266
190	2,6	2.0	20FX	48	▲▲▲▲	Fast-Fix	10		1	L	50110267
190	2,6	2.0	20FX	60	▲▲▲	Fast-Fix	10		1	L	50110268
190	2,6	1.6	20	48	▲▲▲▲	2/6/32,5	10		1	L	50110087
190	2,6	1.6	30	30	▲▲▲	2/7/42	15		1	L	50110089
190	2,6	1.6	30	48	▲▲▲▲	2/7/42	10		1	L	50110090
190	2,6	1.6	30	60	▲▲▲▲	2/7/42	10		1	L	50110091
200	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	L	50110096
210	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	L	50110105
210	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		1	L	50110106
216	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	L	50110108
216	2,8	1.8	30	60	▲▲▲▲	2/7/42	10		1	L	50110109
220	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	L	50110111
220	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	L	50110112

* **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

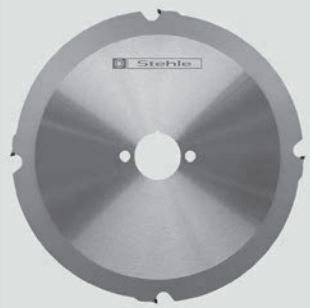
Appropriate **reducing rings** can be found at the end of the chapter

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	48	▲▲▲▲	2/7/42	10		1	L	50110237
225	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	L	50687902
230	2,8	1.8	30	48	▲▲▲▲	2/7/42	15		1	L	50110114
230	2,8	1.8	30	64	▲▲▲▲	2/7/42	10		1	L	50110115

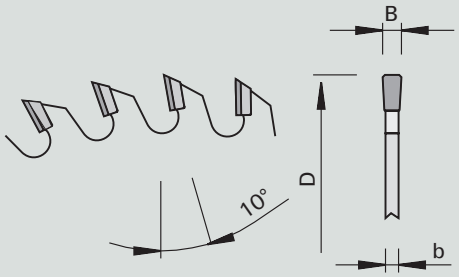
DP HKS - LR

Portable Saw Blades DP - flat tooth with chamfer

Product



Drawing



Machine

Application

Design

2-0-6

F-FA

Machine / Application

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

Design

- tooth configuration: flat with chamfer "F-FA"
- 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	10		1	L	58457997 NEW
190	2,2	1.6	30	4	▲	2/7/42	10		1	L	58457994 NEW
230	2,2	1.6	30	4	▲	Combi3	10		1	L	58457992 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

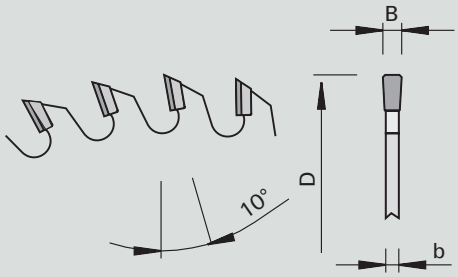
Appropriate **reducing rings** can be found at the end of the chapter

DP HKS - L

Portable Saw Blades DP - flat tooth with chamfer

Product

Drawing



Machine

Application

Design

1,0 mm

1-0-1

2-0-6

F-FA

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 with chamfer "F-FA"
- 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	▲	2/6/32,5	10		1	L	58457378 NEW
160	2,2	1.6	20	8	▲	2/6/32,5	10		1	L	58457379 NEW
160	2,2	1.6	20	30	▲▲▲	2/6/32,5	10		1	L	58458171 NEW
160	2,2	1.6	30	8	▲	2/7/42	10		1	o	58457377 NEW
190	2,2	1.6	30	8	▲	2/7/42	10		1	L	58457357 NEW
190	2,2	1.6	30	30	▲▲▲	2/7/42	10		1	L	58457546 NEW
210	2,2	1.6	30	12	▲	Combi3	10		1	L	58457358 NEW
216	2,2	1.6	30	12	▲	Combi3	10		1	L	58458137 NEW
250	2,2	1.6	30	40	▲▲▲	Combi3	10		1	o	58458000 NEW
250	2,2	1.6	30	16	▲	Combi3	10		1	L	58457360 NEW
230	2,2	1.6	30	15	▲	Combi3	10		1	L	58457359 NEW
300	2,2	1.6	30	36	▲	Combi3	10		1	L	58457557 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

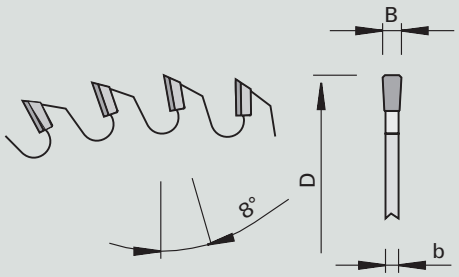
Appropriate **reducing rings** can be found at the end of the chapter

DP HKS - L2

Portable Saw Blades DP - flat tooth with chamfer

Product

Drawing



Machine

Application

Design

2,5 mm

2-0-6

3-0-1

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	2,4	1.8	20	4	▲	2/6/32,5	8		1	O	58458790
180	2,6	2.0	30	4	▲	2/7/42	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	2,8	2.0	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
315	3,0	2.2	30	10	▲▲	Combi3	8		1	O	58458801
350	3,4	2.4	30	12	▲▲	Combi3	8		1	O	58458802
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

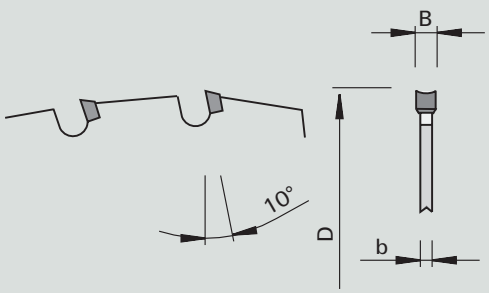
Appropriate **reducing rings** can be found at the end of the chapter

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	▲▲▲	2/6/32,5	10		1	L	58459771
160	2,2	1.8	20	30	▲▲▲	2/6/32,5	10		1	L	58459767
190	2,5	2.0	30	36	▲▲▲		10		1	S	58459768
216	2,5	2.0	30	40	▲▲▲		10		1	L	58459769
230	2,5	2.0	30	44	▲▲▲		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

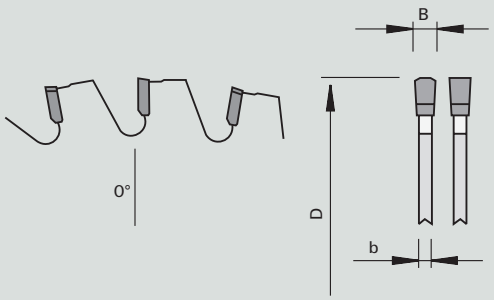
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58116502
160	2,2	1.6	20	30	▲▲	2/6/32,5	0		1	L	58116504
180	2,2	1.6	20	36	▲▲	2/6/32,5	0		1	L	58116507
180	2,2	1.6	30	36	▲▲	2/7/42	0		1	L	58116508
190	2,4	1.8	20	38	▲▲	2/6/32,5	0		1	L	58116509
190	2,4	1.8	30	38	▲▲	Combi3	0		1	L	58116510
210	2,4	1.8	30	40	▲▲	2/7/42	0		1	L	58116512
216	2,4	1.8	30	40	▲▲	2/7/42	0		1	L	58116520
230	2,4	1.8	30	44	▲▲	2/7/42	0		1	L	58116514
235	2,4	1.8	30	44	▲▲	2/7/42	0		1	L	58116521
240	2,4	1.8	30	44	▲▲	Combi3	0		1	L	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

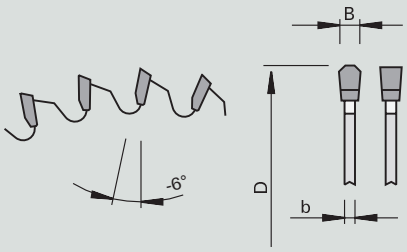
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58115002
160	2,2	1.6	20	42	▲▲	2/6/32,5	-6		1	L	58115004
160	2,2	1.6	20	56	▲▲▲	2/6/32,5	-6		1	L	58115042
160	2,8	2.2	30	42	▲▲	2/7/42	-6		1	L	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	L	58115007
180	2,8	2.2	30	48	▲▲	2/7/42	-6		1	L	58115008
190	2,8	2.2	20	54	▲▲	2/6/32,5	-6		1	L	58115009
190	2,6	2.0	20FX	58	▲▲	Fast-Fix	-6		1	L	58115033
190	2,8	2.2	30	54	▲▲	2/7/42	-6		1	L	58115010
200	2,8	2.2	30	54	▲▲	2/7/42	-6		1	L	58115011
210	2,8	2.2	30	54	▲▲	2/7/42	-6		1	L	58115012
216	2,8	2.2	30	60	▲▲	2/7/42	-6		1	L	58115024
216	2,8	2.2	30	80	▲▲▲	2/7/42	-6		1	L	58115034
220	2,8	2.2	30	54	▲▲	2/7/42	-6		1	L	58115021
225	2,8	2.2	30	60	▲▲	Combi3	-6		1	L	58115039
230	2,8	2.2	30	64	▲▲	2/7/42	-6		1	L	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

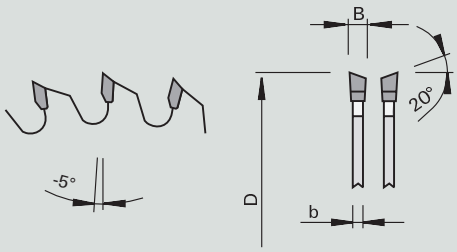
Appropriate **reducing rings** can be found at the end of the chapter

HW 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	L	58110194
216	2,8	1.8	30	24	▲	2/7/42	-5		1	L	58110180
216	2,8	1.8	30	48	▲▲	2/7/42	-5		1	L	58110181
216	2,8	1.8	30	60	▲▲▲	2/7/42	-5		1	L	58110192
254	3,2	2.2	30	24	▲▲	Combi3	-5		1	L	58118119
254	3,2	2.2	30	40	▲▲	Combi3	-5		1	L	58100218
254	3,2	2.2	30	60	▲▲▲	Combi3	-5		1	L	58100231
254	3,2	2.2	30	80	▲▲▲	Combi3	-5		1	L	58110139
260	2,5	1.8	30	60	▲▲	Combi3	-5		1	L	58100233
260	2,5	1.8	30	80	▲▲▲	Combi3	-5		1	L	58100234
300	3,2	2.2	40	72	▲▲▲	4/12/64 + 2/9/55	-5		1	L	58100237
305	3,2	2.2	30	60	▲▲	Combi3	-5		1	L	58110281
305	3,2	2.2	30	32	▲	Combi3	-5		1	L	58110270
305	3,2	2.2	30	96	▲▲▲	Combi3	-5		1	L	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	L	58110273
355	3,5	2.5	30	96	▲▲▲	Combi3	-5		1	L	58110143
420	3,5	2.5	40	84	▲▲	4/12/64 + 2/9/55	-5		1	L	58110144
420	4,4	2.8	40	54	▲▲	4/12/64 + 2/9/55	-5		1	L	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

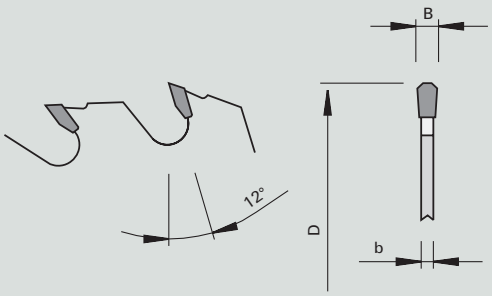
Appropriate **reducing rings** can be found at the end of the chapter

HW BKS (nail proof)

Construction Saw Blades HW - flat with two-sided chamfer

Product

Drawing



Machine

Application

Design

2-0-6

HW
TC20

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 TC20

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	L	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	L	58112015
250	3,2	2.2	30	16	▲	Combi3	12		1	L	58120220
300	3,2	2.2	30	20	▲	Combi3	12		1	L	58120041
315	3,2	2.2	30	20	▲	Combi3	12		1	L	58120046
350	3,5	2.5	30	24	▲	Combi3	12		1	L	58120042
400	3,5	2.5	30	28	▲	Combi3	12		1	L	58120043
450	3,8	2.8	30	30	▲	Combi3	12		1	L	58120044
500	3,8	2.8	30	34	▲	Combi3	12		1	L	58120045
600	4,4	3.2	30	36	▲	Combi3	12		1	L	58120227
700	4,6	3.2	30	42	▲	Combi3	12		1	L	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

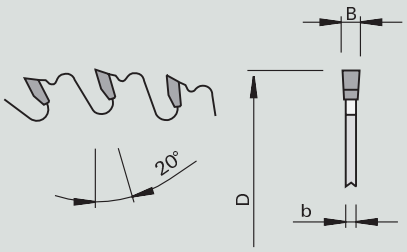
Appropriate **reducing rings** can be found at the end of the chapter

HW BKS (Gasbeton)

Trimming Saw Blades HW - flat tooth

Product

Drawing



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

Machine / Application

- table saws
- special machines
- For trimming cuts in solid wood
- Particularly suited for gas concrete blocks

Design

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

Advantages

- This circular saw blade is suitable for many fields of application
- Ideally suited for gas concrete blocks/gypsum fiber boards and similar workpiece materials

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.
270	3,0	2.0	30	18	▲▲	Combi3	20		1	0	58114170

* **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

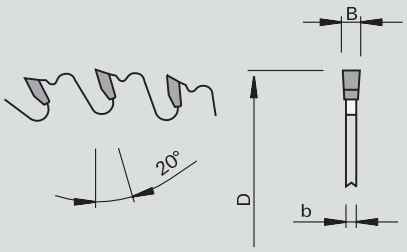
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58104050
300	3,2	2.2	30	14	▲	Combi3		20		1	L	58104006
315	3,2	2.2	30	14	▲	Combi3		20		1	L	58104055
350	3,5	2.5	30	16	▲	Combi3		20		1	L	58104015
350	3,5	2.5	30	24	▲	Combi3		20		1	L	58104041
400	3,5	2.5	30	18	▲	Combi3		20		1	L	58104021
450	3,8	2.8	30	32	▲	Combi3		20		1	L	58104051
500	3,8	2.8	30	36	▲	Combi3		20		1	L	58104052
550	4,6	3.2	30	32	▲	Combi3		20		1	L	58104054
600	4,2	3.2	30	40	▲	Combi3		20		1	L	58104048
700	4,2	3.2	30	46	▲	Combi3		20		1	L	58104049
700	6,0	4.5	30	42	▲		AMR	20		1	L	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

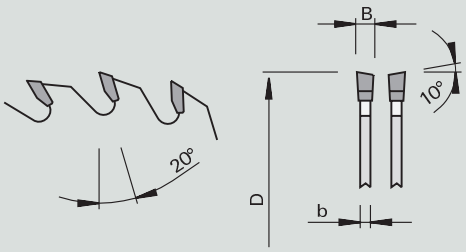
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58100183

* **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

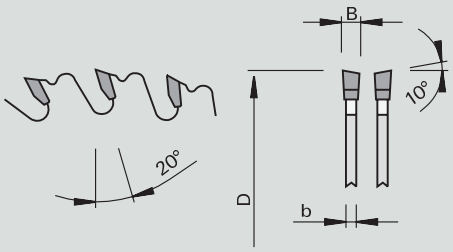
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58102001
300	3,2	2.2	30	28	▲	Combi3	20		1	L	58102002
315	3,2	2.2	30	28	▲	Combi3	20		1	L	58102003
350	3,5	2.5	30	32	▲	Combi3	20		1	L	58101004
400	3,5	2.5	30	36	▲	Combi3	20		1	L	58101005
450	4,2	2.8	30	20	▲	Combi3	25		1	L	58101020
450	3,8	2.8	30	40	▲	Combi3	20		1	L	58101006
500	3,8	2.8	30	44	▲	Combi3	20		1	L	58102007
600	4,2	3.2	30	54	▲	Combi3	20		1	L	58101018
700	4,2	3.2	30	60	▲	Combi3	20		1	L	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

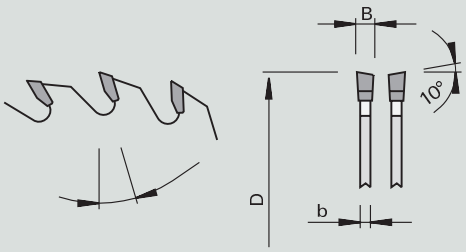
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58100096
180	3,2	2.2	30	30	▲▲	2/7/42		15		1	L	58100016
200	3,2	2.2	30	34	▲▲	2/7/42		15		1	L	58100017
235	2,8	1.8	30	18	▲	2/7/42		20		1	L	50110256
235	2,8	1.8	30	24	▲▲	2/7/42		15		1	L	50110170
235	3,2	2.2	30	24	▲	Combi3		10		1	L	58100191
240	2,8	1.8	30	24	▲▲	2/7/42		20		1	L	50110174
250	2,8	1.8	30	40	▲▲	Combi3		15		1	L	58120020
250	3,2	2.2	30	24	▲▲	Combi3		20		1	L	58120060
250	3,2	2.2	30	30	▲▲	Combi3		20		1	L	58120061
254	2,4	1.8	30	24	▲▲	Combi3	Festool	20		1	L	58120071 NEW
254	2,4	1.8	30	40	▲▲	Combi3	Festool	15		1	L	58120072 NEW
260	3,2	2.2	30	32	▲▲	Combi3		20		1	L	58110185
270	3,2	2.2	30	24	▲▲	Combi3		20		1	L	58110176
300	3,2	2.2	30	24	▲	Combi3		20		1	L	58120002
300	3,2	2.2	30	36	▲	Combi3		20		1	L	58120013
315	3,2	2.2	30	28	▲	Combi3		20		1	L	58120062
315	3,2	2.2	30	36	▲	Combi3		20		1	L	58100255
330	3,2	2.2	30	24	▲	Combi3		25		1	L	58120018
335	3,2	2.2	30	36	▲	Combi3		20		1	L	58120063
350	3,5	2.5	30	24	▲	Combi3		20		1	L	58120005
350	3,5	2.5	30	32	▲▲	Combi3		20		1	L	58100011
350	3,5	2.5	30	36	▲	Combi3		20		1	L	58120014
350	3,5	2.5	30	42	▲	Combi3		20		1	L	58120015
400	3,5	2.5	30	28	▲	Combi3		20		1	L	58100005
400	3,5	2.5	30	32	▲	Combi3		20		1	L	58120008
400	3,5	2.5	30	36	▲▲	Combi3		20		1	L	58100012
400	3,5	2.5	30	48	▲▲	Combi3		20		1	L	58120017
450	3,8	2.8	30	40	▲▲	Combi3		20		1	L	58100013
500	3,8	2.8	30	44	▲▲	Combi3		20		1	L	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

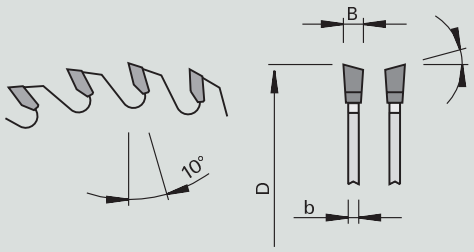
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58100099
150	3,2	2.2	30	48	▲▲▲	2/7/42		10		1	L	58100101
180	3,2	2.2	30	54	▲▲▲	2/7/42		10		1	L	58100015
200	3,2	2.2	30	48	▲▲▲	2/7/42		10		1	L	58100091
200	3,2	2.2	30	64	▲▲▲	2/7/42		10		1	L	58100025
235	2,8	1.8	30	36	▲▲▲	2/7/42		15		1	L	50110117
235	2,8	1.8	30	48	▲▲▲▲	2/7/42		15		1	L	58110121
235	2,8	1.8	30	64	▲▲▲▲	2/7/42		10		1	L	58110118
235	3,2	2.2	30	34	▲▲			10		1	O	50100193
240	2,8	1.8	30	36	▲▲▲	2/7/42		15		1	L	50110123
240	2,8	1.8	30	48	▲▲▲▲	2/7/42		15		1	L	50110124
250	3,2	2.2	30	40	▲▲▲	Combi3		10		1	L	58100018
250	3,2	2.2	30	48	▲▲▲▲	Combi3		10		1	L	58100026
250	3,2	2.2	30	60	▲▲▲▲	Combi3		10		1	L	58100031
250	3,2	2.2	30	80	▲▲▲▲	Combi3		10		1	L	58100038
254	2,4	1.8	30	60	▲▲▲	Combi3	Festool	5		1	L	58120073 NEW
254	3,0	2.2	20/30	40	▲▲▲			10		1	L	58114108
254	3,2	2.2	30	40	▲▲▲	Combi3		10		1	L	58120067
254	3,2	2.2	30	60	▲▲▲▲	Combi3		10		1	L	58120068
260	3,2	2.2	30	40	▲▲▲	Combi3		10		1	L	58110175
260	3,2	2.2	30	60	▲▲▲▲	Combi3		10		1	L	58100254
270	3,2	2.2	30	60	▲▲▲▲	Combi3		10		1	L	58110182
280	3,2	2.2	30	48	▲▲▲▲	Combi3		10		1	L	58110136
300	3,2	2.2	30	48	▲	Combi3		10		1	L	58100250
300	3,2	2.2	30	60	▲▲	Combi3		10		1	L	58100027
300	3,2	2.2	30	72	▲▲	Combi3		10		1	L	58100032
300	3,2	2.2	30	96	▲▲▲	Combi3		10		1	L	58100251
305	3,2	2.2	30	48	▲	Combi3		10		1	L	58120065
305	3,2	2.2	30	60	▲▲	Combi3		10		1	L	58120066
315	3,2	2.2	30	48	▲	Combi3		10		1	L	58100252
315	3,2	2.2	30	60	▲▲	Combi3		10		1	L	58100253
350	3,5	2.5	30	54	▲▲	Combi3		10		1	L	58100021
350	3,5	2.5	30	72	▲▲	Combi3		10		1	L	58100028
350	3,5	2.5	30	84	▲▲	Combi3		10		1	L	58100033
350	3,5	2.5	30	108	▲▲▲	Combi3		10		1	L	58100040
400	3,5	2.5	30	60	▲▲	Combi3		10		1	L	58100022
400	3,5	2.5	30	84	▲▲▲	Combi3		10		1	L	58100029
400	3,5	2.5	30	96	▲▲▲	Combi3		10		1	L	58100034
400	3,5	2.5	30	120	▲▲▲	Combi3		10		1	L	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

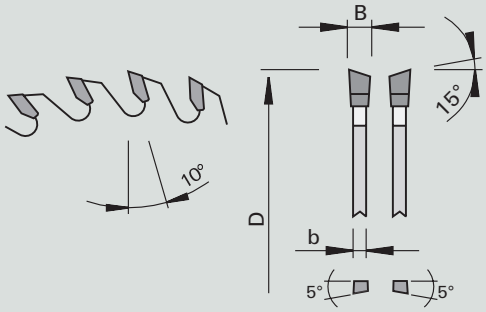
Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
450	3,8	2.8	30	66	▲▲	Combi3	10		1	L	58100023
450	3,8	2.8	30	108	▲▲▲	Combi3	10		1	L	58100060
500	3,8	2.8	30	72	▲▲	Combi3	10		1	L	58100024
550	4,0	3.0	30	64	▲	Combi3	10		1	L	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	60	▲▲▲	Combi3	10		1	L	58100701
300	3,2	2.2	30	48	▲▲	Combi3	10		1	L	58100702
300	3,2	2.2	30	96	▲▲▲▲	Combi3	10		1	L	58100703
350	3,5	2.5	30	54	▲▲	Combi3	10		1	L	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

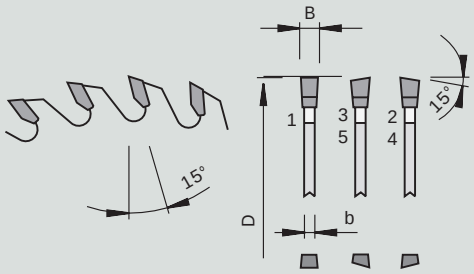
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58808701
200	3,0	2.2	30	65	▲▲▲▲			15		1	L	58808702
216	3,0	2.2	30	60	▲▲▲▲	Combi3	Bosch 635-216	15		1	L	58808714 NEW
220	3,0	2.2	30	70	▲▲▲▲	8/6/52		15		1	L	58808712
220	3,0	2.2	40	70	▲▲▲▲	8/6/52		15		1	L	58808703
240	3,0	2.2	30	75	▲▲▲▲			15		1	L	192791
250	3,0	2.2	30	80	▲▲▲▲	Combi3		15		1	L	58808706
280	3,0	2.2	30	85	▲▲▲▲	Combi3		15		1	L	58808705
300	3,0	2.2	30	100	▲▲▲▲	Combi3		15		1	L	58808708
300	4,0	3.2	30	100	▲▲▲▲	Combi3	Fimal	15		1	L	58808713
303	3,2	2.2	30	100	▲▲▲▲	Combi3		15		1	L	58808707
350	3,0	2.2	30	100	▲▲▲▲	Combi3		15		1	L	58808709
500	3,6	2.8	30	145	▲▲▲▲	Combi3		15		1	L	58808710
550	4,0	3.2	30	160	▲▲▲▲	Combi3		15		1	L	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

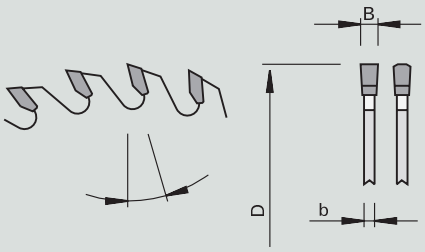
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58104063
160	2,2	1.6	20	48	▲▲	2/7/32		5		1	L	58110161
160	2,2	1.6	20	56	▲▲▲	2/7/32		5		1	L	58110142
190	2,2	1.6	30	56	▲▲▲			5		1	L	58458779
190	2,6	2.0	20FX	54	▲▲▲	Fast-Fix		5		1	L	58110229
216	3,2	2.2	30	60	▲▲▲			5		1	L	58458780
220	3,2	2.2	30	64	▲▲▲	2/7/42		5		1	L	58100399
232	3,2	2.2	30	64	▲▲▲			5		1	#	58458781
250	3,2	2.2	30	60	▲▲	Combi3		5		1	L	58100385
250	3,2	2.2	30	80	▲▲▲	Combi3		5		1	L	58100386
254	2,4	1.8	30	80	▲▲▲	Combi3	Festool	5		1	L	58100402 NEW
300	3,2	2.2	30	72	▲▲	Combi3		5		1	L	58100387
300	3,2	2.2	30	96	▲▲▲	Combi3		5		1	L	58100388
350	3,5	2.5	30	72	▲▲	Combi3		10		1	L	58100300
350	3,5	2.5	30	108	▲▲▲	Combi3		10		1	L	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

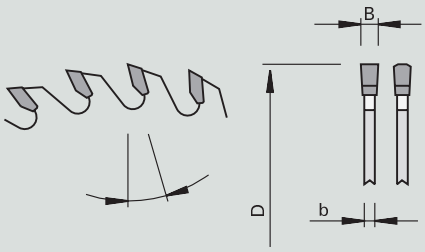
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58803823
300	3,2	2.2	30	96	▲▲▲	Combi3	5	●	1	L	58458788
350	3,5	2.5	30	72	▲▲	Combi3	10	●	1	L	58807830
350	3,5	2.5	30	108	▲▲▲	Combi3	10	●	1	L	58807831

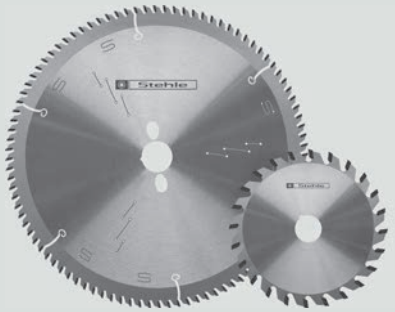
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut

** **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.
3 piece saw blade set in wood box			●	1	L	50804303
Accessories	**Dimension [mm]**			**PU [pc.]**	**L**	**Order-No.**
main saw blade	300x3,2x2,2x30 Z=72 TR-F		●	1	L	58100387
scoring saw blade	125x3,35x2,4x22 Z=24 WS		●	1	L	50806200
Reducing Rings	22x2,0x20		●	1	L	161887

Product features			Order information			
				PU [pc.]	L	Order-No.
3 piece saw blade set in wood box			●	1	L	58804305
Accessories	**Dimension [mm]**			**PU [pc.]**	**L**	**Order-No.**
main saw blade	300x3,2x2,2x30 Z=72 TR-F		●	1	L	58100387
scoring saw blade	120x3,35x2,4x22 Z=24 WS		●	1	S	58806209
Reducing Rings	22x2,0x20		●	1	L	161887

Product features			Order information			
				PU [pc.]	L	Order-No.
3 piece saw blade set in wood box		Altendorf	●	1	L	58804304
Accessories	**Dimension [mm]**			**PU [pc.]**	**L**	**Order-No.**
main saw blade	350x3,5x2,4x30 Z=72 TR-F		●	1	L	58807830
scoring saw blade	180x3,6x2,4x22 Z=36 F		●	1	L	58806210

* **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

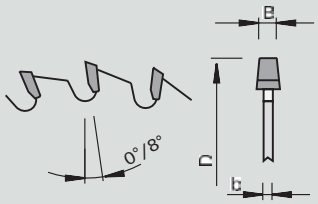
Appropriate **reducing rings** can be found at the end of the chapter

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

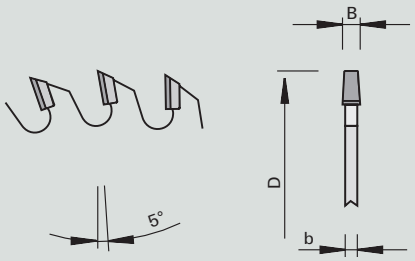
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	Hook angle [°]			PU [pc.]	L	Order-No.
100	3,2-4,0	2.5	20	20	▲▲▲▲	8	Schelling	●	1	L	58807950
120	3,2-4,0	2.5	20	24	▲▲▲▲	8	Altendorf, SCM	●	1	L	58807951
120	3,2-4,0	2.5	22	24	▲▲▲▲	8	Altendorf, Martin	●	1	L	58807952
125	3,1-4,0	2.5	20	24	▲▲▲▲	8	Panhans,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

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

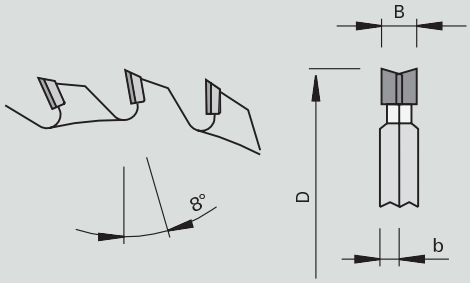
Product features / **Order information**

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

DP RSVS
Scoring Saw Blades DP - adjustable alternate bevel

Product

Drawing



Machine

Application

Design

3-0-1

WS

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

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	S	50750102
120	2,8-3,8	2.2	50	2x12	▲▲▲▲	4/6,2/62	8	Altendorf adjustment unit	●	1	S	50750105

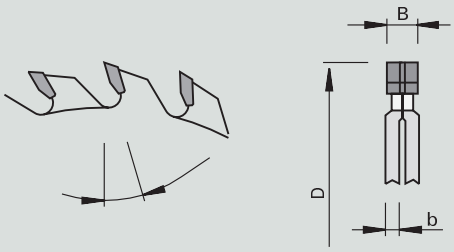
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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	L	58802435
100	2,8-3,6	2.2	20	2x10	▲▲▲▲	12	●	1	L	58110190
100	2,8-3,6	2.2	22	2x10	▲▲▲▲	12	●	1	L	58110188
105	2,8-3,6	2.2	20	2x10	▲▲▲▲	12	●	1	L	58110171
120	2,8-3,6	2.2	20	2x12	▲▲▲▲	12	●	1	L	58110186
120	2,8-3,6	2.2	22	2x12	▲▲▲▲	12	●	1	L	58110187
125	2,8-3,6	2.2	20	2x12	▲▲▲▲	12	●	1	L	58110206
125	2,8-3,6	2.2	22	2x12	▲▲▲▲	12	●	1	L	58110204

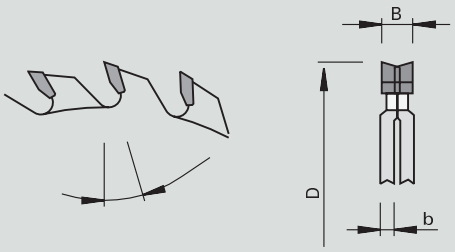
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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	L	50807854
120	2,8-3,8	2.2	50	2x12	▲▲▲▲	12		Altendorf, Martin	●	1	L	50807902
140	2,8-3,6	2.0	36	2x12	▲▲▲▲	12		Martin T75 PreX	●	1	L	193258

Spare parts	Dimension [mm]			PU [pc.]	L	Order-No.
Countersunk Screws - with Torx	M5x6,8 T15 D=Ø9,4	mounting screw for interior flange		10	L	180839
Countersunk Screws - with Torx	M5x10,8 T15 D=Ø9,4	mounting screw for exterior flange		10	L	180840

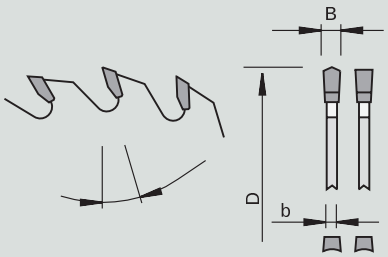
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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

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	L	58804352
303	3,2	2.2	30	60	▲▲▲▲	Combi3	-5		1	L	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

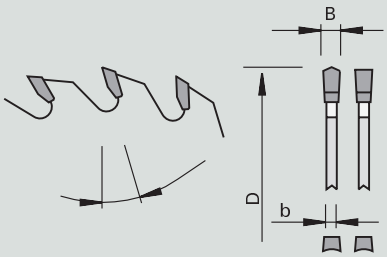
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58804281
250	3,2	2.2	30	48	▲▲	Combi3	10		1	L	58804351
303	3,2	2.2	30	60	▲▲▲▲	Combi3	10		1	L	58804353
350	3,5	2.5	30	72	▲▲▲▲	Combi3	10		1	L	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

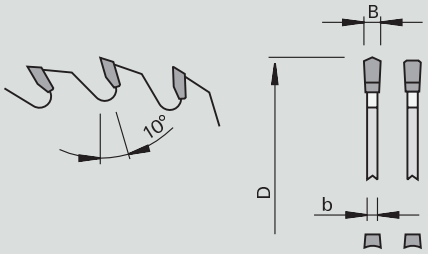
Appropriate **reducing rings** can be found at the end of the chapter

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	L	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

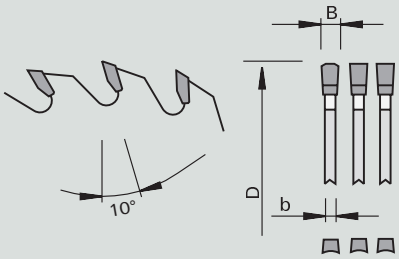
Appropriate **reducing rings** can be found at the end of the chapter

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	L	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

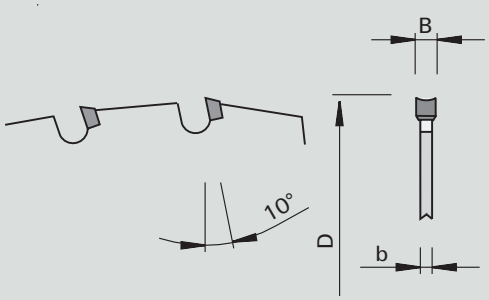
Appropriate **reducing rings** can be found at the end of the chapter

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 + 8/5,2/90	10		1	L	58459455 NEW
303	2,5	2.0	30	60	▲▲▲	Combi2 + 8/5,2/90	10		1	L	58459439 NEW
350	2,5	2.0	30	72	▲▲▲	Combi2 + 8/5,2/90	10		1	L	58459446 NEW

Accessories	Ø D [mm]	B [mm]						PU [pc.]	L	
Splitting wedge	300-350	2,25	Altendorf F45					1	L	192425
Splitting wedge	240-250	2,25	HOLZ-HER Vertikal					1	L	192429
Splitting wedge	300-350	2,25	Striebig Standard III Control Evolution					1	L	192430
Splitting wedge	300-350	2,25	Striebig Standard Eco					1	L	192431
Splitting wedge	300	2,25	Putsch					1	L	192457
Splitting wedge	250-350	2,25	Martin T60A					1	L	192535
Splitting wedge	303	2,2	Elcon					1	S	80384841
Splitting wedge	300-350	2,2	SCM Standard					1	S	192465
Splitting wedge	290-303	2,2	Striebig Typ 5220A					1	S	80348633
Splitting wedge	250-315	2,2	Fleder					1	S	80355169
Splitting wedge	250-315	2,2	Felder Format4					1	S	9208146
Splitting wedge	300-350	2,23	Griggio E3200					1	S	80450295
Splitting wedge	350	2,2	SCM SI3200					1	S	80362574
Splitting wedge	303	2,2	Holz-Her Supercut					1	S	80351444
Splitting wedge	250-315	2,2	SCM SC3W					1	S	80351127

* **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

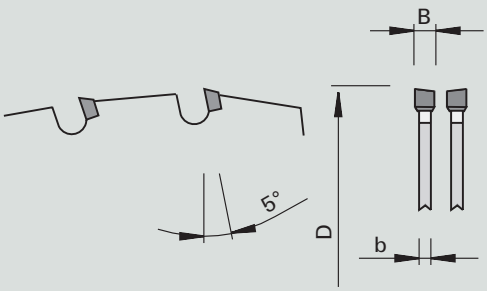
Appropriate **reducing rings** can be found at the end of the chapter

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	▲▲▲▲	8		1	L	192448
120	2,6	2.0	22	24	▲▲▲▲	8		1	L	192447
125	2,6	2.0	20	24	▲▲▲▲	8		1	L	192449
180	2,6	2.0	22	36	▲▲▲▲	8		1	L	192964

* **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

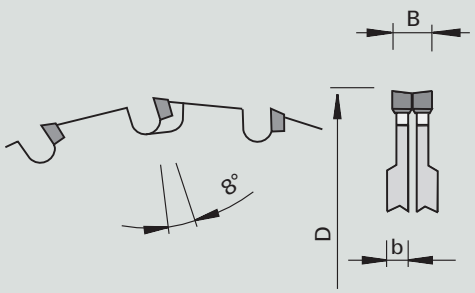
Appropriate **reducing rings** can be found at the end of the chapter

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	L	192452

* **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

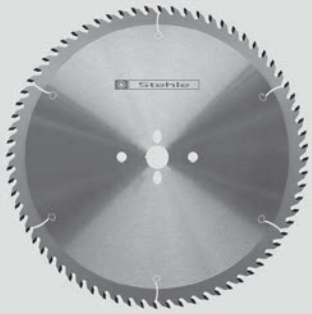
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

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

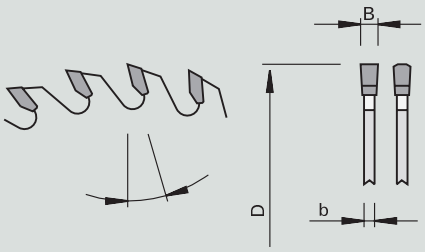
HW TFP

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	L	58806053
320	4,4	3.2	65	72	▲▲▲	3/13/95 + 2/14/110	15	Holzma	●	1	L	58807818 NEW
350	4,4	3.0	30	72	▲▲▲	Combi3 + 2/13/94	10	SCM, Panhans, Mayer, Schelling, HOLZ-HER	●	1	L	58807803
350	4,4	3.2	60	72	▲▲▲	Combi7	10	Holzma 72 HPP 350	●	1	L	58807955
355	4,4	3.0	75	72	▲▲▲	4/15/105	10	Gibben	●	1	L	58807888
380	4,4	3.2	60	72	▲▲▲	Combi7	15	Holzma	●	1	L	58807819 NEW
380	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1	L	58806065
400	4,4	3.2	30	72	▲▲▲	Combi3 + 2/13/94	15	Schelling, Mayer, Irion, Scheer, HOLZ-HER	●	1	L	58806069
400	4,4	3.2	75	72	▲▲▲	4/15/105 + 2/7/110	15	Giben, Homag	●	1	L	58806071
400	4,4	3.2	80	72	▲▲▲	Combi5	15	Selco, Irion	●	1	L	58807809
420	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1	L	58807956
430	4,4	3.2	80	72	▲▲▲	Combi5	15	Selco	●	1	L	58806479
450	4,4	3.2	30	72	▲▲	Combi3 + 2/13/94	15	Irion, Schelling	●	1	L	58458789
450	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1	L	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

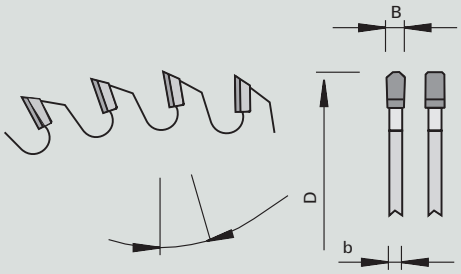
Appropriate **reducing rings** can be found at the end of the chapter

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	S	50750120
350	4,4	3.2	30	72	▲▲▲	Combi3	10	SCM, Panhans, Mayer, Schelling, Scheer	●	1	S	50750128
350	4,4	3.0	60	72	▲▲▲	Combi7	10	SCM, Panhans, Mayer, Schelling, Scheer	●	1	S	50750129
380	4,4	3.2	60	72	▲▲▲	2/14/100 + 2/14/125	10	Holzma	●	1	S	50750130
380	4,8	3.5	60	72	▲▲▲	2/14/100 + 2/14/125	10	Holzma	●	1	S	50750131
400	4,4	3.2	30	72	▲▲▲	Combi3 + 3/13/94	15	Schelling, Mayer, Scheer, Irion	●	1	S	50750132
400	4,4	3.2	75	72	▲▲▲	4/15/105 + 2/7/110	15	Giben, Homag	●	1	S	50750133
400	4,4	3.2	80	72	▲▲▲	Combi5	15	Schelling, Mayer, Scheer, Irion	●	1	S	50750134
420	4,8	3.5	60	60	▲▲	2/10/80 + 2/14/125	15	Holzma	●	1	S	50750135
450	4,8	3.5	60	72	▲▲▲	Combi7	15	Holzma	●	1	S	50750136
450	4,8	3.5	80	72	▲▲▲	4/19/120 + 2/8,4/130	15	Selco	●	1	S	50750137
450	4,4	3.2	30	72	▲▲▲		15	Selco	●	1	S	50750138
460	4,4	3.2	30	72	▲▲▲	3/13/94	15	Schelling	●	1	S	50750146
480	4,8	3.5	30	72	▲▲▲	2/10/60 + 2/13/94	15	Schelling	●	1	S	50750139
480	4,8	3.5	60	72	▲▲▲	2/19/120	15	Holzma	●	1	S	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

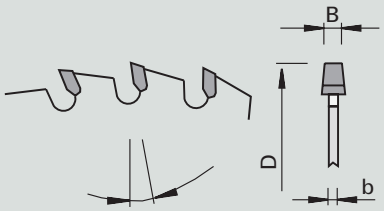
Appropriate **reducing rings** can be found at the end of the chapter

HW RSK - nn-System

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

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

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 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 = 0.2 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.
125	3,1-4,0	2.5	22	24	▲▲▲▲		8	Altendorf, Martin	●	1	58807954
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

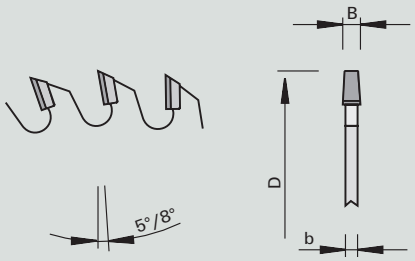
Appropriate **reducing rings** can be found at the end of the chapter

DP RSK

Scoring Saw Blades DP - conical-flat

Product

Drawing



Machine

Application

Design

4,5 mm

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	S	50750121
180	4,4-5,2	3.2	30	30	▲▲▲▲	2/10/60	5	Panhans	●	1	S	50750122
180	4,4-5,2	3.2	45	30	▲▲▲▲		5	Holzma	●	1	S	50750123
180	4,8-5,6	3.5	45	30	▲▲▲▲		5	Holzma	●	1	S	50750124
200	4,4-5,2	3.2	20	30	▲▲▲▲		5	Schelling	●	1	S	50750125
200	4,4-5,2	3.2	20	36	▲▲▲▲		8	Schelling	●	1	S	50750147
200	4,8-5,6	3.5	65	30	▲▲▲▲	2/8,4/110	5	Selco	●	1	S	50750126
200	4,8-5,6	3.5	45	30	▲▲▲▲		5	Holzma	●	1	S	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

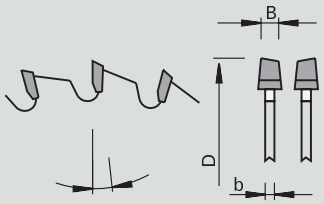
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58807970
300	4,45-5,25	3.2	30	48	▲▲▲	8	1	L	192751 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

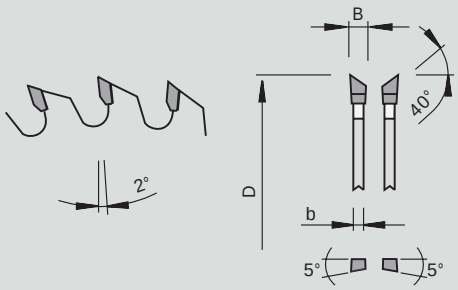
Appropriate **reducing rings** can be found at the end of the chapter

HW OKW

Optimizing Chop Saw Blades HW - alternate top bevel / shear angle

Product

Drawing



Machine

Application

Design

3-0-1

HW
TC06

WSA

Machine / Application

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

Design

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

Advantages

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

Notes

- other dimensions on request

Product features / **Order information**

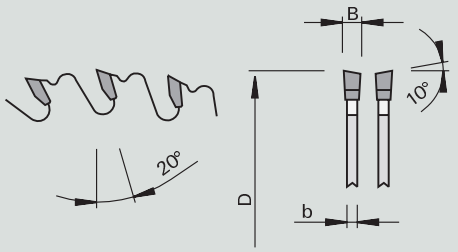
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
400	3,4	2.8	30	120	▲▲▲	2/10/60 + 2/12/90 + 2/12/150	2	●	1	L	58807839 NEW
400	4,6	3.5	30	120	▲▲▲	2/10/60	2	●	1	L	189833 NEW
450	4,6	3.5	30	132	▲▲▲	2/15/63	2	●	1	L	189834 NEW
500	4,6	3.5	30	144	▲▲▲	2/15/63	2	●	1	L	58807842 NEW

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	L	50804422
400	4,2	3.0	30	28	▲	Combi2	2+2	●	1	L	50804423
450	4,2	3.0	30	36	▲	Combi2	2+2	●	1	L	50804425

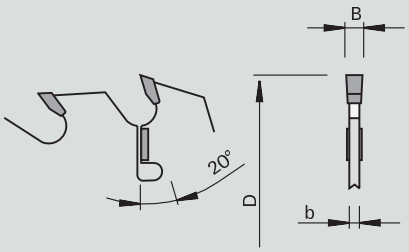
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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
TC20

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 TC20

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	Ø dmax [mm]	Max. flange Ø [mm]	Cutting quality*	DKN [mm]	Number of rakers [pc.]	PU [pc.]	L	Order-No.
250	3,2	2.2	70	20	80	120	▲	2 x 20x5	2+2	1	L	50457841
300	3,4	2.2	70	22	90	130	▲	2 x 20x5	2+2	1	L	50100525
350	3,6	2.5	70	20	100	140	▲	2 x 20x5	2+2	1	L	50100528
350	3,6	2.4	70	28	100	140	▲	2 x 20x5	2+2	1	L	50457843
450	4,2	3.0	50	24	100	160	▲		2+2	1	L	189273 NEW

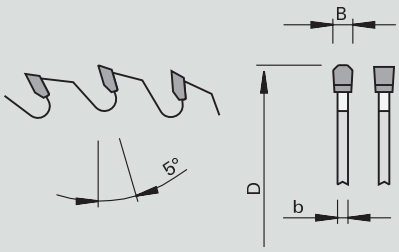
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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 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 2-0-6 until Ø 349
- quality 3-0-1 from Ø 350
- cutting material: HW TC10 until Ø 349
- cutting material: HW TC06 until Ø 350

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	L	58808102
300	3,2	2.5	30	72	▲▲	Combi3	5	TC10		1	L	58808104
300	3,2	2.5	30	96	▲▲▲	Combi3	5	TC10		1	L	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	L	58808111
400	3,8	3.2	30	96	▲▲	Combi3	5	TC06		1	L	58808113
420	3,8	3.2	30	96	▲▲	Combi3	5	TC06		1	L	58808115
500	4,0	3.4	30	120	▲▲▲	4/12/64 +2/10/60	5	TC06		1	L	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

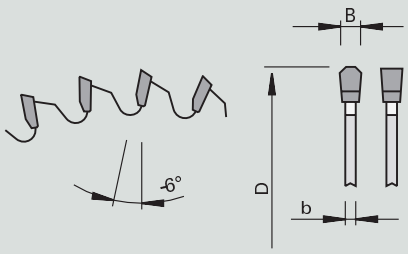
Appropriate **reducing rings** can be found at the end of the chapter

HW NF - negative

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

Product

Drawing



Machine

Application

Design

2-0-6

3-0-1

HW **TC06**

HW **TC10**

TR-F

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 2-0-6 until Ø 349
- quality 3-0-1 from Ø 350
- cutting material: HW TC10 until Ø 349
- cutting material: HW TC06 until Ø 350

Advantages

- noise-reduction thanks to laser ornaments

Notes

Product features / Order information

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**		Hook angle [°]		PU [pc.]	L	Order-No.
235	2,8	2.2	30	64	▲▲	2/7/42		-6		1	L	58115018
250	3,2	2.5	30	60	▲▲	Combi3		-6		1	L	58808201
250	2,8	2.2	30	80	▲▲▲	Combi3		-6		1	L	58808200
250	3,2	2.5	30	80	▲▲▲	Combi3		-6		1	L	58808203
250	3,2	2.5	32	80	▲▲▲	Combi3		-6		1	L	58808204
250	3,2	2.5	40	80	▲▲▲	4/12/64 + 2/9/55 + Combi3		-6		1	O	58808205
254	2,4	1.8	30	60	▲▲	Combi3	Festool	-6		1	L	58808240
254	3,2	2.5	30	80	▲▲▲	Combi3		-6		1	L	58808246
260	2,4	1.8	30	80	▲▲▲	Combi3		-6		1	L	58808260
260	3,2	2.5	30	72	▲▲	Combi3		-6		1	L	58808206
280	3,2	2.5	30	64	▲▲▲	Combi3		-6		1	L	58808261
300	3,2	2.5	30	72	▲▲	Combi3		-6		1	L	58808209
300	2,8	2.2	30	96	▲▲▲	Combi3		-6		1	L	58808213
300	3,2	2.5	30	96	▲▲▲	Combi3		-6		1	L	58808214
300	3,2	2.5	32	96	▲▲▲	4/12/64		-6		1	L	58808215
300	3,3	2.5	40	96	▲▲▲	4/12/64 + 2/9/55		-6		1	L	58808216
305	3,2	2.5	30	60	▲▲	Combi3		-6		1	L	58808241
305	3,2	2.5	30	96	▲▲▲	Combi3		-6		1	L	58808245
315	3,2	2.5	30	96	▲▲▲	Combi3		-6		1	L	58808315
330	3,2	2.5	30	96	▲▲▲	Combi3		-6		1	L	58808217
330	3,2	2.5	32	96	▲▲▲	Combi3		-6		1	O	58808218
350	3,2	2.5	30	90	▲▲	Combi3		-6		1	L	58808222
350	3,2	2.5	30	108	▲▲▲	Combi3		-6		1	L	58808225
350	3,2	2.5	32	108	▲▲▲	4/12/64		-6		1	L	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	L	58808243
400	3,8	3.2	30	96	▲▲	Combi3		-6		1	L	58808232
420	4,0	3.2	30	96	▲▲	Combi3		-6		1	L	58808234

* **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

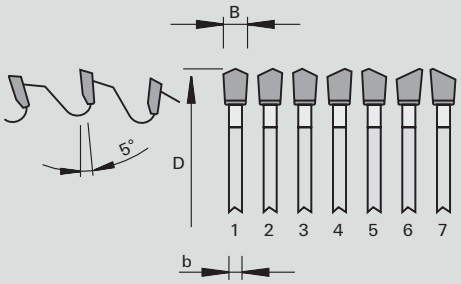
Product features								Order information			
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]		PU [pc.]	L	Order-No.
420	3,8	3.2	40	100	▲▲▲	4/12/64 + 2/9/55	-6		1	L	58808236
450	3,8	3.2	30	96	▲▲	4/12/64 +2/12/80 + Combi3	-6		1	L	58808235
500	4,0	3.4	30	120	▲▲▲	4/12/64 +2/10/60	-6		1	L	58808239

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	L	192663
350	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60	5		1	L	192662
400	3,8	3.2	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/15/80 + 4/12/64	5		1	L	192659
420	3,8	3.2	30	98	▲▲▲▲		5		1	L	192660
500	4,0	3.4	30	126	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/10/70 + 4/12/64	5		1	L	192661

* **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

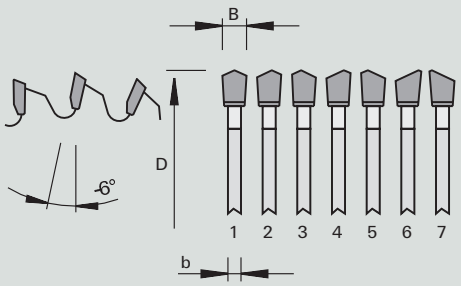
Appropriate **reducing rings** can be found at the end of the chapter

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	L	192965
300	3,2	2.5	30	98	▲▲▲▲	2/7/42 + 2/9/46 + 2/10/60 + 2/11/70	-6			1	L	192568
350	3,2	2.5	30	112	▲▲▲▲	2/7/42 + 2/9/46 + 2/9,5/46,5 + 2/10/60	-6			1	L	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	L	192274
350	3,8	3.2	40	84	▲▲▲▲	4/12/64 + 2/9/55	-6	Eisele LSM II, -LSM II-PV, -VA-L, Graule, Ulmia, Weidmann		1	L	192273
380	3,8	3.2	32	112	▲▲▲▲		-6	Elumatec		1	L	192567
400	3,8	3.2	30	98	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6	DeWALT, Haffner		1	L	58192276
420	4,0	3.2	30	98	▲▲▲▲	2/10/60 + 2/11/70	-6	Rapid, ELU		1	L	192277
450	3,8	3.2	30	112	▲▲▲▲	2/10/60+ 2/12/64+ 4/15/80	-6	DeWALT, Haffner		1	L	58192278
500	4,0	3.4	30	126	▲▲▲▲	2/11/70 + 2/10/60	-6	Pfeiffer, Rapid		1	L	58192279
550	4,0	3.4	30	133	▲▲▲▲	2/10/60 + 2/12/64 + 4/15/80	-6	Pfeiffer, Rapid		1	L	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

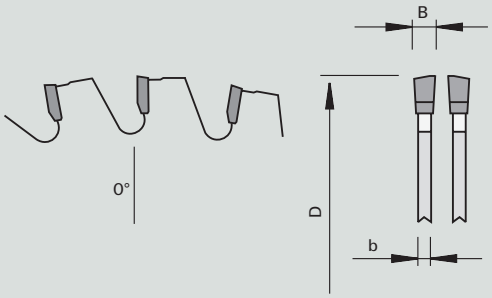
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58165001
260	2,5	1.8	30	60	▲	Combi3	0		1	L	58165010
270	2,6	2.2	30	54	▲▲	Combi3	0		1	L	58116517
305	2,6	2.2	30	60	▲▲	Combi3	0		1	L	58165002
330	2,6	2.2	30	54	▲	Combi3	0		1	L	58165005
355	2,6	2.2	30	80	▲▲	Combi3	0		1	L	58165003
400	2,6	2.2	30	84	▲▲	Combi3	0		1	L	58165004
450	2,6	2.2	30	90	▲▲	Combi3	0		1	L	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

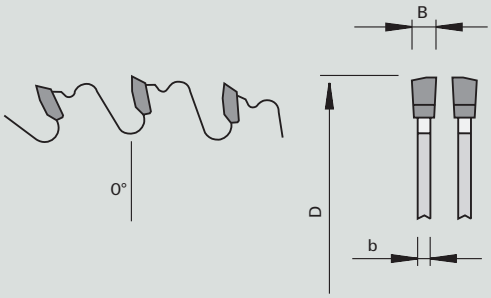
Appropriate **reducing rings** can be found at the end of the chapter

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	L	58805861
305	2,2	1.8	25,4	60	▲▲		0		1	L	58805862
305	2,2	1.8	25,4	80	▲▲		0		1	L	58805863
305	2,2	1.8	30	80	▲▲▲	Combi3	0		1	L	58805864
320	2,2	1.8	25,4	84	▲▲▲		0		1	L	58805859
330	2,2	1.8	30	90	▲▲▲	Combi3	0		1	L	58805865
355	2,2	1.8	25,4	80	▲▲▲		0		1	L	58805866
355	2,2	1.8	25,4	90	▲▲▲		0		1	L	58805868
355	2,2	1.8	30	90	▲▲▲	Combi3	0		1	L	58805867

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

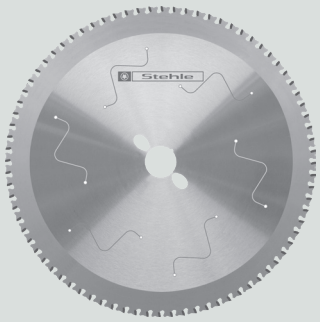
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 2/9/110 + 2/10/80 + 2/11/85 + 2/11/115 + 2/11/148 + 2/14/100 + 2/14/125 + 2/19/120

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

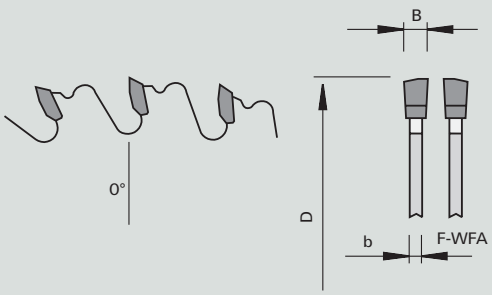
HT Mega-Steel

Chop Saw Blades HT for metal - neutral hook angle

Product



Drawing



Machine

Application

Design

3-0-1

HW
TCx03

F-
WFA

Machine / Application

- dry-cut 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 geometry		PU [pc.]	L	Order-No.
254	2,2	1.8	25,4	72	▲▲		0	F-WFA		1	L	58805870
254	2,2	1.8	30	72	▲▲	Combi3	0	F-WFA		1	L	58805871
305	2,2	1.8	25,4	60	▲▲		0	F-WFA		1	L	50805872
305	2,2	1.8	25,4	80	▲▲▲		0	F-WFA		1	L	50805873
305	2,2	1.8	30	80	▲▲▲	Combi3	0	F-WFA		1	L	50805874
355	2,2	1.8	25,4	80	▲▲▲		0	F-WFA		1	L	50805876
355	2,2	1.8	25,4	90	▲▲▲		0	F-WFA		1	L	50805878
355	2,2	1.8	30	90	▲▲▲	Combi3	0	F-WFA		1	L	50805877

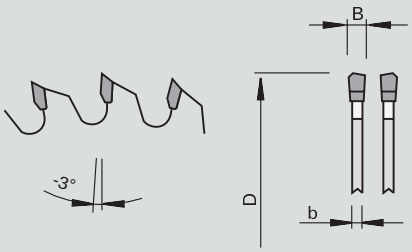
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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

HW **TC06**

HW **TC10**

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	L	58116000
190	2,2	1.6	30	54	▲▲		-3	TC10		1	L	58116001
216	2,8	2.2	30	60	▲▲		-3	TC10		1	L	58116002
250	2,8	2.2	30	80	▲▲▲	Combi3	-3	TC06		1	L	50808500
300	2,8	2.2	30	96	▲▲▲	Combi3	-3	TC06		1	L	50808501
350	2,8	2.2	30	100	▲▲▲	Combi3	-3	TC06		1	L	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

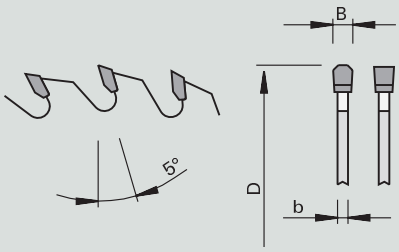
Appropriate **reducing rings** can be found at the end of the chapter

HW KKS - hard plastic positive

Chop Saw Blades HW for extremely hard plastic profiles - triple chip /flat with two-sided chamfer

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

TR-F-FA

Machine / Application

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

Design

- Hook angle: positive
- Tooth configuration: triple chip / flat with two-sided chamfer "TR-F-FA"
- Cutting material: HW TC04 plus

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	L	58808620
300	3,2	2.5	30	96	▲▲▲	Combi3	5		1	L	58808621
350	3,5	2.8	30	108	▲▲▲	Combi3	5		1	L	58808622
400	3,5	2.8	30	108	▲▲▲	Combi3	5		1	L	58808623

* **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

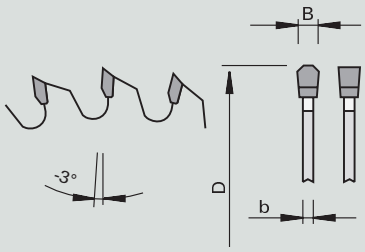
Appropriate **reducing rings** can be found at the end of the chapter

HW KKS - hard plastic negative

Chop Saw Blades HW for extremely hard plastic profiles - triple chip / flat tooth with two-sided chamfer

Product

Drawing



Machine

Application

Design

3-0-1

HW **TC04 plus**

TR-F-FA

Machine / Application

- portable saws
- chop and miter saws
- table 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 TC04 plus

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.	
160	2,2	1.6	20	52	▲▲▲	2/6/32	-3		1	L	58808607	NEW
165	2,2	1.6	20	52	▲▲▲	2/6/32	-3		1	L	58808608	NEW
190	2,6	2.0	20FX	54	▲▲▲	Fast-Fix	-3		1	L	58808604	NEW
190	2,5	1.6	30	54	▲▲▲		-3		1	L	58808609	NEW
210	2,8	1.8	30	54	▲▲▲	2/7/42	-3		1	L	58808610	
216	2,8	1.8	30	60	▲▲▲	2/7/42	-3		1	L	58808611	
232	2,8	1.8	30	64	▲▲▲	2/7/42	-3		1	L	58808616	NEW
254	2,4	1.8	30	80	▲▲▲	Combi3	-3		1	L	58808617	NEW
254	2,8	1.8	30	80	▲▲▲	Combi3	-3		1	L	58808612	
260	2,5	1.8	30	80	▲▲▲	Combi3	-3		1	L	58808613	
305	3,2	2.5	30	96	▲▲▲	Combi3	-3		1	L	58808614	

* **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

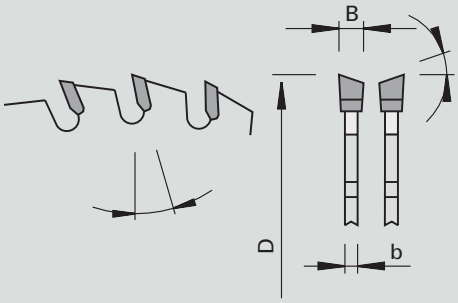
Appropriate **reducing rings** can be found at the end of the chapter

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	L	192471
100	2,4	1.6	22	12	▲		15	10	5	HOLZ-HER		1	L	192472
100	2,4	1.6	22	20	▲▲	2/4/30	-8	10	5	EBM		1	L	58808802
100	3,2	2.2	22	20	▲▲▲		8	15	0	Felder		1	L	192475
100	2,6	1.6	32	30	▲▲		10	15	5	Brandt		1		192476
110	3,6	2.5	22	20	▲▲		8	30	5	HOLZ-HER, Reich		1	L	192477
110	3,6	2.5	32	20	▲▲		8	30	5	Homag		1	L	192478
120	3,2	2.2	32	20	▲▲		10	10	5	Homag		1	L	192483
140	3,2	2.2	16	36	▲▲▲		10	15	5	Ott		1	L	192489
125	2,4	1.6	32	24	▲▲		15	30	0	Brandt		1	L	192900
140	3,2	2.2	22	36	▲▲▲		10	15	5	HOLZ-HER		1	L	192488
150	3,2	2.2	22	48	▲▲▲		10	10	5	IMA		1	L	192493
160	3,2	2.2	20	48	▲▲▲		10	10	5	HOLZ-HER		1	L	192497
160	3,0	2.5	22	36	▲▲▲		-5	15	0	IMA		1	L	192456
160	3,5	2.5	22	36	▲▲▲		-5	15	5	IMA		1	L	188662
160	3,2	2.2	22	48	▲▲▲		-8	10	5	IMA		1	L	192498
160	3,2	2.2	30	24	▲▲	2/7/42	15	10	5	HOLZ-HER		1	L	192495
160	3,2	2.2	40	30	▲▲		-8	20	10	HOLZ-HER		1	L	192496
170	3,2	2.2	30	36	▲▲▲		10	20	0	Homag		1	L	193354
200	3,2	2.2	30	64	▲▲▲		10	15	0	IMA		1	L	192501

* **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

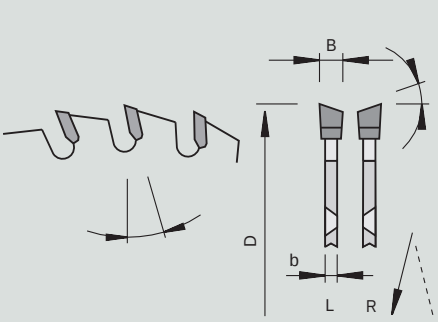
Appropriate **reducing rings** can be found at the end of the chapter

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 VDMA 8849

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	▲▲▲		10	45	5	Homag		L		1	L	192480
110	3,2	2.5	40	20	▲▲▲		10	45	5	Homag		R		1	L	192479
120	3,6	2.8	40	24	▲▲		8	30	0	Homag		N		1	L	189751
120	3,2	2.5	40	36	▲▲▲		10	45	5	Homag		N		1	L	192484
125	2,4	1.6	30	36	▲▲▲		10	30	0	Homag BAZ		N		1	L	192487
140	3,2	2.2	30	36	▲▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800		L		1	O	192491
140	3,2	2.2	30	36	▲▲▲	4/8,6/46	10	15	5	Biesse Akron 600/800		R		1	O	192490
150	3,2	2.2	30	48	▲▲▲		10	15	0	Homag BAZ		R		1	L	192494
180	3,2	2.2	30	54	▲▲▲		10	30	5	Homag BAZ		L		1	L	192500

* **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

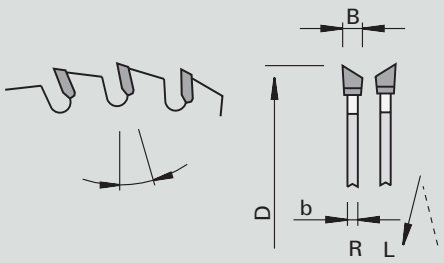
Appropriate **reducing rings** can be found at the end of the chapter

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

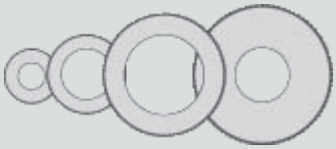
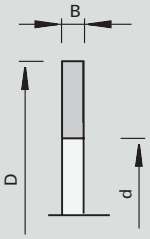
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	Cutting quality*	NL**	Hook angle [°]	Corner [°]	Shear [°]			L/R		PU [pc.]	L	Order-No.
100	2,6	2.0	32	30	▲▲		-10	15	0	Brandt		L		1	L	192510
100	2,6	2.0	32	30	▲▲		-10	15	0	Brandt		R		1	L	192509
100	2,6	2.0	32	30	▲▲		10	15	0	Homag CN		R		1	S	192513 NEW
100	2,6	1.6	32	30	▲▲		10	10	0	Brandt		L		1	L	192511
100	2,6	1.6	32	30	▲▲		10	10	0	Brandt		R		1	L	192512
150	3,5	2.2	30	44	▲▲▲	4/5,5/52	-12	45	10	Homag Powerline		L		1	L	192524
150	3,5	2.2	30	44	▲▲▲	4/5,5/52	-12	45	10	Homag Powerline		R		1	L	192523

* **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
				

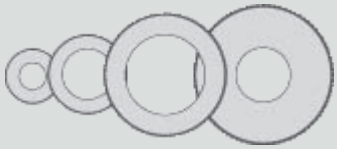
Machine / Application	Design	Advantages	Notes
• portable saws • for reduction of the saw blade bore	• ground bore • knurled on the outside		• this bore can only be reduced if the direct clamping of the saw blade via clamping rings or flanges is guaranteed

Product features			Order information		
Ø D [mm]	B [mm]	Ø d [mm]	PU [pc.]	L	Order-No.
20	1,4	12,7	1	L	50880032
20	1,4	13	1	L	50880029
20	1,8	15	1	L	50880018
20	1,4	16	1	L	50880027
20	1,6	16	1	L	50880050
25,4	2,0	20	1	L	50882620
30	2,0	15	1	L	50880014
30	1,4	16	1	L	50880031
30	1,4	20	1	L	50880026
30	2,0	22	1	L	50880033
30	2,0	24	1	L	50880009
30	1,4	25	1	L	50880008
32	2,0	20	1	L	50883220
30	2,0	20	1	S	50880045
30	2,0	25	1	S	50880042

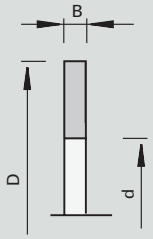
* **Cutting quality:** ▲ very rough cut, ▲▲ rough cut, ▲▲▲ fine cut, ▲▲▲▲ very fine cut
** **Pin holes: Combi1** = 2/10/60 + 2/7/42 **Combi2** = 2/7/42 + 2/9/46 and 2/10/60 **Combi3** = 2/10/60 + 2/9/46 + 2/9,5/46,5 + 2/7/42 **Combi5** = 2/7/110 + 2/9/110 + 2/8,4/130 + 2/14/110 + 4/9/100 + 4/19/120 **Combi7** = 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 - 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	16		1	L	161945
22	2,0	20		1	L	161887
22	4,0	20		1	L	161830
25	2,2	20		1	L	000104
30	1,4	16		1	L	000111
30	1,4	20		1	L	000117
30	1,9	16		1	L	000112
30	1,9	20		1	L	000118
30	2,0	20		1	L	016848
30	2,2	16		1	L	000113
30	2,2	18		1	L	000114
30	2,2	20		1	L	000119
30	2,2	22		1	L	000120
30	2,2	25		1	L	000128
30	2,2	25,4	1″	1	L	000130
30	3,0	25		1	L	000129
32	2,0	16		1	L	161886
32	2,2	30		1	L	000137
35	1,0	30		1	L	000145
35	1,9	30		1	L	000147
35	2,2	25		1	L	000142
35	2,2	30		1	L	000148
40	2,0	32		1	L	161962
40	2,2	20		1	L	000151
40	2,2	30		1	L	000153
45	2,5	30		1	L	161831
50	2,2	30		1	L	000156
55	2,2	30		1	C	000159
60	2,2	30		1	L	000161
60	2,2	35		1	L	000162
60	2,2	50		1	L	000164
60	2,8	30		1	L	010577
70	2,2	30		1	C	000166
80	2,2	30		1	L	000171
80	2,2	35		1	C	000172
80	2,2	50		1	L	000175
80	2,2	60		1	L	000177
80	2,2	70		1	C	000179
80	2,8	60		1	C	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

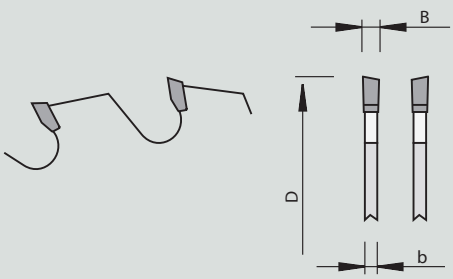
MILLING TOOLS WITH BORE

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

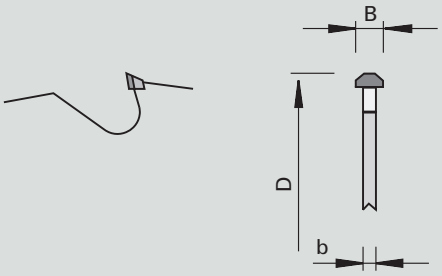
Product features / **Order information**

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	L	50660300
100	3,97	2.8	22	12	4/4,5/36	7500-13100	Lamello®		1	L	50110178
102	3,85	3.0	22	12		7500-13100	ELU DS 140		1	L	50660301

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

Product

Drawing



Machine

Application

Design

0,0 mm

MAN

MEC

Machine / Application

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

Design

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

Advantages

Notes

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

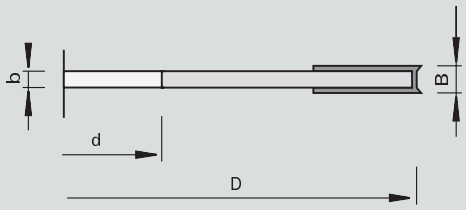
Product features / **Order information**

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	L	50660347
100.4	7,0	4	30	3				1	L	50660346

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

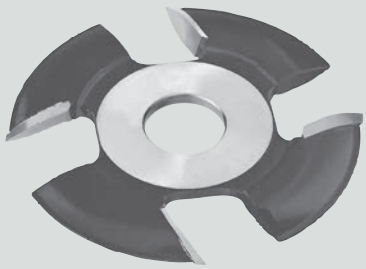
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	NL**			PU [pc.]	L	Order-No.
100	3,97	3.97	22	4 V4	4/4,5/36			1	O	69470022

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			18	18	1.95	TCw20		10	L	50450220
Spurs			14	14	1.2			10		163701

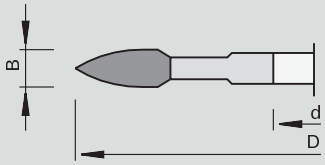
Spare parts		Dimension [mm]		PU [pc.]	L	Order-No.
Countersunk Screws		M4x0,5x3,2 T9 D=Ø6		10	L	163925
Special Nuts	for profile knives	M4x0,5x2,2		10	L	163703
Screwdrivers		T9		1	L	164344
Special Nuts	for spurs	M4x0,5x1,6		10	L	163704

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

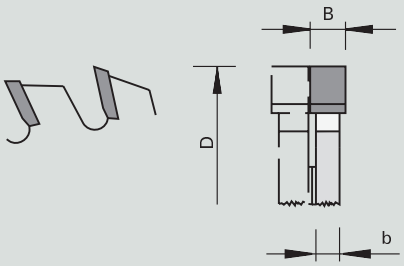
Order information

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	L	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

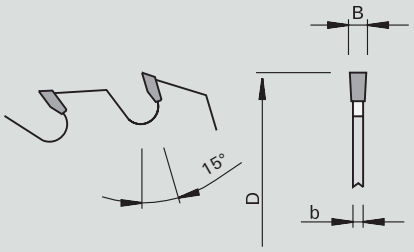
Product features / Order information

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	L	188359
125	1,8	1.0	30	12	MAN	6100-10500		1	L	188360
125	2,0	1.2	30	12	MAN	6100-10500		1	L	188361
125	2,2	1.2	30	12	MAN	6100-10500		1	L	188362
125	2,5	1.4	30	12	MAN	6100-10500		1	L	188363
125	3,0	2.0	30	12	MAN	6100-10500		1	L	188364
125	3,5	2.5	30	12	MAN	6100-10500		1	L	188365
125	4,0	2.5	30	12	MAN	6100-10500		1	L	50188366
125	4,5	3.0	30	12	MAN	6100-10500		1	L	188367
125	5,0	4.0	30	12	MAN	6100-10500		1	L	188368
125	6,0	4.0	30	12	MAN	6100-10500		1	L	188369
150	10	6.0	30	12	MAN	5200-8800		1	L	188387
150	9,0	6.0	30	12	MAN	5200-8800		1	L	188386
150	8,0	5.0	30	12	MAN	5200-8800		1	L	50188385
150	7,0	5.0	30	12	MAN	5200-8800		1	L	50188384
150	6,0	4.0	30	12	MAN	5200-8800		1	L	50188383
150	5,0	4.0	30	12	MAN	5200-8800		1	L	50188382
150	4,5	3.5	30	12	MAN	5200-8800		1	L	188381
150	4,0	3.0	30	12	MAN	5200-8800		1	L	50188380
150	3,5	2.5	30	12	MAN	5200-8800		1	L	188379
150	3,0	2.0	30	12	MAN	5200-8800		1	L	50188378
150	2,5	1.5	30	12	MAN	5200-8800		1	L	188377
150	2,2	1.2	30	12	MAN	5200-8800		1	L	188376
150	2,0	1.2	30	12	MAN	5200-8800		1	L	188375
150	1,5	0.8	30	12	MAN	5200-8800		1	L	188373
125	10	6.0	30	12	MAN	6100-10500		1	L	188372
125	8,0	5.0	30	12	MAN	6100-10500		1	L	50188371
125	7,0	5.0	30	12	MAN	6100-10500		1	L	188370

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

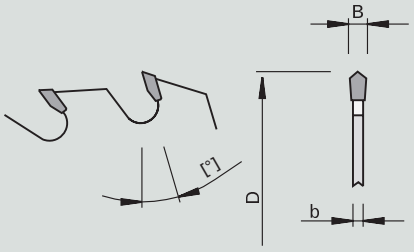
Product features / **Order information**

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	L	169685
180	5,0	4.0	30	18	▲▲▲	MEC	15		1	L	169684
180	8,0	5.0	30	18	▲▲▲	MEC	15		1	L	169683
180	10	6.0	30	18	▲▲▲	MEC	15		1	L	169682

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**

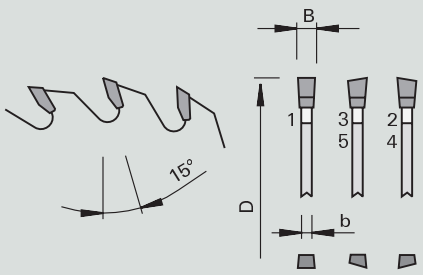
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z		nmin-nmax [min-1]		PU [pc.]	L	Order-No.
100	7,0	5.0	22	6	MAN	7600-13000		1	O	50660303
160	6,0	3.0	20	12	MAN	7600-13000		1	O	50660304

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

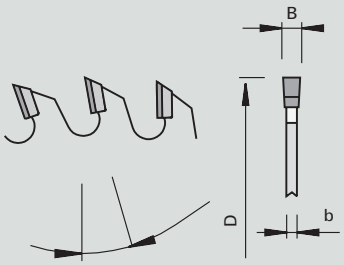
Product features / Order information

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	L	50806250
100	5,0	4.0	30	35	▲▲▲		Weeke BHX	15		1	L	50806252
120	4,0		20	35	▲▲▲			15		1	L	191948
120	5,0	4.0	20	35	▲▲▲			15		1	L	191949
120	3,2	2.2	20	35	▲▲▲		Weeke BHX	15		1	L	58806260
120	4,0	2.8	20	35	▲▲▲	2x3/4,5/35	SCM / Morbidelli	15		1	L	50806254
120	5,0	4.0	20	35	▲▲▲	2x3/4,5/35	SCM / Morbidelli	15		1	L	50806255
120	4,0	2.8	35	35	▲▲▲	2x4/5,5/50 + 2/6/46+50	Biesse	15		1	L	191952
120	5,0	4.0	35	35	▲▲▲	2x4/5,5/50 + 2/6/46+50	Biesse	15		1	L	191953
125	4,0	2.8	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	Weeke BHX	15		1	L	50806251
125	5,0	4.0	30	35	▲▲▲	4/5,5/48R + 4/5,5/48L	Weeke BHX	15		1	L	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

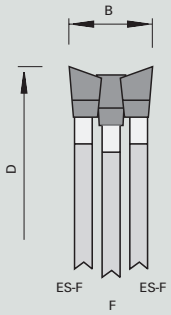
Product features — **Order information**

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 by - 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 across 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**

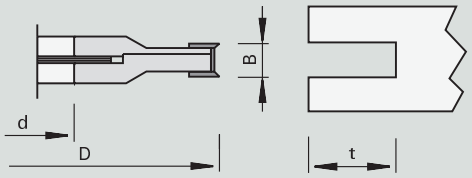
Ø D [mm]	B [mm]	Ø d [mm]	Z	Cutting quality*	NL**					PU [pc.]	L	Order-No.
250	5,0-13	30	30	▲▲▲	Combi2				●●	1	L	50459024

HW 5561 Grooving Cutterheads - Silverline

adjustable by means of HW turnover knife

Product

Drawing



Machine

Application

Design

STEEL

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

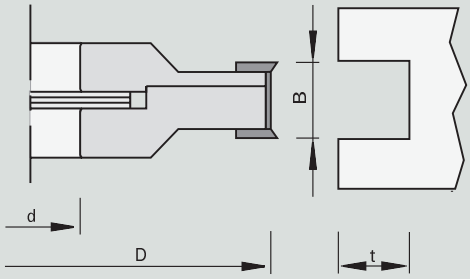
Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Turnover Knives	18	18	1.95	TCw20	10	L	50450220
Spurs	14	14	2.0	TCw30	10	L	003079

HW 5562 Grooving Cutterheads - Silverline

adjustable by means of HW turnover knife

Product

Drawing



Machine

Application

Design

STEEL

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

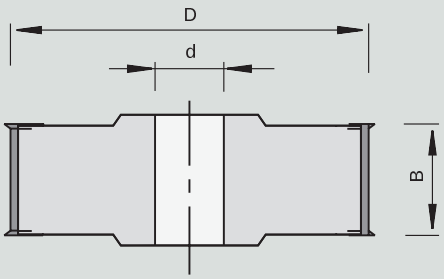
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Spurs			14	14	2.0	TCw30		10	L	003079
Turnover Knives			12	12	1.5	TC05		10	L	003080
Turnover Knives			7,5	12	1.5	TC05		10	L	052543

HW 1586 Jointing and Rabbeting Cutterheads - Silverline

scoring cut

Product

Drawing



Machine

Application

Design

STEEL

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

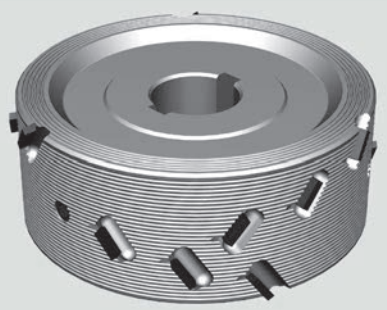
Product features / Order information

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	S	68010013
125	30	40	4 V4	9000	1	S	68010014
125	30	50	4 V4	9000	1	S	68010015
125	50	30	4 V4	9000	1	S	68010023
125	50	40	4 V4	9000	1	S	68010024
125	50	50	4 V4	9000	1	S	68010025
140	50	30	4 V4	9000	1	S	68010043
140	50	40	4 V4	9000	1	S	68010044
140	50	50	4 V4	9000	1	S	68010045

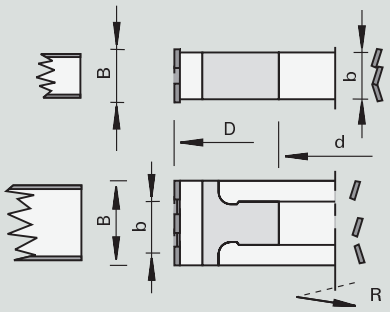
Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Spurs	14	14	2.0	TCw30	10	L	003079
Turnover Knives	50	12	1.5	TC05	10	L	003085
Turnover Knives	30	12	1.5	TC05	10	L	003083

DP 3585 Jointing Cutters DP airFace

Product



Drawing



Machine

Application

Design

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 VDMA 8849

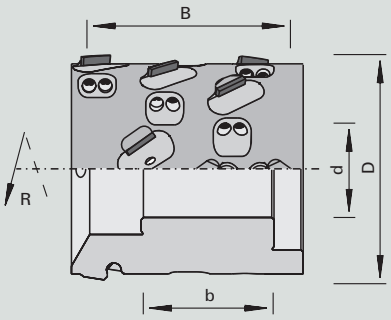
Product features / Order information

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	24000	Felder/Format 4		●	1	L	186382	L	186381
85	43,2	50	30	3+3	8x3,3	22000	Ott		●	1	L	186408	L	186409
100	43,2	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani		●	1	L	186385	L	186386
100	43,2	40.6	30	3+3	8x3,3	19000	Brandt		●	1	L	186373	L	186374
100	43,2	60.6	30	3+3	8x3,3	19000	SCM-Stefani		●	1	L	186414	L	186415
100	43,2	61	30	2+2	8x3,3	19000	EBM / Hebrock	asymmetrical	●	1	L	58186378	L	58186377
100	64,5	40.6	30	3+3	8x3,3	19000	Brandt		●	1	L	186371	L	186372
100	64,5	25	30	2+2	8x3,3	19000	HOLZ-HER up to 2008, SCM-Stefani, EBM		●	1	L	186387	L	186388
125	29	34	30	3+3	8x3,3	15000	Homag		●	1	L	186401	L	186401
125	43,2	40	30	3+3	8x3,3	15000	Homag		●	1	L	58186399	L	58186399
125	64	40	30	3+3	8x3,3	15000	Homag		●	1	L	58186400	L	58186400

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 VDMA 8849

Product features / Order information

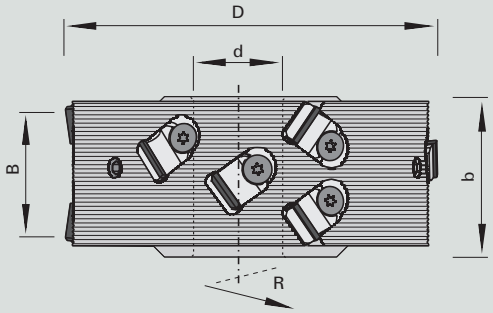
Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	nmax [min-1]			PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
70	48	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802		1	L	185800	L	185801
70	64	41	30	2+2	8x3,3	18000	HOLZ-HER aggregate 1801 / 1802		1	L	185802	L	185803
100	63	40	30	3+3	8x3,3	18500	HOLZ-HER aggregate 1804		1	L	186937	L	186936

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 VDMA 8849

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	L	186037	L	186038
70	64	56	30	2+2	8x3,3	asymmetrical	HOLZ-HER 1801/1802	12		1	L	187025	L	187026

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=70 / 35°	17,2x14,2x8,9	4	L	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	L	186031	L	186031

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=80 / 35°	17,2x14,2x8,9	4	L	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	L	186058	L	186057

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=85 / 35°	17,2x14,2x8,9	4	L	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 110F, 112OFC	8		1	L	186071	L	186072
100	43	40.6	30	3+3	8x3,3	asymmetrical	Brandt	12		1	L	186065	L	186066
100	64	40.6	30	3+3	8x3,3	asymmetrical	Brandt, SCM	18		1	L	186073	L	186074
100	64	60.6	30	3+3	8x3,3	asymmetrical	SCM	18		1	L	186062	L	186061
100	43	60.6	30	3+3	8x3,3	asymmetrical	SCM	12		1	L	186063	L	186064

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=100 / 35°	17,2x14,2x8,9	4	L	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	32,5	54	30	3+3	8x3,3	asymmetrical	Homag	9		1	L	186307	L	186306
125	43,2	54	30	3+3	8x3,3	asymmetrical	Homag	12		1	L	185971	L	185970
125	43	40	30	3+3	8x3,3	symmetrical	Homag	12		1	L	186047	L	186047
125	43,2	72	30	3+3	8x3,3	asymmetrical	IMA 08.378	12		1	O	186051	O	186052
125	63	57	30	3+3	8x3,3	asymmetrical	IMA 08.379	21		1	L	186055	L	186056
125	64	40	30	3+3	8x3,3	symmetrical	Homag	18		1	L	186048	L	186048
125	64,4	72	30	3+3	8x3,3	asymmetrical	IMA 08.378	18		1	O	186049	O	186050
125	64,4	54	30	3+3	8x3,3	asymmetrical	Homag	18		1	L	185973	L	185972

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=125 / 35°	17,2x14,2x8,9	4	L	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	L	186055	L	186056

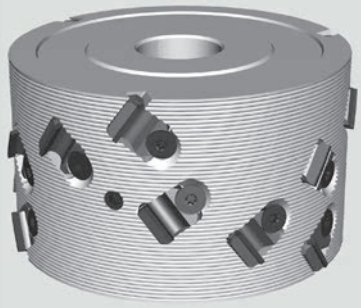
Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
DP cutting edges	Ø D=125 / 43°	17,2x14,2x8,9	4	L	186075

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

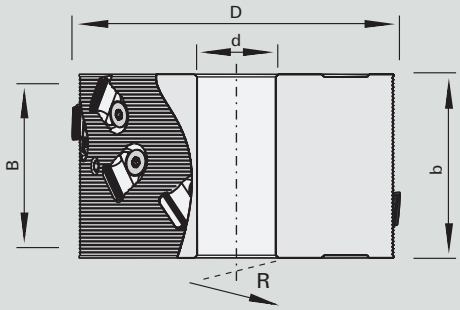
3589 Jointing Cutterheads airFace - MAN

With exchangeable DP cutting edges

Product



Drawing



Machine

Application

Design

Machine / Application

- table shapers
- For jump-milling units for very quiet jointing of solid wood and wood-based panels with and without coating, focusing particularly on diameter consistency and noise reduction

Design

- aluminum body with airFace surface
- with exchangeable stainless steel DP cutting edges
- 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
- Reduced spindle bearing load thanks to less unbalance
- Exchangeable DP cutting edges with wear-resistant exchangeable gullet
- Diameter consistency thanks to the use of new DP cutting edges
- Excellent cutting quality thanks to large shear angle
- Corrosion protection over the entire tool thanks to 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 VDMA 8849

Product features

Ø D [mm]	B [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]	nmax [min-1]
125	64	70	30	3+3		

Order information

	PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
	1	L	186986	L	186986

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

Spare parts / Accessories	Dimension [mm]	PU [pc.]	L	Order-No.
Countersunk Screws	M5x13,5 T20	10	L	185080

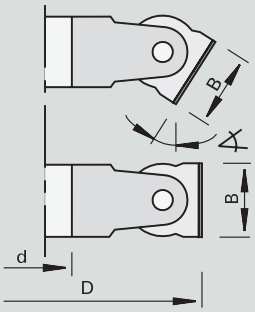
Spare parts / Accessories	Dimension [mm]	PU [pc.]	L	Order-No.
Torque Screwdrivers	5,0 Nm	1	L	185292
Plug Insert Torx	T20	2	L	185293

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

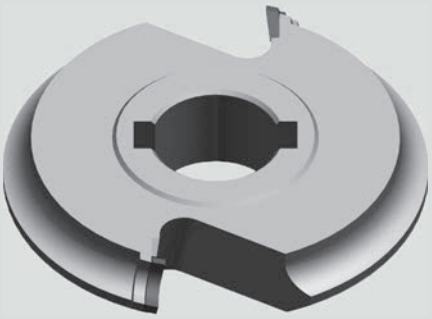
Ø D [mm]	B [mm]	Ø d [mm]	Z			nmin-nmax [min-1]		PU [pc.]	L	Order-No.
167	50	30	2			4600-7800		1	L	50663009

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
			50	12	1.5	TC05		10	L	003085

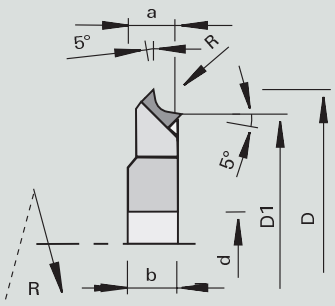
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Set Screws	M6x16 SW3		10	L	001617
Screwdrivers	SW3x100		1	L	166090
Cranked Wrench Keys	SW6 DIN ISO 2936		1	L	009675
Pressure Bars	B=50		2	L	50930124

DP 3565 Edge Rounding Cutters

Product



Drawing



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 VDMA 8849

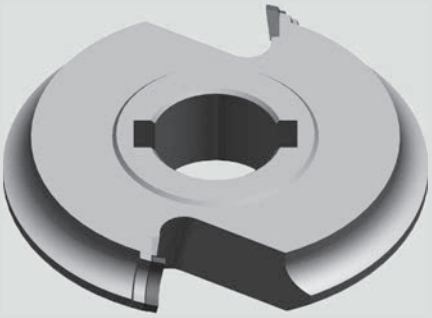
Product features

Order information

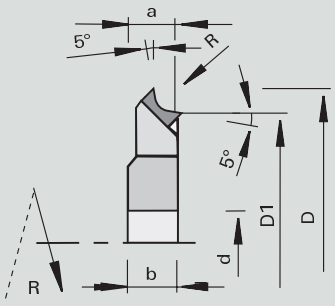
R [mm]	Ø D [mm]	Ø D1 [mm]	a [mm]	b [mm]	Ø d [mm]	Z	DKN [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
2,0	69	61	9.72	10.5	16	4	5x2,3		1	L	185679	L	185680

DP 3565-1 Edge Rounding Cutters

Product



Drawing



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 VDMA 8849

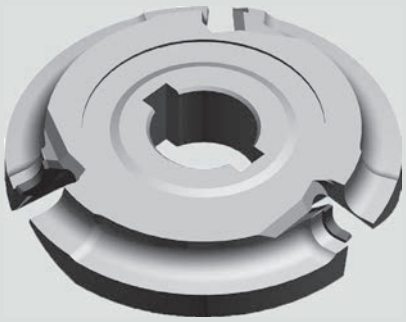
Product features

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	L	182141	L	182142

DP 3565-2 Edge Rounding Cutters CM

Product



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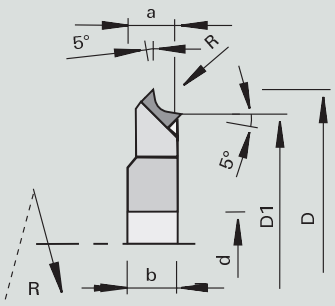


Machine

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 VDMA 8849

Product features

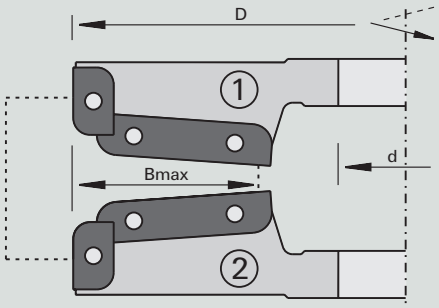
Order information

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	L	187135
3,0	58.7	50	8.5	12	16	3	5x2,3		1	L	187140

HW 5540 Panel Raising Cutterheads - Silverline

Product

Drawing



Machine

Application

Design

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

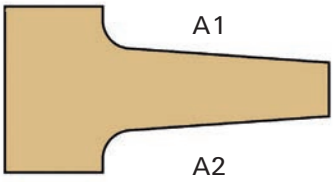
Product features / Order information

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	S	68255130
200	60	30	2+2	2	3800 - 6500	R		1	S	68255230
200	60	40	2+2	1	3800 - 6500	L		1	S	68255140
200	60	40	2+2	2	3800 - 6500	R		1	S	68255240
200	60	50	2+2	1	3800 - 6500	L		1	S	68255150
200	60	50	2+2	2	3800 - 6500	R		1	S	68255250

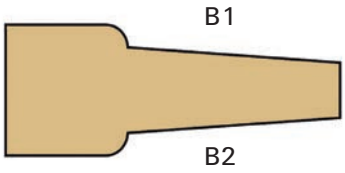
Knives	Dimension [mm]	suitable for	L/R	PU [pc.]	L	Order-No.
Profile Panel Raising Cutting Edges A1	60x12x1,5	68255130, 68255140, 68255150	L	6	S	62556011
Profile Panel Raising Cutting Edges A2	60x12x1,5	68255230, 68255240, 68255250	R	6	S	62556012
Profile Panel Raising Cutting Edges B1	60x12x1,5	68255130,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

5540 Panel Raising Cutterheads Silverline - Drawing

Profile combinations



A



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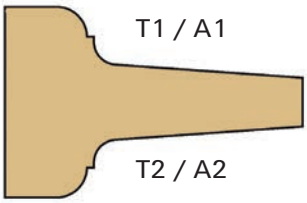
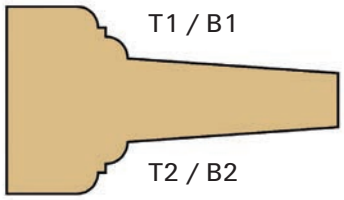


A/T



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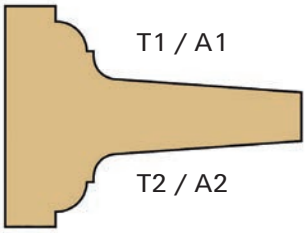

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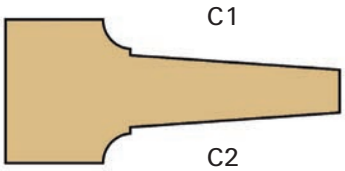

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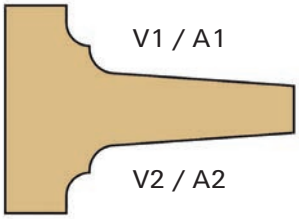
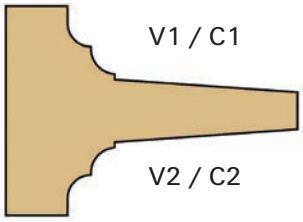
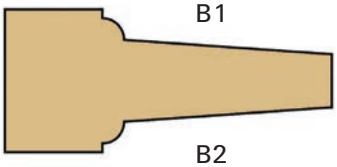


A/V



CV



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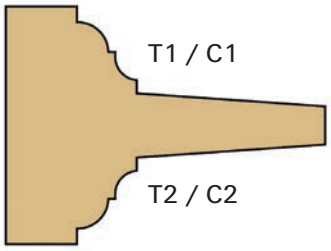
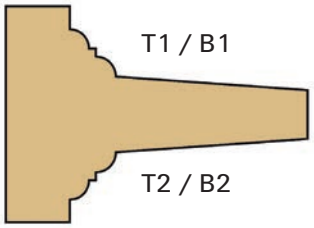


CT



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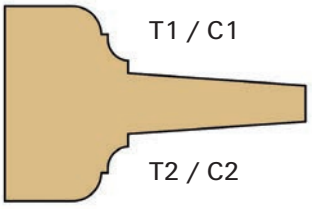


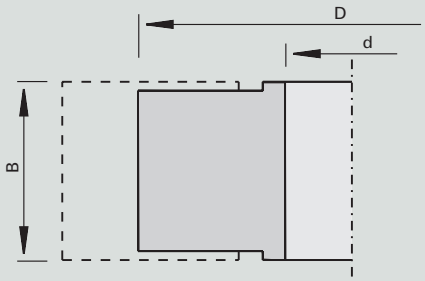
CT

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

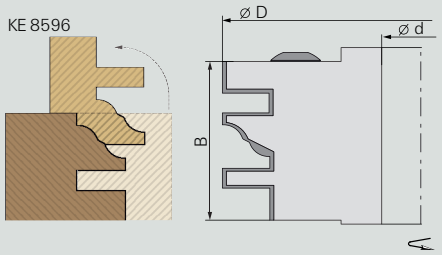
Order information

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

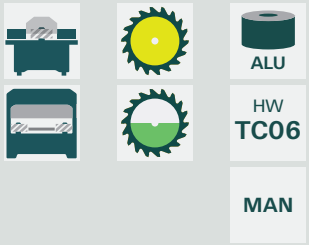
Advantages

- 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



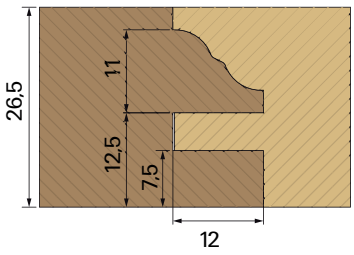
Product features / Order information

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	L	50664637

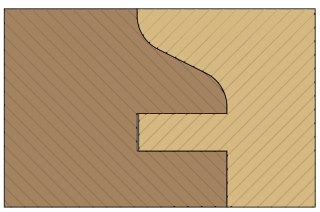
Turnover Knives	Cutting material	PU [pc.]	L	Order-No.
Profile Knives KE7826	TC06	2	L	50687826
Profile Knives KE7828	TC06	6	S	50687828
Profile Knives KE7824	TC06	6	S	50687824
Profile Knives KE8598	TC06	6	S	50688598
Profile Knives KE8596	TC06	6	S	50688596

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

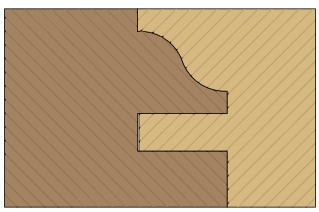
KE 8596



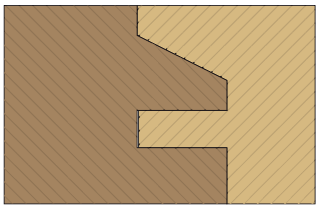
KE 7824



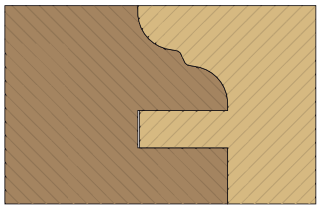
KE 7826



KE 7828



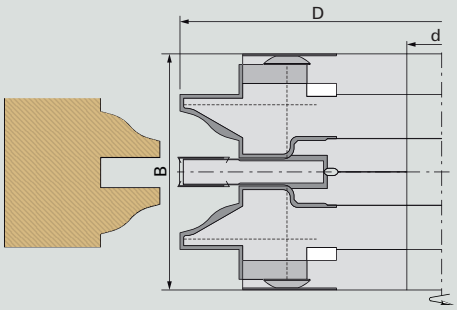
KE 8598



HW 5554 Counter Profile Set

Product

Drawing



Machine

Application

Design

HW TC05

HW TC06

HW TCw30

MAN

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

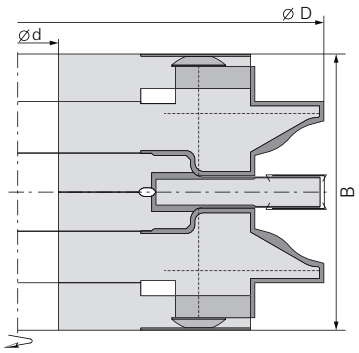
Product features

Order information

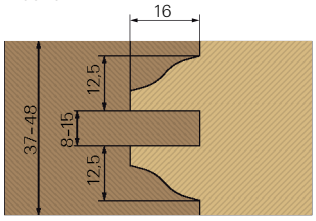
Ø D [mm]	B [mm]	Ø d [mm]	Z		Profile	nmin-nmax [min-1]		PU [pc.]	L	Order-No.
160	37-48	30	2		A	4800-8200		1	L	50664655

Turnover Knives		Profile	B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Profile Knives KE8620		A	25,3	29	2.0	TC06		6	S	50688620
Profile Knives KE8621		A	25,3	29	2.0	TC06		6	S	50688621
Profile Knives KE8622		B	25,3	29	2.0	TC06		2	S	50688622
Profile Knives KE8623		B	25,3	29	2.0	TC06		6	S	50688623
Profile Knives KE8624		C	25,3	29	2.0	TC06		6	S	50688624
Profile Knives KE8625		C	25,3	29	2.0	TC06		6	S	50688625
Profile Knives KE8626		D	25,3	29	2.0	TC06		6	S	50688626
Profile Knives KE8627		D	25,3	29	2.0	TC06		6	S	50688627
Profile Knives KE8628		E	25,3	29	2.0	TC06		6	S	50688628
Profile Knives KE8629		E	25,3	29	2.0	TC06		6	S	50688629
Profile Turnover Knives HW with 4 cutting edges - Ledinek Rotoles			14	14	2.0	TCw30		10	L	003079
Turnover Knives HW with 2 cutting edges			7,5	12	1.5	TC05		10	L	052543

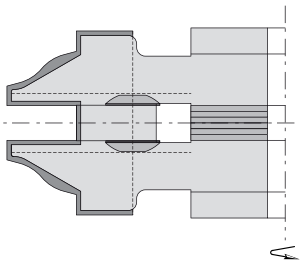
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Pressure Bars	B=7,2		2	L	168074
Set Screws	M6x16 SW3		10	L	001617
Set Screws	M5x12 DIN EN ISO 4028		10		050565
Countersunk Screws	M5x6 T20 D=Ø9,3		10	L	176199
Screwdrivers	SW3x100		1	L	166090
Cranked Wrench Keys	SW2,5 DIN ISO 2936		1		009671
Screwdrivers	T20x100		1	L	166092
Adjusting Gauges	0,3		1		055883
Spacer Sets	65/30x20 TK48		1	S	50252708



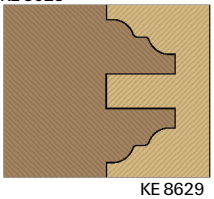
KE 8620



KE 8621

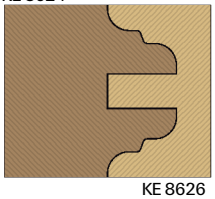


KE 8628



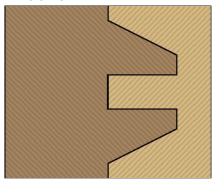
KE 8629

KE 8624



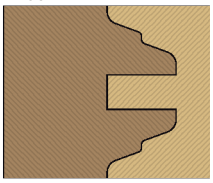
KE 8626

KE 8626



KE 8627

KE 8622

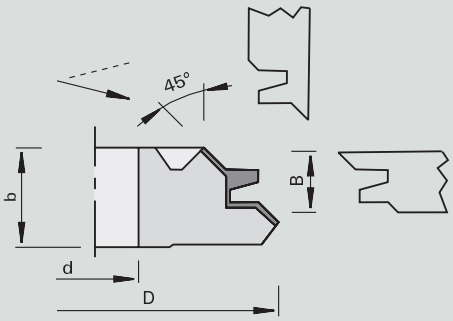


KE 8623

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	L	176097

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

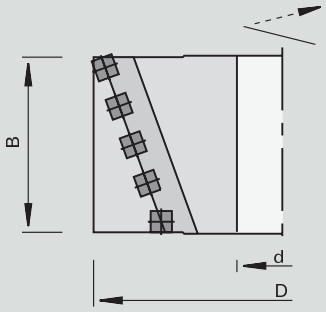
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Pressure Bars	38x11x6		2	L	180538
Clamping Pieces	12x8,5/M8L		2	L	180357
Clamping Set Screws	M8x26 SW4		10	L	180340
Countersunk Screws	M5x10,8 T15 D=Ø9,4		10	L	180840
Screwdrivers	SW4x100		1	L	166091
Screwdrivers	T15x80		1	L	171188

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
- 180454 R=50 mm for Cutterheads ≤ 2022
- 187323 R=150 mm for Cutterheads ≥ 2023
- HSK mounting arbor (183748 + screw 173592)
- HSK mounting arbor (183749 + screw 173592)

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

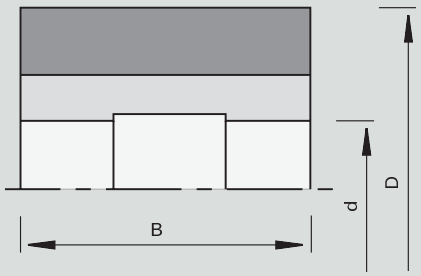
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives (with rounded edges R=50 mm)			15	15	2.5	TCw20		10	L	180454
Turnover knives with rounded edges (rounded R=150 mm)			15	15	2.5	TCw20		10	L	187323

Spare parts	Dimension [mm]			PU [pc.]	L	Order-No.
Screwdrivers	T20x100			1	L	166092
Countersunk Screws with collar 6 mm	M5x13 T20			10	S	80306012
Countersunk Screws with collar 6 mm	M5x15,5 T20 D=Ø8,5			10	L	182112

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

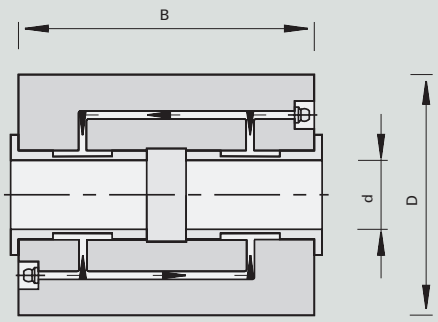
Ø D [mm]	B [mm]	Ø d [mm]	Z						PU [pc.]	L	Order-No.
125	80	40	4						1	S	50561046
125	100	40	4						1	S	50561038
125	130	40	4						1	S	50561035
125	150	40	4						1	S	50561036
125	180	40	4						1	S	50561037
125	240	40	4						1	S	50561054

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

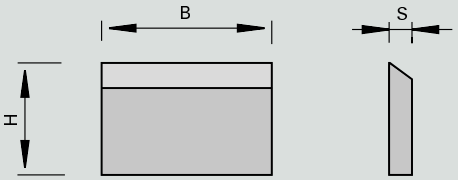
Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min-1]	PU [pc.]	L	Order-No.
143	60	40	4	8500	1	S	58562686
143	130	40	4	8500	1	S	58562689
143	230	40	4	8500	1	S	58562990
163	60	50	4	6000	1	S	58562687
163	100	50	4	6000	1	S	58562691
163	130	50	4	6000	1	S	58562741
163	130	50	4	6000	1	S	58562693
163	180	50	4	6000	1	S	58562700
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	L	181466
Screwdrivers	SW6x200	1	L	167817
Grease presses		1	L	163706
Grease Cartridges		1	L	163707

HS 569 Planing Knives HS - Plus

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

- HS Plus quality for long edge lives

Notes

- for 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

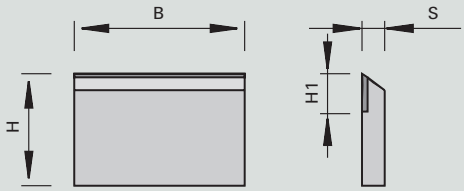
B [mm]	H [mm]	S [mm]	PU [pc.]	L	Order-No.
60	30	3	2	S	58400131
80	30	3	2	S	58400132
100	30	3	2	S	58400133
120	30	3	2	S	58400134
130	30	3	2	L	58400135
150	30	3	2	S	58400136
160	30	3	2	S	58400137
170	30	3	2	S	58400161
180	30	3	2	S	58400138
180	35	3	2	S	58400201
210	30	3	2	S	58400162
230	30	3	2	L	58400139
240	30	3	2	S	58400206
300	30	3	2	S	58400140
300	35	3	2	S	58400202
310	30	3	2	L	58400147
310	35	3	2	S	58400187
320	30	3	2	S	58400205
330	30	3	2	S	58400141
350	30	3	2	L	58400198
350	35	3	2	S	58400188
400	30	3	2	S	58400170
400	35	3	2	S	58400171
410	30	3	2	L	58400149
410	35	3	2	S	58400158
420	30	3	2	S	58400142
420	35	3	2	S	58400190
450	30	3	2	S	58400150
460	30	3	2	S	58400151
460	35	3	2	S	58400192
500	30	3	2	L	58400143
500	35	3	2	S	58400196
510	30	3	2	L	58400152
510	35	3	2	L	58400159
520	30	3	2	L	58400184
530	30	3	2	S	58400144
530	35	3	2	L	58400166
600	30	3	2	S	58400165
600	35	3	2	S	58400193
610	30	3	2	L	58400153
610	35	3	2	L	58400160
630	30	3	2	L	58400145

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

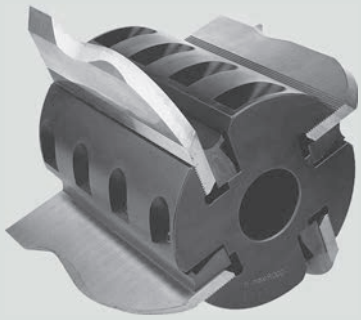
Notes

- packing unit: 2 pieces

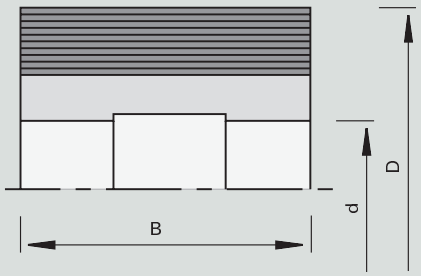
Product features										Order information			
B [mm]	H [mm]	S [mm]	H1 [mm]								PU [pc.]	L	Order-No.
60	30	3.0	11							○	2	S	50400021
100	30	3.0	11							○	2	S	50400023
120	30	3.0	11							○	2	S	50400024
130	30	3.0	11							○	2	S	50400025
150	30	3.0	11							○	2	S	50400026
160	30	3.0	11							○	2	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	S	179221
Pressure Bars	B=180		2	S	179227
Pressure Bars	B=150		2	S	179226
Pressure Bars	B=100		2	S	179224
Pressure Bars	B=80		2	S	179223
Pressure Bars	B=60		2	S	179222
Pressure Bars	B=230		2	S	179228
Pressure Bars	B=130		2	S	179225
Dummy Pieces	B=40		2	S	179229
Dummy Pieces	B=180		2	S	179235
Dummy Pieces	B=150		2	S	179234
Dummy Pieces	B=100		2	S	179232
Dummy Pieces	B=80		2	S	179231
Dummy Pieces	B=60		2	S	179230
Dummy Pieces	B=230		2	S	179236
Dummy Pieces	B=130		2	S	179233
Screwdrivers	SW5x150		1	L	168703
Set Screws	M10x20 DIN EN ISO 4028		10	L	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

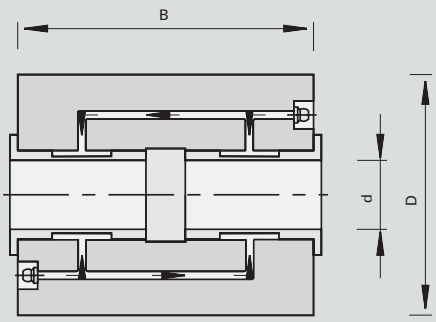
Maximum RPM

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	S	58562920
137	100	40	4	1	S	58562921
137	130	40	4	1	S	58562922
137	150	40	4	1	S	58562923
137	180	40	4	1	S	58562924
137	230	40	4	1	S	58562925
150	60	50	4	1	S	58562926
150	60	50	6	1	S	58562934
150	100	50	4	1	S	58562927
150	100	50	6	1	S	58562935
150	130	50	4	1	S	58562928
150	130	50	6	1	S	58562936
150	150	50	4	1	S	58562929
150	150	50	6	1	S	58562937
150	180	50	4	1	S	58562930
150	180	50	6	1	S	58562938
150	230	50	4	1	S	58562931
150	230	50	6	1	S	58562939
150	260	50	4	1	S	58562932
150	260	50	6	1	S	58562940
150	310	50	4	1	S	58562933
150	310	50	6	1	S	58562941
163	60	50	8	1	S	58562942
163	100	50	8	1	S	58562943
163	130	50	8	1	S	58562944
163	150	50	8	1	S	58562945
163	180	50	8	1	S	58562946
163	230	50	8	1	S	58562947
163	260	50	8	1	S	58562948
163	310	50	8	1	S	58562949

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

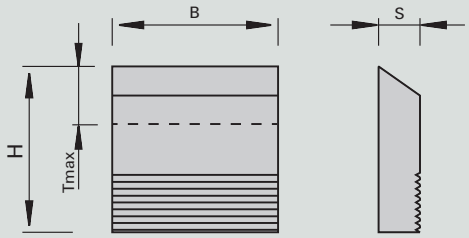
Maximum RPM

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

HS

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

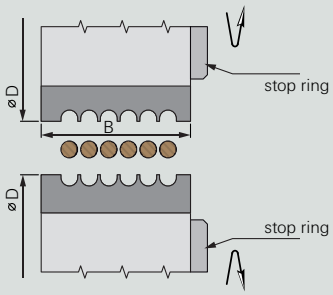
Order information

B [mm]	H [mm]	S [mm]	Tmax [mm]						PU [pc.]	L	Order-No.
40	50	8.0	12					●	2	L	50822712
40	60	8.0	20					●	2	L	163386
50	50	8.0	12					●	2	S	180533
60	50	8.0	12					●	2	L	163388
60	60	8.0	20					●	2	L	163389
60	70	8.0	30					●	2	L	163390
80	50	8.0	12					●	2	L	50822716
80	60	8.0	20					●	2	L	163392
80	70	8.0	30					●	2	L	163393
100	40	8.0	-					●	2	o	50822705
100	50	8.0	12					●	2	L	163394
100	60	8.0	20					●	2	L	163395
130	40	8.0	-					●	2	o	50822706
130	50	8.0	12					●	2	L	163397
130	60	8.0	20					●	2	L	163398
130	70	8.0	30					●	2	S	163399
150	50	8.0	12					●	2	L	163400
150	60	8.0	20					●	2	L	163401
150	70	8.0	30					●	2	L	163402
180	50	8.0	12					●	2	S	163403
180	60	8.0	20					●	2	S	163404
180	70	8.0	30					●	2	S	163405
230	50	8.0	12					●	2	L	164495
230	60	8.0	20					●	2	S	164496
650	50	8.0	12					●	2	L	176318
650	70	8.0	30					●	2	L	50822754
40	70	8.0	30					●	2	L	163387

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

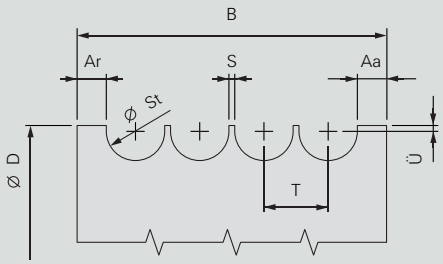
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Head Cap Screws	M8x30-8.8 DIN 7984		10	L	180005
Cranked Wrench Keys	SW6x100		1	S	180383
Washers	B=8,4 DIN 125		10	S	50945505

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

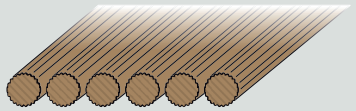
KNIVES

	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

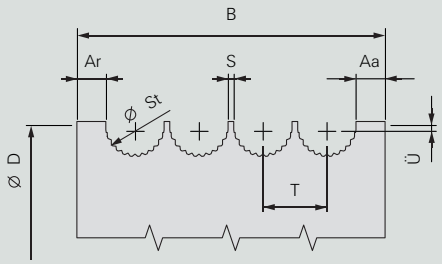
HS 464 HS Knives ripple bars

for fine serration dowels

Product



Drawing



Machine

Application

Design

Machine / Application

Design

Advantages

Notes

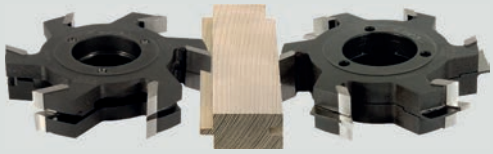
- small quantities: surcharge of 50%
- intermediate dimensions: surcharge of 25% on the next lower dimension
- indicate machine type when placing an order
- price per piece when ordering 8 identical knives

KNIVES

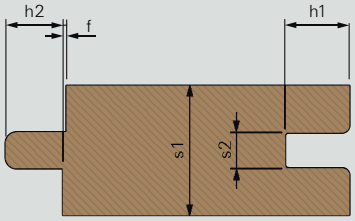
	St= bar Ø	6,1	7,1	8,1	10,1	11,1	12,1	13,1	14,1	15,1	16,1
	No. of serrations	16	16	20	22	22	22	22	22	22	22
	S = bridge	1	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5
	T= pitch	7,1	8,1	9,1	11,1	12,6	13,6	14,6	15,6	16,6	17,6
	D= diameter	127	127	135	135	135	135	135	135	135	135
B=50	No. of bars	6	5	4	3	3	3	3	2	2	2
	Order-No.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

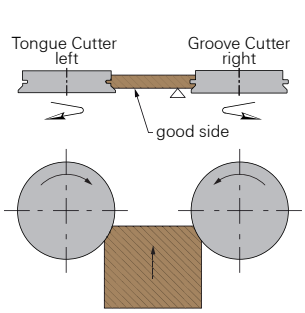
Notes

- 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

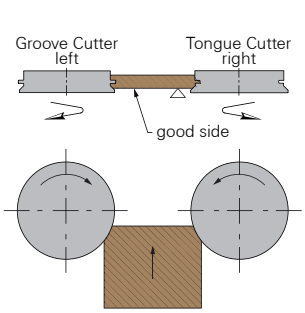
Product features / Order information

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

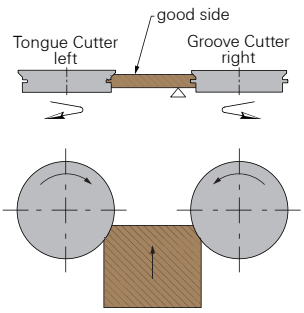
Example I



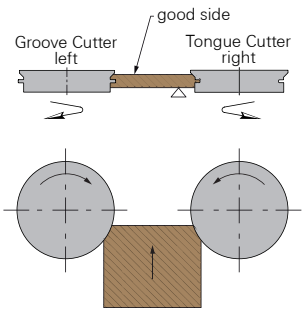
Example II



Example III



Example IV



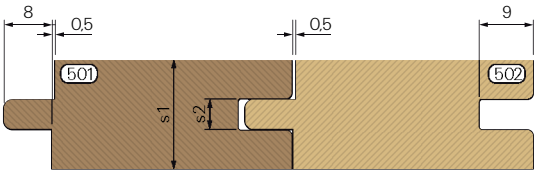
4000 Tongue and Groove Tools

Diagram I

Tongue Cutters

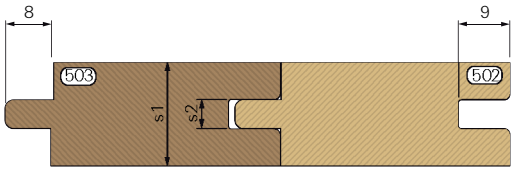
Grooving Cutters

Profile 501



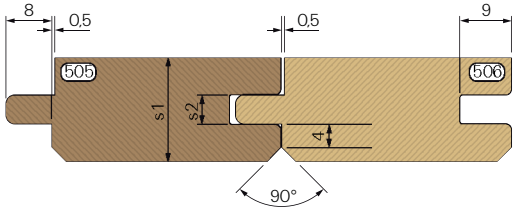
Profile 502

Profile 503



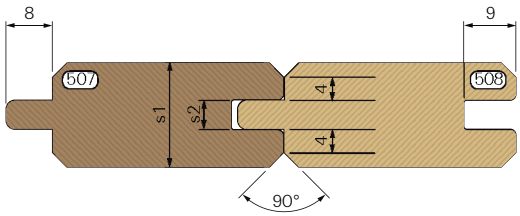
Profile 502

Profile 505



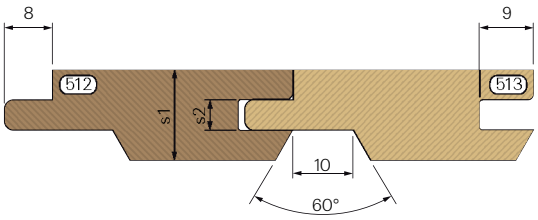
Profile 506

Profile 507



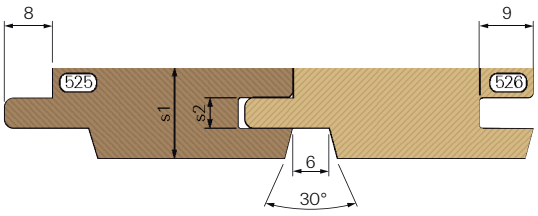
Profile 508

Profile 512



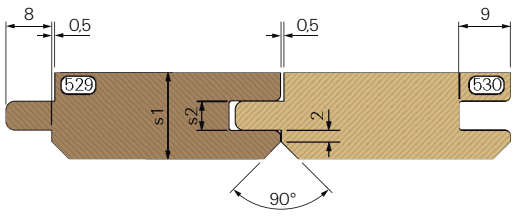
Profile 513

Profile 525



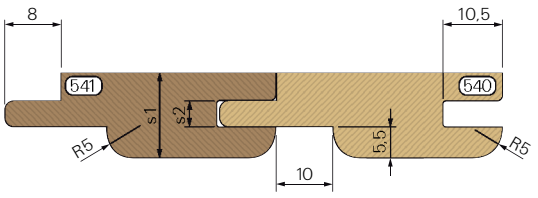
Profile 526

Profile 529



Profile 530

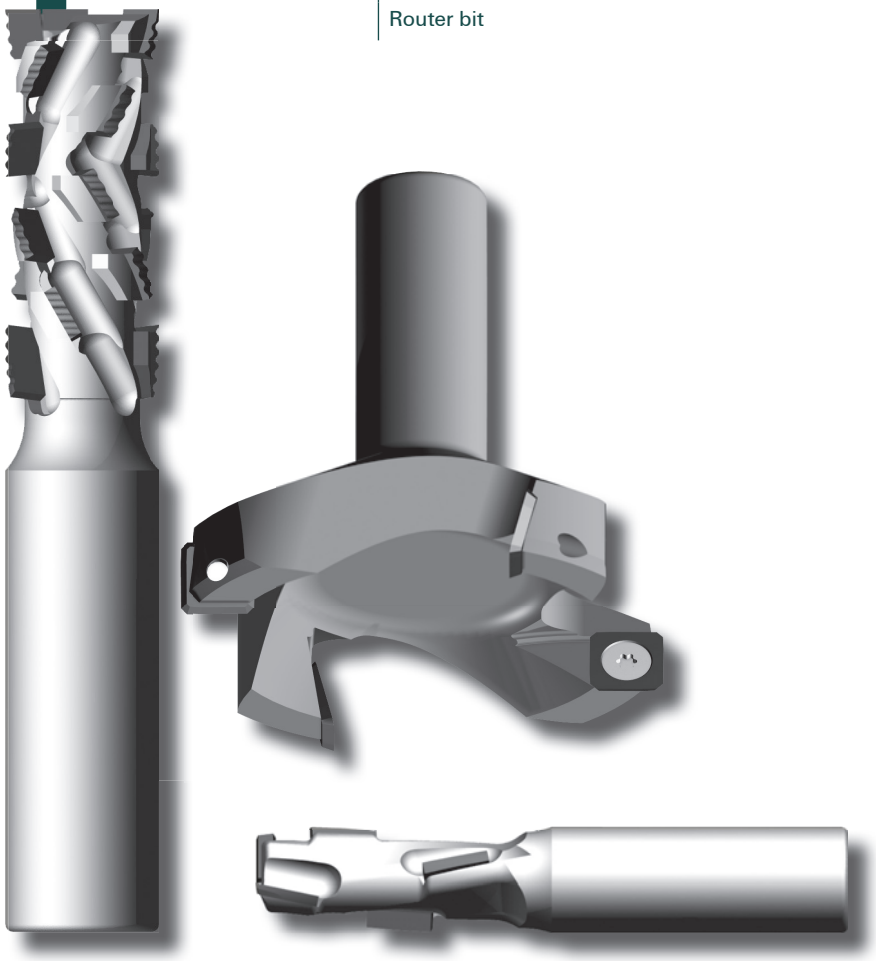
Profile 541



Profile 540

CNC MILLING TOOLS

CONTENTS

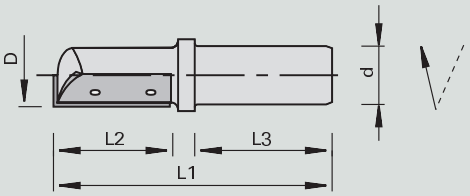


HW 2231 Shank-Type Cutters

With HW turnover knives

Product

Drawing



Machine

Application

Design

HW
TC05

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edge parallel to cutter axis and face cutting
- cutting material: HW TC05

Advantages

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter

Product features — **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z	PU [pc.]	L	Order-No.
8.0	20	12	70	1	1	L	175669
10	25	10	75	1	1	L	175678
10	25	12	75	1	1	L	175670
12	30	12	80	1	1	L	175664

Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
for Ø D = 8	20	4.1	1.1	TC05	10	L	173480
for Ø D = 10	25	5.5	1.1	TC05	10	L	173793
for Ø D = 12+14	30	5.5	1.1	TC05	10	L	173482

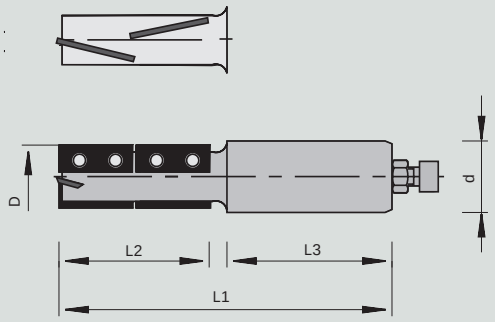
Spare parts	Dimension [mm]	Suitable for	PU [pc.]	L	Order-No.
Clamping Wedges	B=30	175664	2	S	175726
Clamping Wedges	B=25	175670, 175678	2	S	175724
Clamping Wedges	B=20	175669	2	L	175722
Head Cap Screws	M3x5,5 T8	175664	10	L	168239
Head Cap Screws	M2,5x4 T8	175670, 175678	10	L	168238
Head Cap Screws	M2,5x3 T8	175669	10	L	168237
Screwdriver with flag	T8	For all	1	L	166499

HW 2233 Shank-Type Cutters

With HW knives

Product

Drawing



Machine

Application

Design

HW
TC05

Machine / Application

- CNC routers
- for jointing, dividing, grooving and rabbeting in laminated panels and solid woods
- traveling plunge cut using Z and X or Y axis

Design

- staggered HW knives with with alternating shear angle
- plunge tip: 4-side HW turnover knife
- cutting material: HW TC05

Advantages

- 4 edge lives by turning the knives and exchanging the upper and lower turnover knife

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
20	53	25	55	125	2+2	1	c	184256	L	184254

Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Plunge tip	9,0	9.0	1.5	TC05	10	L	184259
	29,5	7.0	1.5	TC05	10	L	184258

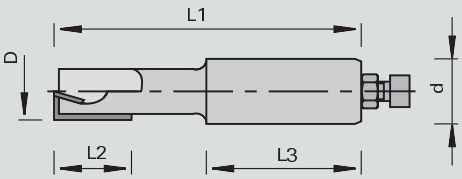
Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Round Head Screws	M3x4 T9	10	L	180449
Screwdrivers	T9x60	1	L	173796

HW 2235 Shank-Type Cutters

With HW turnover knives

Product

Drawing



Machine

Application

Design

HW
TC05

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- 1 cutting edge parallel to cutter axis and peripheral cutting
- 1 plunging tip with shear angle
- cutting material: HW TC05

Advantages

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Product features — **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z					PU [pc.]	L	Order-No.
16	30	16	43	92	1+1					1	L	168682

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Plunge tip for Ø 16			7,5	12	1.5	TC05		10	L	052543
Turnover Knives			29,5	12	1.5	TC05		10	L	180825

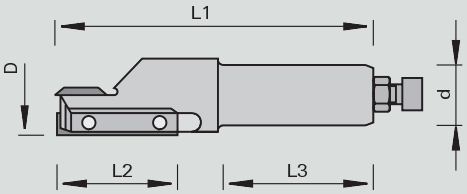
Spare parts	Dimension [mm]					PU [pc.]	L	Order-No.
Head Cap Screws	M3,5x3,8 T15					10	L	162645
Round Head Screws	M3,5x4 T15					10	L	168893
Screwdrivers	T15					1	L	163161

HW 2236 Shank-Type Cutters

With HW turnover knives

Product

Drawing



Machine

Application

Design

HW
TC05

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- 1 cutting edge parallel to cutter axis and peripheral cutting
- 1 plunging tip
- cutting material: HW TC05
- with attachment screw

Advantages

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck, adapter
- with attachment screw

Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z					PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
16	50	16	45	106	1+1					1			L	175714
16	50	25	55	116	1+1					1			L	175715
18	50	25	55	116	1+1					1	L	175717	L	175716

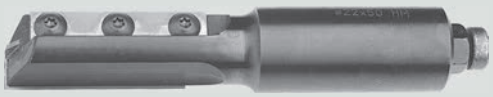
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			12	12	1.5	TC05		10	L	003080
Mini Turnover Knives			50	5.5	1.1	TC05		10	L	173483

Spare parts	Dimension [mm]	Suitable for	PU [pc.]	L	Order-No.
Clamping Wedges	B=50	175714, 175715	2	O	171111
Clamping Wedges	B=50	175717	2	O	171114
Clamping Wedges	B=50	175716	2	L	171113
Head Cap Screws	M3,5x5,5 T15	For all	10	L	168236
Round Head Screws	M4x5,9 T15	For all	10	L	167966
Screwdrivers	T15	For all	1	L	163161

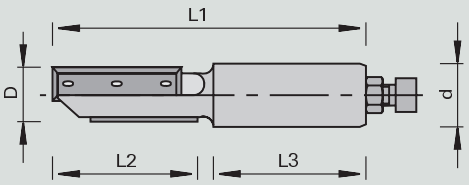
HW 2237 Shank-Type Cutters

With HW turnover knives

Product



Drawing



Machine

Application

Design

HW
TC05

Machine / Application

- CNC routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- cutting edges parallel to cutter axis in stepped design
- 1 plunging tip
- cutting material: HW TC05
- with attachment screw

Advantages

Notes

- Clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with attachment screw

Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
18	55	25	55	125	2	1	L	180906	L	177156
20	55	25	55	125	2	1	L		L	177157

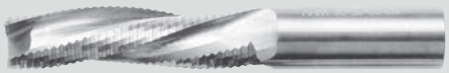
Turnover Knives	B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Turnover Knives HW with 2 cutting edges, end sharpened - 3 holes	50	12	1.7	TC05	10	L	179994

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

VHW 2265 Roughing Cutters

With negative spiral

Product



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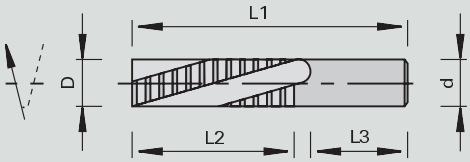


Machine

Application

Design

Machine / Application

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

Design

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

Advantages

- high hogging volume
- cutting pressure towards the bottom thanks to negative spiral

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

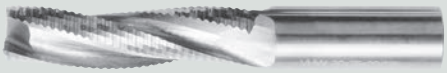
Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No.
12	42	12	45	90	3				1	L	178304
16	35	16	48	90	3				1	L	178311
16	55	16	48	110	3				1	L	178312
20	55	20	50	115	3				1	L	178320

VHW 2265-1 Roughing Cutters

With positive spiral

Product



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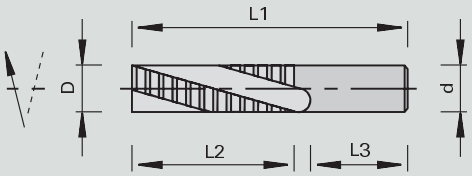


Machine

Application

Design

VHW

Machine / Application

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

Design

- positive spiral for tightly clamped workpieces face side down
- n max = 30,000 min-1

Advantages

- high hogging volume
- optimum upward chip evacuation thanks to positive spiral

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

Product features / Order information

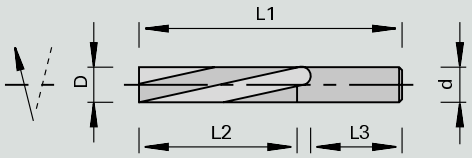
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No.
12	45	12	45	90	2				1	L	178302
10	30	10	40	75	2				1	L	178301
12	45	12	45	90	3				1	L	50811025
16	55	16	48	110	2				1	L	178313
16	35	16	48	90	3				1	L	178310
16	35	16	48	90	2				1	L	178309
14	55	14	45	110	3				1	L	178307
14	35	14	45	90	3				1	L	178305
16	55	16	48	110	3				1	L	50811408
18	55	18	48	115	3				1	L	178316
20	55	20	50	115	2				1	L	178318
20	55	20	50	115	3				1	L	50811031
20	75	20	50	135	3				1	L	50811032

VHW 2257 Finishing Cutters

With negative spiral

Product

Drawing



Machine

Application

Design

VHW

VHW

Machine / Application

- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

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

Advantages

- cutting pressure and chip evacuation towards the bottom thanks to negative spiral

Notes

- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

Product features

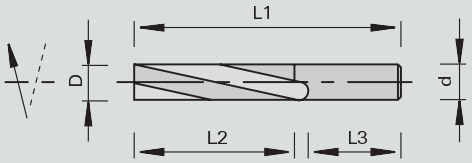
Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z					PU [pc.]	L	Order-No.
4.0	15	4,0	28	60	2					1	L	50811418
6.0	15	6,0	36	60	2					1	L	178327
8.0	30	8,0	36	75	2					1	L	50811421
10	30	10	40	75	2					1	L	178332
12	42	12	45	90	2					1	L	178335
12	42	12	45	90	3					1	L	178336
16	35	16	48	90	2					1	L	178342
16	35	16	48	90	3					1	L	178343
16	55	16	48	110	3					1	L	178347
20	55	20	50	115	3					1	S	178354
20	75	20	50	135	3					1	L	178356

VHW 2257-1 Finishing Cutters
with positive spiral

Product

Drawing



Machine

Application

Design

Machine / Application
- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design
- positive spiral for tightly clamped workpieces face side down
- n max = 30,000 min-1

Advantages
- optimal upward chip evacuation thanks to positive spiral

Notes
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

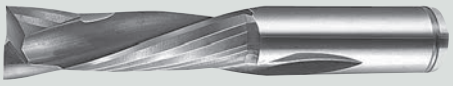
Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
6.0	15	6,0	36	60	2		1	L		L	50811419
8.0	30	8,0	36	75	2		1	L		L	50811034
10	30	10	40	75	2		1	L		L	50811036
12	42	12	45	90	2		1	L		L	50811037
12	42	12	45	90	3		1	L		L	50811424
16	55	16	48	110	2		1	L		L	178344
16	35	16	48	90	3		1	L		L	178341
16	35	16	48	90	2		1	S		S	178340
14	55	14	45	110	3		1	L		L	178339
14	35	14	45	90	3		1	L		L	178337
16	55	16	48	110	3		1	L	178348	L	50811432
18	55	18	48	115	3		1	L		L	178351
20	55	20	50	115	3		1	L		L	178353
20	75	20	50	135	3		1	L		L	178355

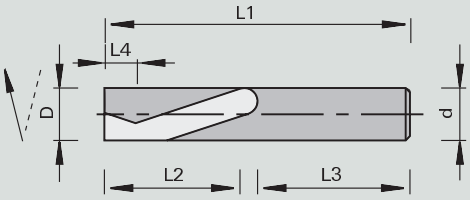
VHW 2257-2 Finishing Cutters

two-sided shear angle

Product



Drawing



Machine

Application

Design

VHW

Machine / Application

- CNC routers
- for finish cutting in solid woods and plastic
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- two-sided shear angle
- n max = 30,000 min-1

Advantages

- optimum cutting quality in laminated panels thanks to shear angle

Notes

- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

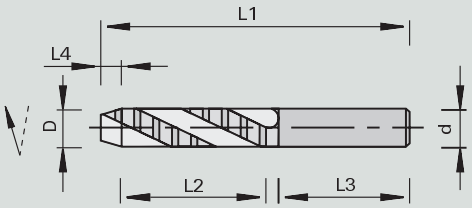
Product features / **Order information**

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No.
8.0	7.0	32	8,0	80	2+2				1	L	50811564
10	7.0	32	10	80	2+2				1	L	50811565
12	7.0	42	12	90	2+2				1	L	50811566
16	24	55	16	110	2+2				1	L	50811567

VHW 2268 Plunge Roughing Cutters
For door manufacturing

Product

Drawing



Machine / Application
- CNC machining centers
- for drilling of latchholes and keyholes

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

Advantages

Notes
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

Product features

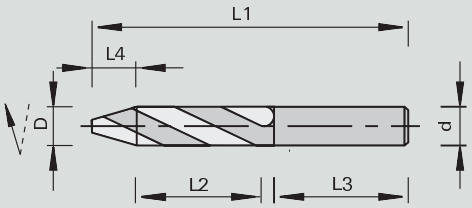
Order information

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
16	5.0	75	16	48	130	2			1	L	185831

VHW 2269 Plunge Finishing Cutters
For door manufacturing

Product

Drawing



Machine / Application
- CNC machining centers
- for drilling of peepholes and for through holes

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

Advantages

Notes
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck

Product features

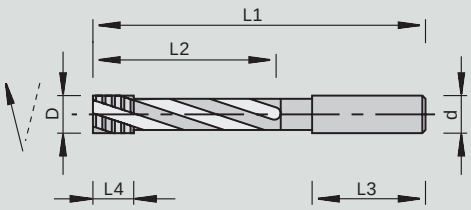
Order information

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
12	10	47	12	53	110	2			1	L	185826
12	10	70	12	50	130	2			1	L	185828
14	10	47	14	45	110	2			1	L	185829
16	11	52	16	60	130	2			1	L	185830

VHW 2254 Lock-Case Roughing Cutters
For door manufacturing

Product

Drawing



Machine

Application

Design

Machine / Application
- CNC machining centers
- for cutting of lock-cases in doors

Design
- positive spiral
- cutting edges with chip breakers
- roughing cutter

Advantages
- optimum chip evacuation thanks to positive spiral
- high balance quality thanks to cutting edges with chip breakers

Notes
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary
- surcharge for the mounting of Weldon tool holders

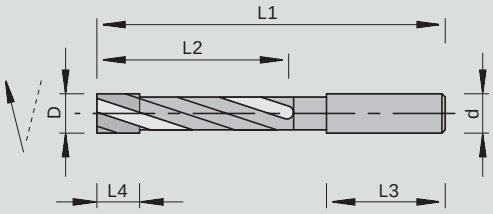
Product features / **Order information**

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	nmax [min-1]		PU [pc.]	L	Order-No.
16	25	115	16	50	175	3	24000		1	L	185836
18	25	115	20	50	175	3	24000		1	L	185837

VHW 2255 Lock-Case Finishing Cutters
For door manufacturing

Product

Drawing



Machine

Application

Design

Machine / Application
- CNC machining centers
- for cutting of lock-cases and face-plates in doors

Design
- positive spiral
- cutting edges with chip breakers
- serrated cutting edge with chip breakers

Advantages
- optimum chip evacuation thanks to positive spiral
- high balance quality thanks to cutting edges with chip breakers

Notes
- clamping elements: ps-System with intermediate sleeves, TRIBOS, draw-in collet chuck
- for attachment in horizontal boring-cutting aggregat (Homag, Weeke) side clamping surfaces are necessary
- surcharge for the mounting of Weldon tool holders

Product features / **Order information**

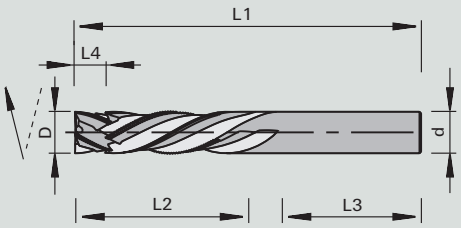
Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	nmax [min-1]		PU [pc.]	L	Order-No.
14	25	95	14	50	155	2	24000		1	L	185833
16	25	115	16	50	175	2	24000		1	L	185834

VHW 2270 Roughing / Finishing Cutter

for lightweight panels

Product

Drawing



Machine

Application

Design

VHW

MEC

Machine / Application

- CNC routers
- for sizing and grooving
- for milling of openings and contours
- particularly in many lightweight construction materials, e.g. honeycomb panels, plywood, composite panels with hard foam core
- for plunge cutting with feed in the direction of the Z, X or Y axis

Design

- special serration of the roughing knives
- alternating shear angle
- special tungsten carbide
- n max=24,000 min-1

Advantages

- optimum chip evacuation thanks to positive spiral
- high balance quality thanks to cutting edges with chip breakers

Notes

- clamping elements:we recommend hydro expansion chuck ps-System, TRIBOS or heat shrink-fit chuck

Product features

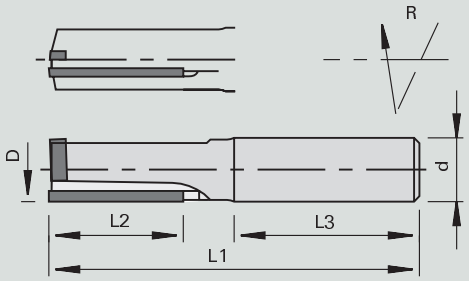
Order information

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
12	9	20	12	40	86	2+2		●	1	L	58187301 NEW
12	9	40	12	45	100	2+2		●	1	L	58187302 NEW

DP 3501 Shank-Type Cutters

Product

Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for jointing and sizing without overlap marks in wood-based panels, solid woods and plastics

Design

- polished face and high-finish clearance angle
- with HW plunge tip for diagonal plunge-cutting (travelling plunge-cut using Z and X axis)
- straight cutter axis
- solid tungsten carbide body for <= Ø 10 mm

Advantages

- high quality machining of MDF and hard woods
- no overlap-marks thanks to continuous cutting edge
- increased stability thanks to special design of brazing area

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Product features / Order information

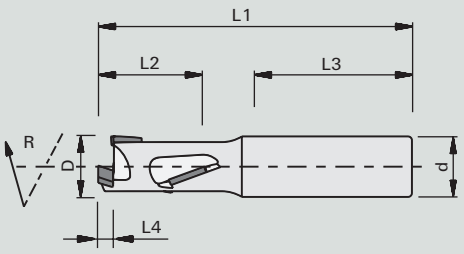
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	nmax [min-1]	Resharpening area [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
6.0	12	12	40	60	1	24000	0.2		1	L		L	183567
8.0	12	12	35	60	1	24000	0.5		1	L		L	178659
8.0	22	12	35	70	2	24000	0.5		1			L	187724 NEW
10	22	12	35	70	2	24000	1.2		1	L	186785	L	186784
12	25.4	12	35	70	1	24000	1.2		1	L		L	181102
16	25.4	16	45	85	1	24000	1.2		1	L		L	181104
16	35	16	45	95	1	24000	1.2		1	L		L	181106

DP 3502 Shank-Type Cutters

Z=1+1

Product

Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpenable several times
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to larger shear angle, alternating top and bottom
- smooth running thanks to special tool body
- Chip-free grooving possible from groove depths of 4.5 mm

Notes

- Feed rates up to 8 m/min
- recommended clamping elements: ps-System, TRIBOS, heat-shrinking chuck
- without thread for length adjusting screw! Specify in your order if required!

Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	Resharpening area [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
8	22	12	40	69	1+1	0.6	●	1			L	58186994 NEW
8.5	15	12	40	65	1+1	0.6	●	1			L	58187249 NEW
10	22	12	40	69	1+1	0.6	●	1			L	186789
12	22	12	40	69	1+1	0.8	●	1	L		L	186790
12	28	12	40	75	1+1	0.8	●	1	L	186793	L	186792
16	22	16	45	78	1+1	1.0	●	1			L	186794
16	28	16	45	83	1+1	1.0	●	1			L	186795
16	35	16	45	90	1+1	1.0	●	1	L	186797	L	186796
18	28	16	45	85	1+1	1.0	●	1			L	186798
18	28	20	45	95	1+1	1.0	●	1	L	186799	L	186800
18	35	16	45	92	1+1	1.0	●	1	L	186801	L	186802
18	35	20	55	102	1+1	1.0	●	1	L	186804	L	186803
18	43	16	45	100	1+1	1.0	●	1	L	186806	L	186805
18	43	20	55	110	1+1	1.0	●	1	L	58186808	L	58186807
20	35	20	55	102	1+1	1.0	●	1			L	186809
20	52	25	55	120	1+1	1.0	●	1	L	58186811	L	58186810
18	43	25	55	110	1+1	1.0	●	1	L	186913	L	186912 NEW

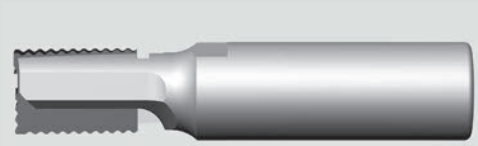
Product features / Order information

Ø D [inch]	L2 [inch]	Ø d [inch]	L3 [inch]	L1 [inch]	Z	Resharpening area [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
1/2″	1″	1/2″	1 3/8″	2 2/3	1+1	1.0	●	1			L	186791

DP 3511 High-Performance Roughing Shank-Type Cutters DP

for the machining of for solid core panels

Product



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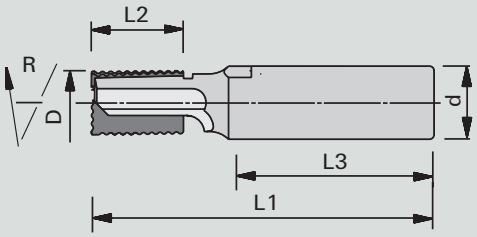


Machine

Application

Design

MEC

Machine / Application

- CNC routers
- for pre-sizing in roughing quality in wood-based materials, solid wood and plastic
- especially suited for the machining of plastic solid core panels (e.g. Trespa®, Corian®, Varicor®, LG-HiMacs, etc.)

Design

- high-performance tool for rough and finish milling
- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- n max=24,000 min-1

Advantages

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

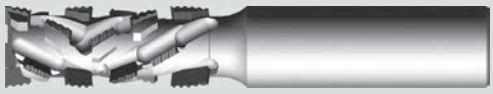
Product features

Order information

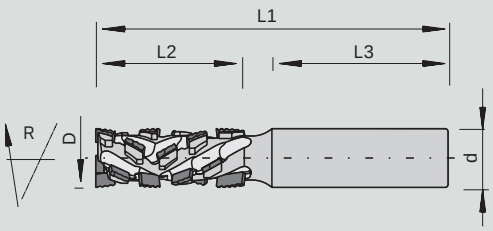
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
14	20	16	45	75	2+1			1	L	186579

DP 3510 Roughing Cutters DP

Product



Drawing



Machine

Application

Design

MEC

Machine / Application

- CNC routers
- for sizing in roughing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based materials or other abrasive materials such as GFRP, HPL-compact boards and several sandwich materials
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- resharpening area ≥ 2.0 mm
- n max=24,000 min-1

Advantages

- for long edge lives also in abrasive materials
- chip-free cutting edges on both sides
- high milling performance

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks “ps-System”, TRIBOS or heat shrink-fit chucks

Product features

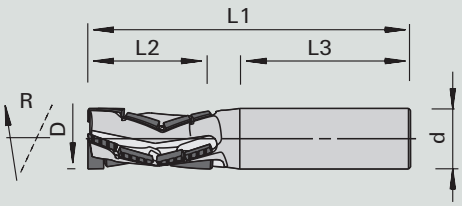
Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
20	50	20	60	120	2+2			1	L	185027

DP 3514 roughing/finishing cutters

Product

Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for sizing in almost finishing quality with chip-free cutting edges on both sides in solid woods and plywood, laminated wood-based panels and sandwich materials
- for cutting of cut-outs and contours
- traveling plunge cut using Z and X or Y axis

Design

- with alternating shear angle
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- resharpening area ≥ 1.6 mm
- n max = 30,000 min-1

Advantages

- for long edge lives also in abrasive materials
- chip-free cutting edges on both sides
- high hogging volume

Notes

- slightly rough cutting surface due to fine cut division
- clamping elements: we recommend the use of the tools in high precision clamping chucks such as hydro expansion chucks “ps-System”, TRIBOS or heat shrink-fit chucks

Product features / Order information

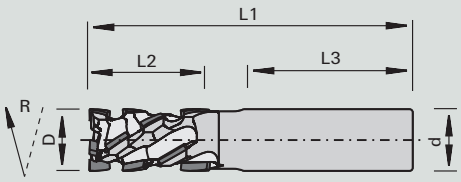
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	L/R		PU [pc.]	L	Order-No.
16	32	16	45	85	4 (2+2)	R		1	L	185498

DP 3503 High-Performance Shank-Type Cutters

Z=2+2

Product

Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for jointing, rabbeting, grooving and copying in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 1,2 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to 4-wing design of cutting edges
- very long edge lives, less cutting forces and less noise thanks to optimized tool body

Notes

- feed rates up to 20 m/min
- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

Product features / Order information

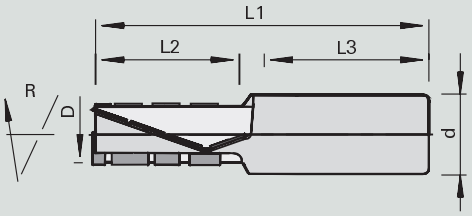
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z					PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
16	28	16	45	80	2+2				●	1			L	186147
16	38	16	45	90	2+2				●	1	L	186149	L	186148
20	28	20	55	95	2+2				●	1			L	186150
20	28	25	55	95	2+2				●	1	L	186152	L	186151
20	38	20	55	105	2+2				●	1			L	186153
20	38	25	55	105	2+2				●	1	L	186155	L	186154
20	48	20	55	115	2+2				●	1			L	186156
20	48	25	55	115	2+2				●	1	L	186158	L	186157
25	65	25	55	130	2+2				●	1	L	186160	L	186159

DP 3509 High-Performance Shank-Type Cutters

Tool body VHW - DP-Z= 3

Product

Drawing



Machine

Application

Design

v_f 60 m / min

MEC

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered wood-based materials

Design

- solid carbide design of tool body
- high-performance tool for rough and finish milling, as well as panel sizing with Nesting Technology
- with DP plunge tip
- face cutting for diagonal plunge-cutting
- feed speed up to 25 m/min
- resharpening area 2.0 mm
- n max=24,000 min-1

Advantages

- high cutting quality and smooth running thanks to spiral design of cutting edges
- optimum chip disposal thanks to open arrangement of cutting edges
- optimum cutting lengths suitable for most popular panel thicknesses

Notes

- clamping elements: ps-System, TRIBOS , draw-in collet chuck

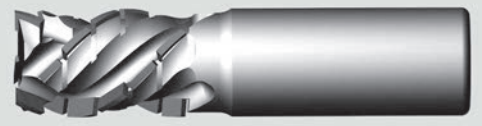
Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	H [mm]		PU [pc.]	L	Order-No.
12	21	16	45	73	3	16-19	●	1	L	181935
12	28	16	45	80	3	22-25	●	1	L	181936
12	30	16	45	82	3	28	●	1	L	181937

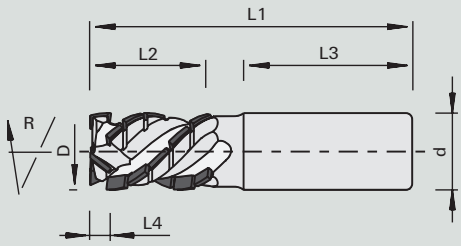
DP 3505 High-Performance Shank-Type Cutters

Z=3+3

Product



Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for sizing and dividing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels
- high-performance tool for pre- and finish-milling

Design

- with DP plunge tip for diagonal plunge-cutting
- with shear angle
- resharpening area 3.0 mm
- n max = 24,000 min-1

Advantages

- optimum cutting quality thanks to shear angle, alternating top and bottom
- smooth running thanks to spiral cut configuration

Notes

- feed rates up to 30 m/min
- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

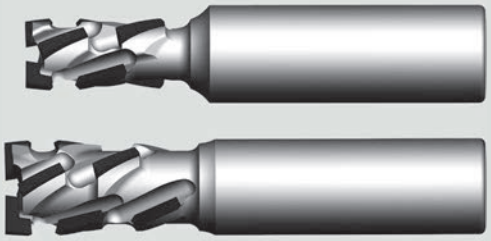
Product features / **Order information**

Ø D [mm]	L2 [mm]	L4 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
18	28	7	25	55	95	3+3		●	1	S	186665	S	186118
20	38	7	20	55	105	3+3		●	1	S	186666	S	186119
25	28	7	25	55	95	3+3		●	1	L	186121	L	186120
25	38	7	25	55	105	3+3		●	1	L	186123	L	186122
25	48	7	25	55	115	3+3		●	1	L	186125	L	186124

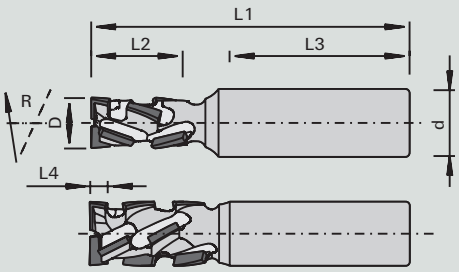
DP 3513 High-Performance Shank-Type Cutters CM

For Nesting - Z=2+2

Product



Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for panel sizing with Nesting Technology
- for jointing, rabbeting and *grooving (*negative design)
- particularly for processing MDF panels and Multiplex

Design

- with DP plunge tip
- face cutting for diagonal plunge-cutting
- Ø D=12 mm with highly stiff tool body
- resharpening area 1.6 mm
- n max = 24,000 min-1

Advantages

- high cutting quality and high-quality cutting edges on both sides thanks to specially adapted arrangement of cutting edges
- positive spiral: optimum upward chip evacuation towards the dust extraction
- negative spiral: downward chip evacuation and cutting pressure
- negative spiral especially suitable for smaller or narrow workpieces and for grooving
- Z=2+2 = bigger gullets for better chip removal (MDF) and for reducing heat generation, particularly when processing Multiplex

Notes

- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw
- in case of higher feed rates and thicker boards choose the higher diameter
- adapt the cutting length to the panel thickness (H)
- * indicate "H" in case of Nesting with protection board

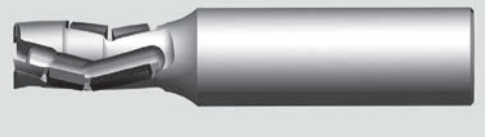
Product features / Order information

Ø D [mm]	L2 [mm]	L4 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	H [mm]	Helical direction		PU [pc.]	L	Order-No.
12	22		16	45	75	2+2	16-19 *	positive	●	1	L	187075
12	22	4.5	16	45	75	2+2	-19	negative	●	1	L	187076
16	28	4.5	16	45	80	2+2	-25	negative	●	1	L	187077

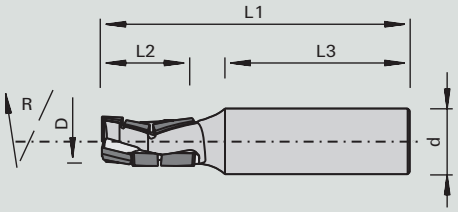
DP 3506 High-Performance Shank-Type Cutters CM

For Nesting - Z=3+3

Product



Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for panel sizing with Nesting Technology
- for jointing, rabbeting and *grooving (*negative version) in raw and laminated wood-based materials

Design

- with DP plunge tip
- face cutting for diagonal plunge-cutting
- feed rates up to 25 m/min
- resharpening area 1,6 mm
- n max = 30,000 min-1

Advantages

- high cutting quality and high-quality cutting edges thanks to specially adapted cutting edge configuration
- positive spiral: optimum upward chip evacuation towards the exhaustion
- negative spiral: downward chip evacuation and cutting pressure
- negative spiral especially for smaller or narrow workpieces and for grooving

Notes

- clamping elements: use in high-precision clamping elements recommended (e.g. TRIBOS, ps-System)
- with thread for length adjusting screw
- in case of higher feed rates and thicker boards choose the higher diameter
- adapt the cutting length to the panel thickness (H)
- * indicate "H" in case of Nesting with protection board

Product features / Order information

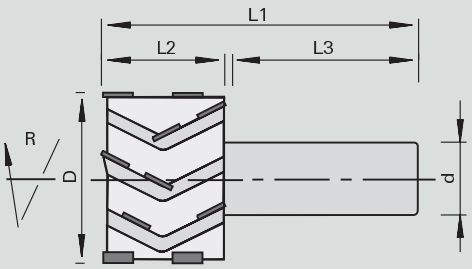
Ø D [mm]	L2 [mm]	L4 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	H [mm]	Helical direction		PU [pc.]	L	Order-No.
12	22		16	45	75	3+3	16-19 *	positive	●	1	L	58186571
14	33	7.2	16	45	85	3+3	-30	negative	●	1	L	187282
12	23	7.2	16	45	75	3+3	-19	negative	●	1	L	187281
16	28		16	45	80	3+3	22-25 *	positive	●	1	L	186574
16	22		16	45	75	3+3	16-19 *	positive	●	1	L	186573
12	28		16	45	80	3+3	22-25 *	positive	●	1	L	186572
16	28	7.2	16	45	80	3+3	-25	negative	●	1	L	50811803

DP 3507 High-Performance Trimming Router Bits

Z=4+2+4

Product

Drawing



Machine

Application

Design

Machine / Application

- CNC routers
- for sizing cuts in raw, melamine-, paper-, HPL-laminated, foiled and veneered panels

Design

- high-performance tool for finish cuts
- with shear angle
- resharpening area 3.0 mm

Advantages

- high feed rates (up to 35 m/min) and good edge quality thanks to 4 cutting edges working in top layer
- minimized formation of dust thanks to 2 cutting edges working in core of board
- very good surface thanks to large cutting circle diameter
- good cutting quality on top and bottom edge thanks to opposing shear angle

Notes

- preferably for finish-cut operations on pre-sized workpieces
- clamping elements: ps-System, TRIBOS , draw-in collet chuck
- with thread for length adjusting screw

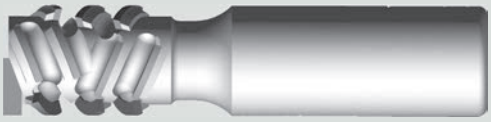
Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	H [mm]			PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
48	22	25	62	85	4+2+4	16-19		●	1	C	186139	L	186140
48	28	25	62	91	4+2+4	22-25		●	1	C	186141	L	186142
48	35	25	62	98	4+2+4	28-32		●	1	C	186143	L	186144
48	48	25	55	110	4+2+4	35-45		●	1	L	186146	L	186145

DP 3600 p-System High-Performance Shank-Type Cutters

Z=1+1 / Z=2+2

Product



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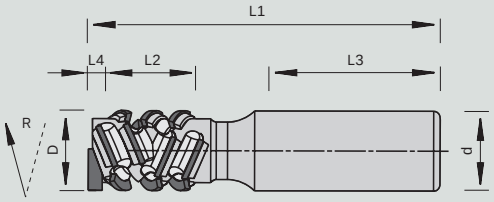


Machine

Application

Design

Machine / Application

- CNC stationary machines
- for chip-free high-performance jointing and dividing of solid woods (free of knots) along and accross the grain
- for jointing and dividing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- extremely scoring cut
- DP plunge tip
- resharpening area 2.5 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- chip-free cuts even on the exit side
- perfectly suitable for laser-edge-technology

Notes

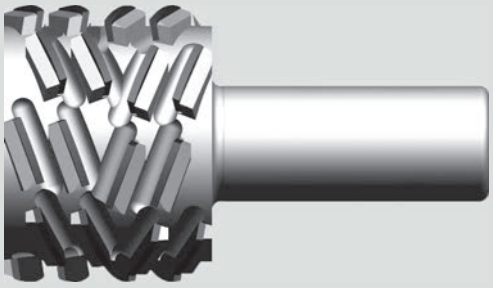
- adjust the tool to run centrally to the workpiece
- Tools with plunge tip must project at least 4,5 mm on bottom side of workpiece in order to bring p-System cutting edges into action. D 30 is without plunge tip
- for ramping or circular plungeing only
- recommended feed rate per tooth: wood-based panels 0.3 - 0.35 mm, solid wood 0.15 - 0.2 mm
- clamping element: precision clamping element e.g. ps-System, TRIBOS
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Product features / Order information

Ø D [mm]	L4 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	H [mm]		PU [pc.]	L	Order-No. [R]
20	3.8	29,5	25	55	110	1+1	26,5		1	L	50184380
25	3.8	48	25	55	130	2+2	45		1	L	50184384

DP 3610 p-System High-Performance Jointing Shank-Type Cutters

Product



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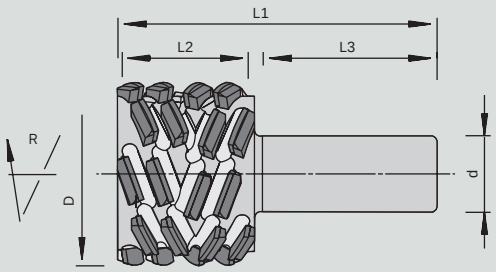


Machine

Application

Design

Machine / Application

- CNC stationary machines
- for chip-free high-performance jointing of solid woods (free of knots) along and accross the grain
- for jointing of melamine-, paper-, HPL-laminated, foiled and veneered panels and lacquered surfaces
- Finish-quality in the case of fiber materials such as fabric-laminated panels, linoleum with jute fibers, cork etc.

Design

- symmetrical design
- non-convex design
- extremely scoring cut
- resharpening area 4 mm

Advantages

- maximum cutting quality and edge lives
- large depth of cut possible
- chip-free cuts even on the exit side
- perfectly suitable for laser-edge-technology

Notes

- with thread for length adjusting screw
- recommended feed rate per tooth: wood-based panels 0.55 mm, solid wood 0.28 mm
- crowned design on request
- clamping element: precision clamping element e.g. ps-System, TRIBOS
- sense of rotation according to VDMA 8849

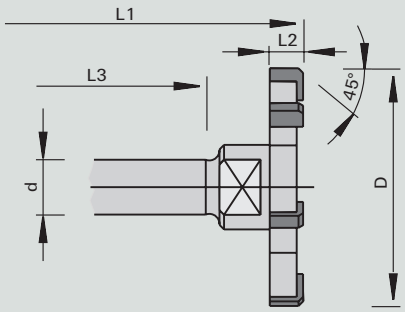
Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No. [R]
60	38	25	57.4	105	3+3	symmetrical		1	L	50184083

HW 1594 Planing Cutters
Z=6

Product

Drawing



Machine

Application

Design

HW TC05

MAN

MEC

Machine / Application
- CNC machines
- portable routers
- for plain milling of top layers, edge bands, etc. on solid woods and wood-based materials

Design
- cutting: HW-tipped, with side chamfer
- manual feed

Advantages

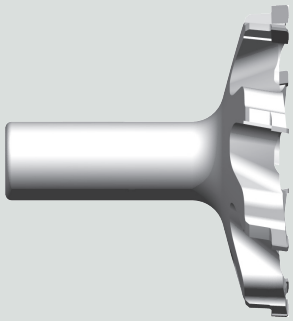
Notes

Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	PU [pc.]	L	Order-No.
52	7	12	40	60	6	1	O	50811814

DP 3508 Planing and Rabbeting Shank-Type Cutters

Product



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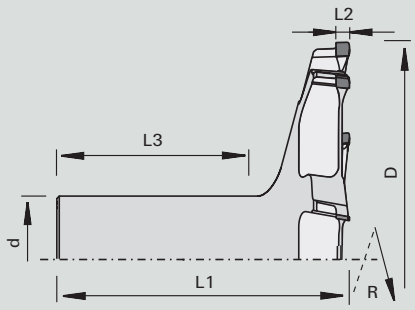


Machine

Application

Design

Machine / Application
- CNC routers
- for planing, rabbeting and panel raising in wood-based panels

Design
- cutting material: DP
- resharpening area 3,5 mm

Advantages
- high milling performance when dressing the workbench boards, e.g. with Nesting technology
- smooth surface thanks to special cutting edge geometry

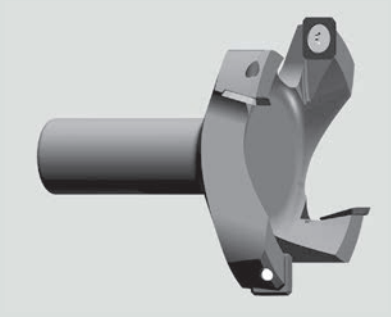
Notes
- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	nmax [min-1]	PU [pc.]	L	Order-No.
100	5,6	25	59.3	90	8	24000	1	S	50811708

HW 5572 Planing and Rabbeting Shank-Type Cutterhead

Product



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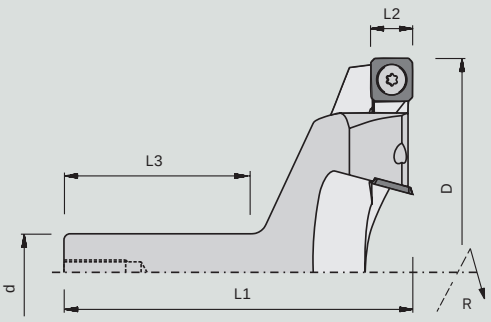


Machine

Application

Design

MEC

Machine / Application

- CNC routers
- for planing, rabbeting and panel raising in wood-based materials

Design

- cutting material: TC25

Advantages

- high milling performance when dressing the workbench boards, e.g. with Nesting Technology
- smooth surface thanks to special cutting edge geometry

Notes

- with thread for length adjusting screw
- sense of rotation according to VDMA 8849

Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	nmax [min-1]	PU [pc.]	L	Order-No.
100	14	25	55	96	4	15200	1	L	182620

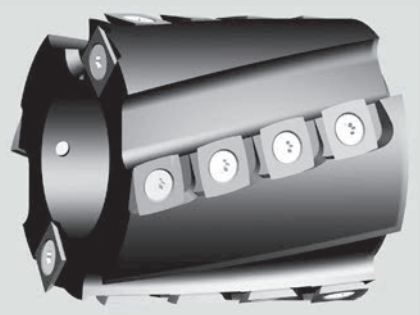
Turnover Knives	B [mm]	H [mm]	S [mm]	PU [pc.]	L	Order-No.
Profile Turnover Knives HW with 4 cutting edges and radius - Ledinek Rotoles	14	14	2.0	10	L	182441

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Screwdrivers with sliding handle for Torx	T20x100	1	L	166092
Countersunk Screws - with Torx	M5x6 T20 D=Ø9,3	10	L	176199

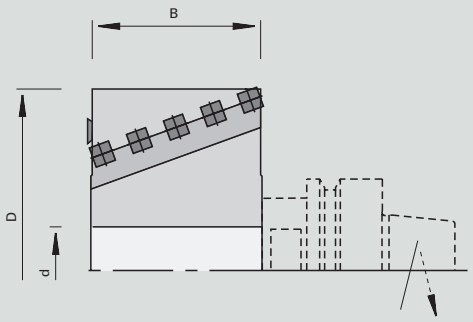
HW 5575 Spiral Cutterheads

with HW turnover knife

Product



Drawing



Machine

Application

Design

HW TCw25

MEC

Machine / Application

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

Design

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

Advantages

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

Notes

- for HSK mounting arbors with double key without spacer
- for Ident-No. 58665105 clamping length 50 mm with HSK63 mounting arbor 183748 + screw 173592
- for Ident-No. 58665106 clamping length 80 mm with HSK63 mounting arbor 183749 + screw 173592

Product features / Order information

Ø D [mm]	B [mm]	Ø d [mm]	Z	nmax [min-1]						PU [pc.]	L	Order-No.
80	80	30	2+2+v2	18000					●	1	L	58665105
80	100	30	2+2+v2	18000					●	1	L	58665106

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Spurs			14	14	2.0	TCw30		10	L	003079

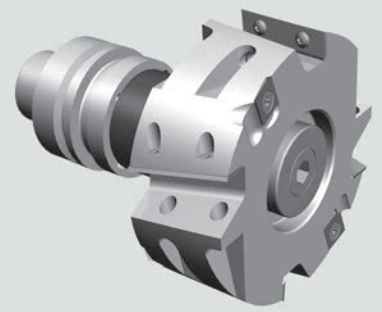
Accessories	Dimension [mm]		PU [pc.]	L	Order-No.
Mounting arbors with HSK shank	Ø30x50xHSK 63F		1	L	183748
Mounting arbors with HSK shank	Ø30x80xHSK 63F		1	L	183749

Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Countersunk Screws with collar 6 mm	M5x15,5 T20 D=Ø8,5		10	L	182112
Screwdrivers	T20x100		1	L	166092
Countersunk Screws	M5x6 T20 D=Ø9,3		10	L	176199

HW 5576 Jointing and rabbeting cutterheads

mounted on mounting arbor HSK63F

Product



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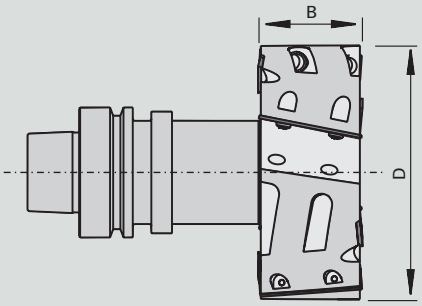


Machine

Application

Design

HW TC06

MEC

Machine / Application

- CNC milling machines
- for chip-free grooving and rabbeting in solid wood and wood-based materials
- for laminated, uncoated and glued solid wood and strongly wearing wood

Design

- with alternating shear angles for pulling cut
- cutting material: HW TC06
- Body made of high-tensile aluminum
- with 2 upper and 2 lower spurs each

Advantages

- optimum cutting quality

Notes

- mounted on mounting arbor HSK63F including spacer

Product features / **Order information**

Ø D [mm]	B [mm]	Ø d [mm]	Z	DKN [mm]	nmin-nmax [min-1]		PU [pc.]	L	Order-No. [L]
125	50	30	2+2 V2+2	8x3,3	10600		1	L	58665108

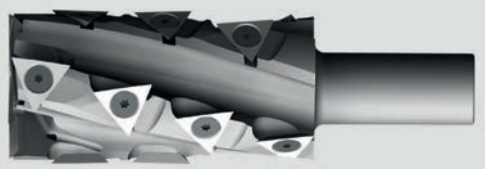
Turnover Knives		B [mm]	H [mm]	S [mm]	Cutting material	PU [pc.]	L	Order-No.
Spurs		14	14	2.0	TCw30	10	L	003079
Turnover knives		50	12	1.5	TC06	10	L	178289

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Screwdrivers	T20x100	1	L	166092
Screwdrivers	T15x80	1		171188

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
5576 Jointing and rabbeting cutterhead	125x50x30 Z2+2 V2+2 DKN8x3	1	S	58665107
Mounting arbors with HSK shank	Ø30x80xHSK 63F	1	L	183749
Countersunk Screws	M5x6 T20 D=Ø9,3	10	L	176199
Round Head Screws	M3,5x12 T15	10	L	171067

HW 3520 Shank-Type Cutters with HW Turnover Knives - t3-System

Product



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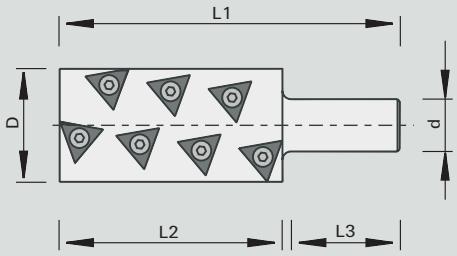


Machine

Application

Design

MEC

Machine / Application

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

Design

- Rounded triangular turnover knives with cutting edges drawing from bottom to top and from top to bottom

Advantages

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

Notes

- spiral plunge-cutting, pockets larger than Ø 60
- feed rate per tooth fz = 0.2-0.5 mm

Product features / Order information

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	Number of cutting edges [pc.]		PU [pc.]	L	Order-No.
54	63	25	52	120	2+2	12		1	L	58187299
54	78	25	52	133.5	2+2	14		1	L	58187300
54	106,5	25	52	162.5	2+2	18		1	L	58187113

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives HW with 3 cutting edges and countersink - with rounded edges			20,88	18.3	3.0	TCw20		10	L	187251
Turnover Knives HW with 3 cutting edges and countersink - with rounded edges			20,88	18.3	3.0	TC06		10	L	187692 NEW
Turnover Knives HW with 3 cutting edges and countersink - with rounded edges			20,88	18.3	3.0	HL Solid 20 topcoat		10	L	187694 NEW
Turnover Knives HW with 3 cutting edges and countersink - with rounded edges			20,38	17.9	3.0	TCw20		10	O	9209773 NEW

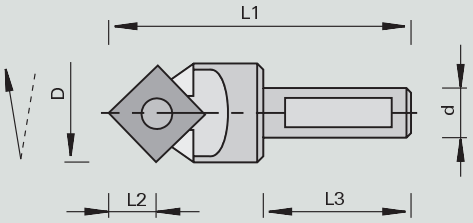
Accessories	Dimension [mm]		PU [pc.]	L	Order-No.
Screwdrivers	T15x80		1		171188
Countersunk Screws	M5x10,8 T15 D=Ø9,4		10	L	180840

HW 1591 Ornamental Groove Cutters

with HW turnover knife

Product

Drawing



Machine

Application

Design

HW
TC05

MAN

Machine / Application

- portable routers
- CNC routers
- for cutting of ornamental grooves, inscriptions and engravings in solid woods and wood-based panels

Design

- with negative shear angle
- cutting material: HW TC05

Advantages

- chip-free cutting of laminated panels thanks to negative shear angle

Notes

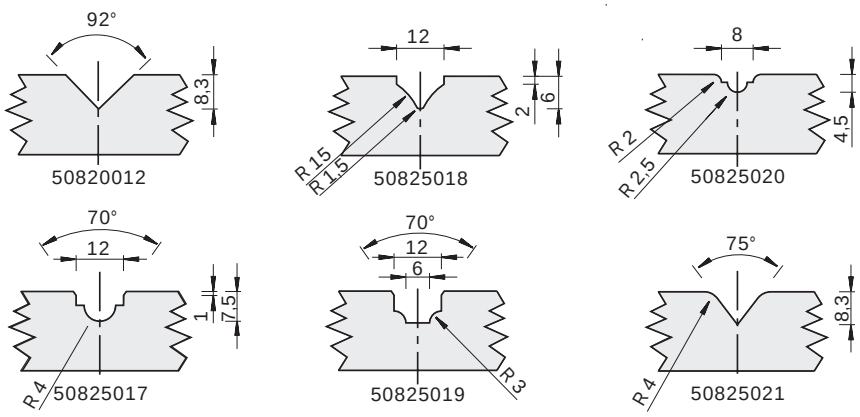
- clamping elements: ps-System, draw-in collet chuck
- included in delivery: Order-No. 58186880 cutter with TOK Order-No. 50820012 or "Set" Order-No. 50811728: 1 piece ornamental shank-type groove cutter Order-No. 50811713 and 2 pieces profile knives (Order-No. and drawing as pictured)

Product features — **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No.
						Set			1	&	50811728
17	8,3	10	40	67	1				1	L	186880

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives HW with 4 cutting edges			12	12	1.5	TC05		10	L	003080
Profile Knives HW for Ornamental Groove Cutterheads			11	12	1.5	TC05		10	L	171172
Profile Knives HW for Ornamental Groove Cutterheads			11	12	1.5	TC05		10	L	171173
Profile Knives HW for Ornamental Groove Cutterheads			11	12	1.5	TC05		10	L	171175
Profile Knives HW for Ornamental Groove Cutterheads			12	12	1.5	TC05		10	L	171216
Profile Knives HW for Ornamental Groove Cutterheads			12	12	1.5			10	L	171177

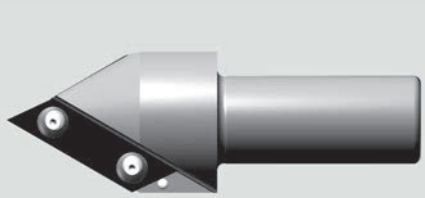
Spare parts	Dimension [mm]				PU [pc.]	L	Order-No.
Head Cap Screws	M3,5x6,5 T15				10	L	163223
Screwdrivers	T15				1	L	163161



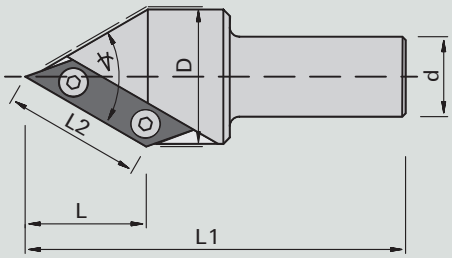
HW 5573 Folding Chamfering Cutterhead

Z=1

Product



Drawing



Machine

Application

Design

MEC

Machine / Application

- CNC 5-axis routers
- for picking of internal corners and for chamfering, for the cutting of ornamental grooves and folding cuts in solid wood and wood-based materials

Design

- with shank
- n max=15,000 min-1

Advantages

Notes

- please order adapters separately
- clamping elements: ps-System, TRIBOS, heat-shrinking chuck, draw-in collet chucks

Product features / **Order information**

Wedge◁ [°]	Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	PU [pc.]	Order-No.
60	41.5	41,3	25	55	118	1	1	185138

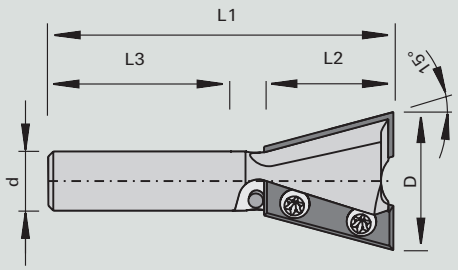
Turnover Knives	B [mm]	H [mm]	S [mm]	PU [pc.]	L	Order-No.
Turnover Knives HW with 2 cutting edges, edge bevel for scribing cutterheads	50	12	1.5	10	L	185140

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Round Head Screws	M3,5x4 T15	10	L	168893
Screwdrivers	T15	1	L	163161

HW 1521 Dovetail Cutterheads
with chamfer angle 15°

Product

Drawing



Machine

Application

Design

HW TCw05

MAN

MEC

Machine / Application
- portable routers
- CNC machines
- milling of dovetail connections and for special work during Corian® processing
- for chamfering of 15°

Design
- body with 2 HW turnover knives with chamfer on both sides
- stop pin for a trouble-free knife change
- for manual and mechanical feed
- chamfer 15°

Advantages

Notes

Product features

Order information

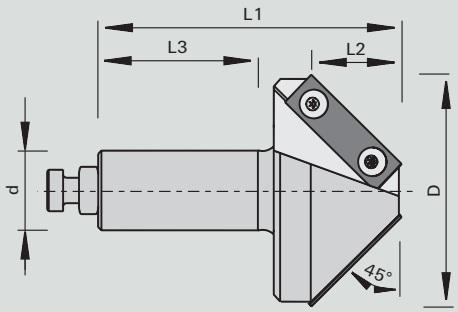
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z					PU [pc.]	L	Order-No.
28	26	12	40	70	2					1	O	50811817

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			27	9	1.5	TCw05		10	S	50811818

HW 1522 Chamfering Cutterheads
Z=2

Product

Drawing



Machine

Application

Design

HW TC05

MEC

Machine / Application
- conventional routers
- CNC machines
- for chamfering of wood-based materials and panel materials

Design
- body with 2 HW turnover knives
- peripheral cutting only
- chamfer 45°
- mechanical feed

Advantages

Notes

Product features

Order information

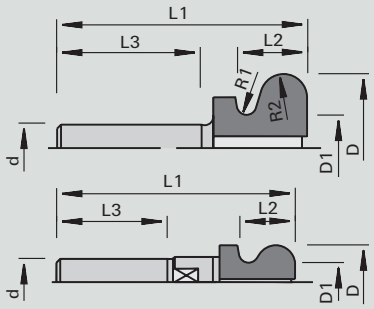
Ø D [mm]	Ø D1 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No.
74	17	28	25	55	95	2				1	O	50811819

Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Turnover Knives			50	12	1.5	TC05		10	L	003085

HW 1520 Cutters for recessed grips
Z=2

Product

Drawing



Machine

Application

Design

HW TC05

MAN

MEC

Machine / Application

- for cutting of hidden handle bars in solid woods, wood-based materials, and panels
- in a single operation, the complete handle bar on the drawer front and the door edges can be manufactured

Design

- two axially parallel cutting edges
- peripheral cutting and face cutting
- righthand rotation
- manual feed

Advantages

Notes

- other shank diameters upon request

Product features

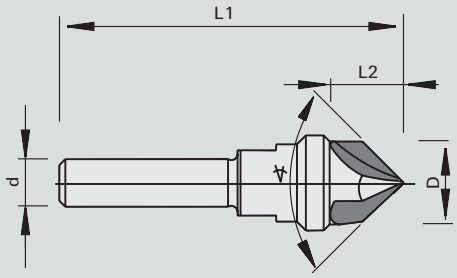
Order information

Ø D [mm]	R1 [mm]	R2 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z		PU [pc.]	L	Order-No.
19	2.5	5	14,5	12	25	60	2		1	O	50811815
38	2.5	6	18	12	25	63	2		1	O	50811816

HW 1593 V Groove Letter Cutters
Z=3

Product

Drawing



Machine

Application

Design

HW TC05

MAN

Machine / Application

- portable routers
- CNC machines
- for milling of V grooves, ornamental grooves, letters and for chamfering of hard wood, wood-based materials and panels

Design

- solid carbide cutters with 3 HW cutting edges
- righthand rotation
- manual feed

Advantages

Notes

- cutter with angle 90°, suitable for countersinking of bores

Product features

Order information

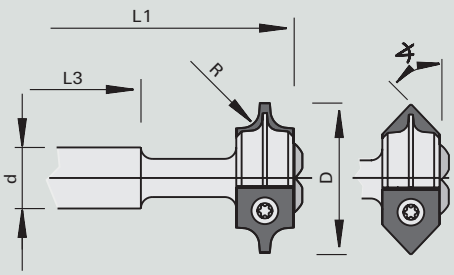
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	∢ [°]	L1 [mm]	Z			PU [pc.]	L	Order-No.
14	16,5	12	25	60	62.5	3			1	O	50811812
14	12,5	12	25	90	62.5	3			1	O	50811813

HW 1523 Rounding Chamfering Cutterheads Set Z=2

Set in a wooden box

Product

Drawing



Machine

Application

Design

HW
TC05

MEC

Machine / Application

- CNC machines
- for rounding of one or both sides and chamfering of panel materials

Design

- body with 2 HW turnover knives
- righthand rotation
- mechanical feed

Advantages

Notes

- in the same body, the rounding knives with different radii or chamfering knives 45° can be used.

Product features

Order information

	Ø D1 [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z	Type		PU [pc.]	L	Order-No.
1 body size 1 2 pieces of each rounding knife R2 / R3 / R4 / R5 2 chamfering knives 45°	27	6	16	60	100	2	Set 1		1	L	50811820
1 body size 2 2 pieces of each rounding knife R6 / R8 / R10 / R12 2 chamfering knives 45°	47.8	9	20	55	120	2	Set 2		1	O	50811821

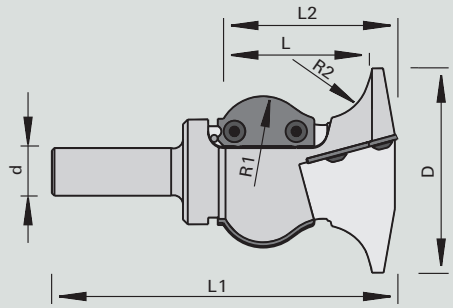
Turnover Knives			B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Rounding knives	R= 2 mm		15	18	2.0	TC05		6	S	50811822
Rounding knives	R= 3 mm		15	18	2.0	TC05		6	S	50811823
Rounding knives	R= 4 mm		15	18	2.0	TC05		6	S	50811824
Rounding knives	R= 5 mm		15	18	2.0	TC05		6	S	50811825
Chamfering turnover knife	Chamfer 45°		15	18	2.0	TC05		6	S	50811826
Rounding knives	R= 6 mm		30	25	2.0	TC05		6	S	50811827
Rounding knives	R= 8 mm		30	25	2.0	TC05		6	S	50811828
Rounding knives	R= 10 mm		30	25	2.0	TC05		6	S	50811829
Rounding knives	R= 12 mm		30	25	2.0	TC05		6	S	50811830
Chamfering turnover knife	Chamfer 45°		30	25	2.0	TC05		6	S	50811831

HW 1524 Handrail cutterheads

Z=2+2

Product

Drawing



Machine

Application

Design

HW
TCw05

MEC

Machine / Application

- CNC machines
- for profiling of handrails for stairs and railings made of solid wood

Design

- body with 2+2 HW turnover knives
- with shear angle
- peripheral cutting and face cutting
- mechanical feed

Advantages

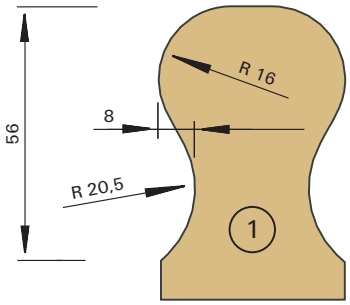
Notes

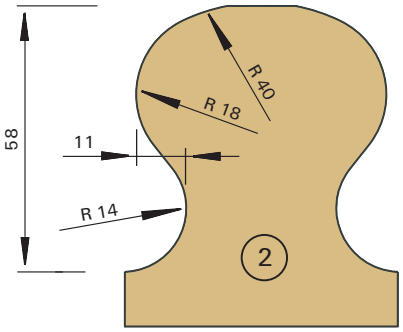
Product features

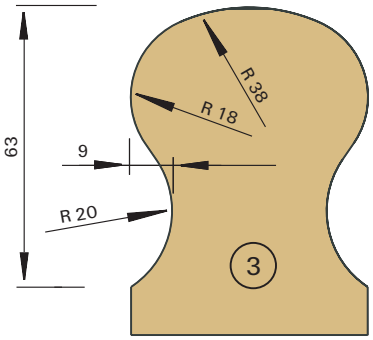
Order information

Profile	Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
1	90	76	20	62	145	2+2			1	O	50811832
2	90	76	20	59	145	2+2			1	O	50811833
3	90	76	20	63	145	2+2			1	O	50811834

Turnover Knives		Profile	B [mm]	H [mm]	S [mm]	Cutting material		PU [pc.]	L	Order-No.
Profile Knives		1 oben	40	25	2.0	TCw05		2	S	50811835
Profile Knives		1 unten	40	50	2.0	TCw05		2	S	50811836
Profile Knives		2 oben	40	50	2.0	TCw05		2	S	50811837
Profile Knives		2 unten	40	25	2.0	TCw05		2	S	50811838
Profile Knives		3 oben	40	25	2.0	TCw05		2	S	50811839
Profile Knives		3 unten	40	50	2.0	TCw05		2	S	50811840



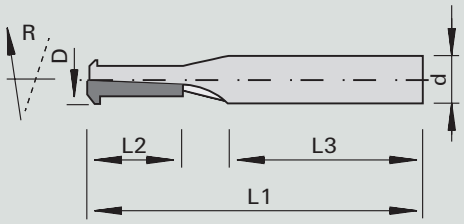




HW 3512 Profile Grooving Shank-Type Cutters HW - for Lamello Clamex P®

Product

Drawing



Machine

Application

Design

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

- HW-tipped
- disposable tool

Advantages

- problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with D Ø100.4 mm)

Notes

- depending on the type of work-piece, a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

Product features

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z
10	20	10	40	70	1

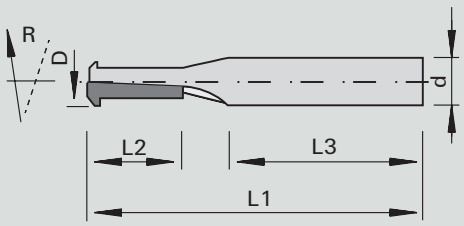
Order information

	PU [pc.]	L	Order-No. [L]
	1	L	185368

VHW 3519 Profile Grooving Shank-Type Cutters VHW - for Lamello Clamex P®

Product

Drawing



Machine

Application

Design

LONG LIFE

VHW

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

- Massive solid tungsten carbide
- Spiral design Z=2
- TC 104 topcoat coating
- Disposable tool
- Not resharpenable

Advantages

- High rigidity = low vibration even with difficult materials
- Low cutting pressure and good cutting quality thanks to spiral design
- Hard coating and additionally low coefficient of friction for longer edge life

Notes

Product features

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z
9.8	23	12	36	80	2

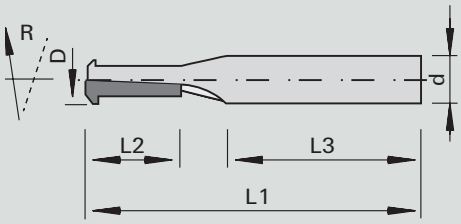
Order information

	PU [pc.]	L	Order-No. [L]
	1	L	186879

DP 3518 Profile Grooving Shank-Type Cutters DP - for Lamello Clamex P®

Product

Drawing



Machine

Application

Design

MEC

Machine / Application

- 5-axis CNC machines
- for the milling of Lamello Clamex P® profile grooves
- particularly for profile grooves to be cut into the panel surface further away from the panel edge and if the housing of the angular aggregate does not allow the use of Lamello Clamex P® bore type tool

Design

- DP-tipped
- disposable tool

Advantages

- problem solution if space problems occur with angular aggregates (touching of the panel with the aggregate's bottom side when using bore-type cutters with DØ100.4 mm)

Notes

- depending on the type of work-piece, a pre-grooving operation with a negative solid carbide finishing spiral cutter can make sense (reduced risk of chipping of sensitive laminations) resp. reduces the cutting pressure when milling the profile grooves

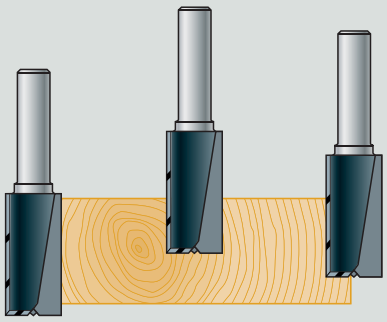
Product features

Order information

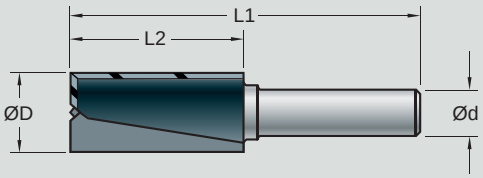
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]	Z				PU [pc.]	L	Order-No. [L]
10	20	12	40	70	1				1	L	185703

HW HW groove cutter
with plunge tip

Product



Drawing



Machine

Application

Design

MAN

Machine / Application
- Hand routers
- for jointing, rabbeting and grooving in solid woods and wood-based panels

Design
- with straight cut
- cutting material: HW

Advantages
- smooth and clean ground cutting

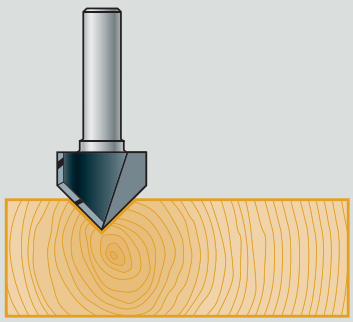
Notes
- for tool holder with collet chuck
- the basic cutting edge allows plunging into the workpiece

Product features / **Order information**

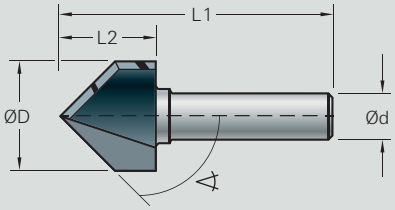
Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
3	15	8	58	2	VHW		1	L	58502110
4	15	8	58	2	VHW		1	L	58502111
5	19	8	64	2	VHW		1	L	58502112
6	25	8	62	2			1	L	58502113
8	20	8	70	2			1	L	58502009
8	30	8	90	2			1	L	58502116
10	32	8	90	2+1			1	L	58502119
12	25	8	59	2+1			1	L	58502121
12	38	8	90	2+1			1	L	58502122

HW HW-V-Grooving cutter

Product



Drawing



Machine

Application

Design

MAN

Machine / Application
- Hand routers
- For beveling and making recessed of V-grooves in wood and panel materials

Design
- Cutting material: HW
- with rabbeting

Advantages

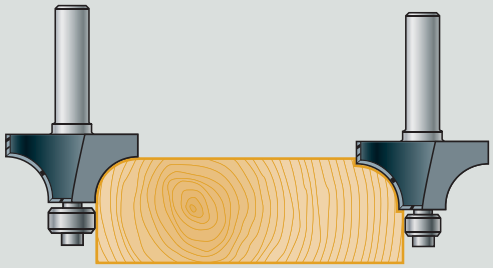
Notes
- bores are possible
- for tool holder with collet chuck

Product features / **Order information**

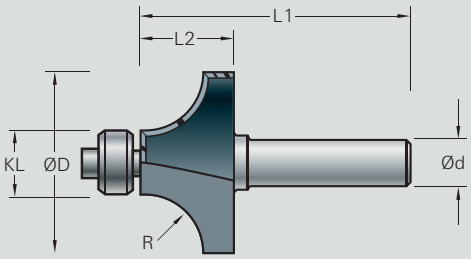
Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Chamfer◁ [°]	Z		PU [pc.]	L	Order-No.
19	16	8	51	45	2		1	L	58502261

HW HW-Rounding cutter / HW-Quarter-round cutter
with bearing

Product



Drawing



Machine

Application

Design

MAN

Machine / Application
- Hand routers
- For rounding solid wood, laminated and not laminated panels

Design
- Cutting material: HW
- with straight cut

Advantages
- peripheral and face cutting edge
- radius with runout

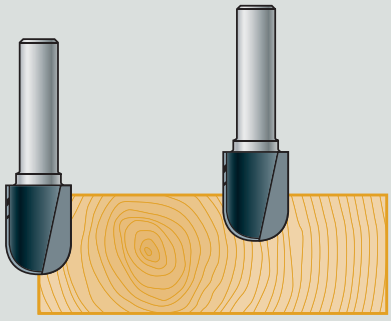
Notes
- for tool holder with collet chuck

Product features / **Order information**

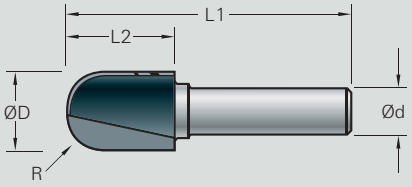
Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
16.7	19	6	49	2	12,7		1	L	58512078
18.7	10	6	51	2	12,7		1	L	58512090
14.7	8	8	51	2	12,7		1	L	58512087
15.7	8	8	50	2	12,7		1	L	58512088
16.7	9	8	49	2	12,7		1	L	58512089
18.7	10	8	51	2	12,7		1	L	58512096
20.7	11	8	54	2	12,7		1	L	58512097
22.7	12	8	54	2	12,7		1	L	58512098
24.7	13	8	55	2	12,7		1	L	58512099
28.7	16	8	57	2	12,7		1	L	58512100
32.7	17	8	59	2	12,7		1	L	58512101

HW HW-Concave cutter
Extended cut

Product



Drawing



Machine

Application

Design

MAN

Machine / Application
- Hand routers
- for milling of coves in solid wood and panel materials

Design
- Cutting material: HW
- with straight cut

Advantages
- deeper profiles are possible

Notes
- plunging is possible
- for tool holder with collet chuck

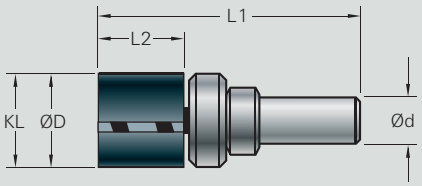
Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z	R [mm]		PU [pc.]	L	Order-No.
10	20	8	54	2	5		1	L	58502299
12	20	8	54	2	6		1	L	58502288

HW HW-Edge-Cutter
with open radial bearing

Product

Drawing



Machine | Application | Design

MAN

Machine / Application
- Hand routers
- for jointing of solid wood, laminated panel materials, MDF, etc.

Design
- Cutting material: HW
- with straight cut

Advantages
- cutting on a diameter

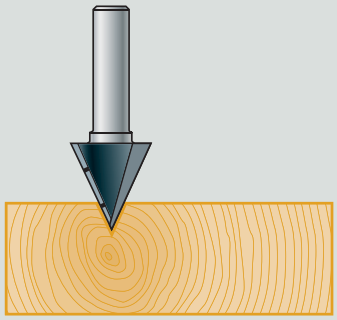
Notes
- for tool holder with collet chuck

Product features

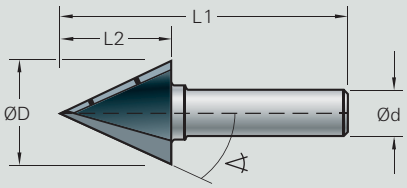
Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z			PU [pc.]	L	Order-No.
12.7	25	8	69	2	12,7		1	L	58512018

HW HW V-grooving and engraving cutter

Product



Drawing



Machine | Application | Design

MAN

Machine / Application
- Hand routers
- for copying, drilling and milling of edges in thin materials

Design
- Cutting material: HW
- with rabbeting

Advantages
- exact milling of sharp V-grooves

Notes
- bores are possible
- for tool holder with collet chuck

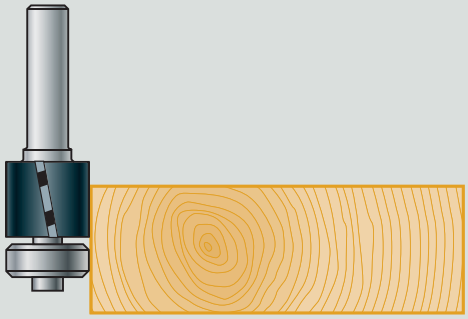
Product features

Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z	Chamfer◁ [°]		PU [pc.]	L	Order-No.
15.8	16	8	51	2	30		1	L	58502269

HW HW-Edge-Cutter

with bearing at the bottom and pulling cut

Product



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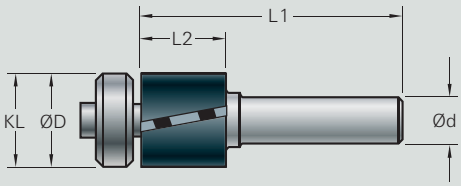


Machine

Application

Design

MAN

Machine / Application

- Hand routers
- for jointing of solid wood, laminated panel materials, MDF, etc.

Design

- Cutting material: HW
- with straight cut
- scoring cut

Advantages

- cutting to diameter

Notes

- for tool holder with collet chuck

Product features

Ø D [mm]	L2 [mm]	Ø d [mm]	L1 [mm]	Z			Order information	PU [pc.]	L	Order-No.
12.7	25	8	70	3	12,7			1	L	58512334

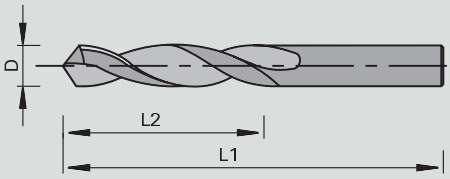
DRILL BITS

CONTENTS

VHW 2010 Twist Drills

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through holes and dowel holes in solid woods and wood-based panels

Design

- 2 v-point cutting edges
- solid carbide design
- cutting Ø = shank Ø
- tip angle 120°

Advantages

- high feed rates possible
- large resharpenable area

Notes

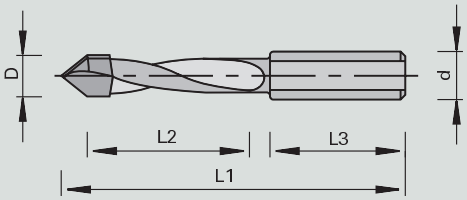
- clamping elements: draw-in collet chuck, drill chuck

Product features					Order information					
Ø D [mm]	L2 [mm]	L1 [mm]	Ø d [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
2.0	25	50	2,0		1	L	182625	L	182626
2.5	27	55	2,5		1	L	50600742	L	50600743
2.5	27	55	2,5		1	L	182627	L	182628
3.0	27	55	3,0		1	L	182629	L	182630
3.5	27	52	3,5		1	L	182631	L	182632
4.0	27	55	4,0		1	L	50600750	L	50600751
4.0	27	55	4,0		1	L	182633	L	182634
5.0	28	60	5,0		1	L	182635	L	182636

HW 2020 Through-Hole Bits

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through-holes in solid woods and wood-based panels

Design

- 2 v-point cutting edges (60 degree angle)
- HW-tipped
- cylindrical shank with clamping surface
- spiral without back guide

Advantages

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

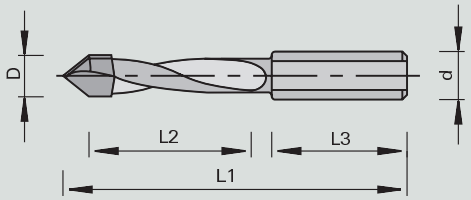
Product features / **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
5.0	25	10	25	57.5		1	L	50600132	L	50600133
5.0	35	10	25	70		1	L	50600136	L	50600137
5.0	45	10	25	77		1		176477		176476
6.0	25	10	25	57.5		1	L	176475	L	176474
6.0	35	10	25	70		1	L	50600318	L	50600319
8.0	22	10	25	57.5		1	L	055830	L	055826
8.0	35	10	25	70		1	L	50600138	L	50600139
8.0	43	10	25	77		1	L	50600326	L	50600327

HW 2021 Through-Hole Bits

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- HW-plunging tip made from super-fine grain material

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- long edge lives thanks to HW plunging tip
- high process safety thanks to constant quality of the bores for a long time

Notes

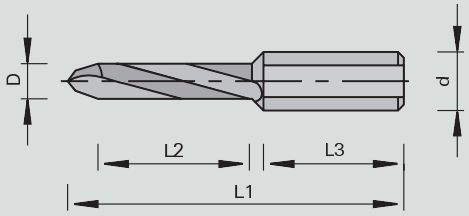
- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

Product features						Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]	
5.0	27	10	26	57.5		1	L	182458	L	182459	
5.0	35	10	26	70		1	L	50600372	L	50600373	
8.0	35	10	26	70		1	L	182464	L	182465	
10	35	10	26	70		1	L	183693	L	183692	

VHW 2022 Through-Hole Bits

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of through-holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- boring part made from fine-grain solid tungsten carbide

Advantages

- chip-free hole edges thanks to special cutting edge geometry
- high feed rates and edge lives increased up to sixfold compared to traditional through-hole drills thanks to solid carbide design
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 included in delivery
- through-hole bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- adjusting screw Order-No. 186017 M5x11,5 for Weeke must be ordered separately
- clamping elements: combi chuck, quick-change chuck

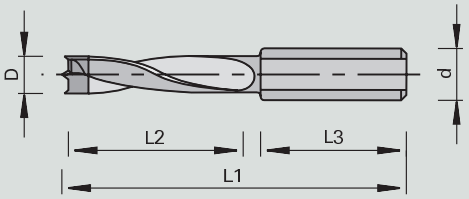
Product features							Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]				PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
3.0	27	10	30	70				1	L	50600588	L	50600376
4.0	35	10	24	70				1	L	50600451	L	50600450
5.0	35	10	24	70				1	L	183153	L	183152
6.0	35	10	50	100		for Lamello Clamex P®		1			L	184289
8.0	35	10	24	70				1	L	183157	L	183156

HW 2031 Dowel Bits

With back-guide

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral with back-guide
- plastic coated
- HW-tipped

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- protection of the hole edge upon exiting thanks to spiral with back guide
- optimum chip evacuation thanks to plastic coating

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- clamping elements: combi chuck, quick-change chuck

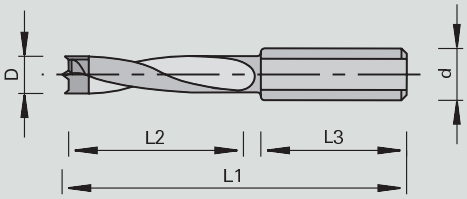
Product features						Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]	
5.0	30	10	19	57.5		1	L	50600174	L	50600175	
6.0	30	10	20	57.5		1	L	167185	L	167175	
8.0	30	10	20	57.5		1	L	50600178	L	50600179	
10	30	10	20	57.5		1	L	167188	L	167178	
12	30	10	20	57.5		1	L	167189	L	167179	

HW 2032 Dowel Bits

Without back-guide

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- 2 negative spurs
- centering point
- spiral without back guide
- plastic coated
- HW-tipped

Advantages

- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- optimum chip evacuation thanks to plastic coating

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

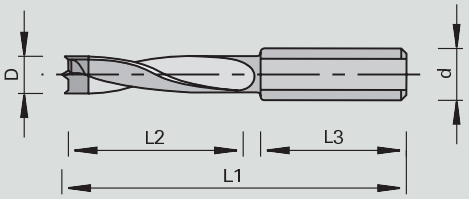
Product features					Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
4.0	27	10	27	57.5		1	L	50600100	L	50600101
5.0	27	10	27	57.5		1	L	50600102	L	50600103
6.0	27	10	27	57.5		1	L	50600104	L	50600105
8.0	27	10	27	57.5		1	L	50600108	L	50600109
8.2	27	10	27	57.5		1	L	167216	L	167213
9.0	27	10	27	57.5		1	L	003195	L	003194
10	27	10	27	57.5		1	L	50600112	L	50600113
12	27	10	27	57.5		1	L	003207	L	003206
4.0	35	10	30	70		1	L	173175	L	173174
5.0	35	10	30	70		1	L	50600116	L	50600117
6.0	35	10	30	70		1	L	50600118	L	50600119
7.0	35	10	30	70		1	L	50600120	L	50600121
8.0	35	10	30	70		1	L	50600122	L	50600123
9.0	35	10	30	70		1	L	167225	L	167220
10	35	10	30	70		1	L	50600126	L	50600127
11	35	10	30	70		1	L	167226	L	167227
12	35	10	30	70		1	L	50600130	L	50600131

HW 2033 Dowel Bits

Long design with back-guide

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- long cutting length
- 2 negative spurs
- centering point
- spiral with back-guide
- plastic coated
- HW-tipped

Advantages

- deep holes thanks to long cutting length
- chip-free hole edges thanks to negative spurs
- safe drilling thanks to centering point
- protection of the hole edge upon exiting thanks to spiral with back guide
- optimum chip evacuation thanks to plastic coating

Notes

- adjustable countersink attachment on the boring spiral for simultaneous chamfering of the hole
- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

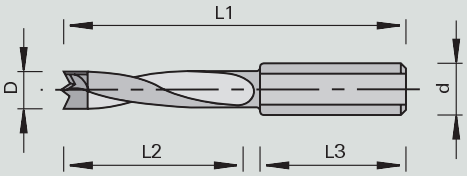
Product features						Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]	
5.0	50	10	30	85		1	L	177194	L	177193	
8.0	50	10	30	85		1	L	177200	L	177199	
10	50	10	30	85		1	L	177202	L	177201	
7.0	65	10	30	105		1	L	177210	L	177209	
8.0	65	10	30	105		1	L	177212	L	177211	
10	65	10	30	105		1	L	177214	L	177213	

HW 2040 Dowel Bits

With special tooth geometry

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- 2 spurs
- centering point
- HW-tipped

Advantages

- chip-free hole edges thanks to special cutting edge geometry with spurs
- safe drilling thanks to centering point
- high process safety thanks to constant quality of the bores for a long time
- tool life increased up to sixfold compared to traditional dowel bits thanks to wear-resistant HW plunging tip

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck

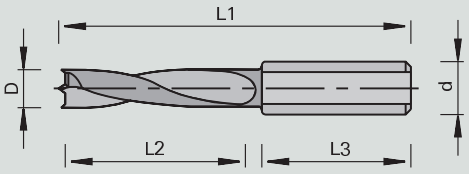
Product features					Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
5.0	25	10	27	57.5		1	L	50600640	L	50600641
6.0	25	10	27	57.5		1	L	50600642	L	50600643
8.0	25	10	27	57.5		1	L	50600644	L	50600645
10	25	10	27	57.5		1	L	50600646	L	50600647
5.0	35	10	30	70		1	L	50600648	L	50600649
6.0	35	10	30	70		1	L	50600650	L	50600651
8.0	35	10	30	70		1	L	50600652	L	50600653
10	35	10	30	70		1	L	50600654	L	50600655

VHW 2041 Dowel Bits

With special tooth geometry

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of dowel holes in solid woods and wood-based panels

Design

- special cutting edge geometry
- 2 spurs
- centering point
- boring part made from fine-grain solid tungsten carbide

Advantages

- chip-free hole edges thanks to special cutting edge geometry with spurs
- safe drilling thanks to centering point
- high feed rates and edge lives increased up to sixfold compared to traditional dowel bits thanks to solid carbide design
- high process safety thanks to constant quality of the bores for a long time

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 included in delivery
- dowel bit with shank length L3=22 mm is not suitable for Weeke adjusting screw
- adjusting screw Order-No. 186017 M5x11,5 for Weeke must be ordered separately
- clamping elements: combi chuck, quick-change chuck

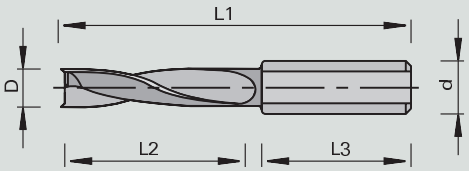
Product features | **Order information**

Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
3.0	18	10	31	57.5		1	L	50600261	L	50600262
4.0	20	10	29	57.5		1	c	182382	O	182383
5.0	22	10	27	57.5		1	L	50600263	L	50600264
3.0	18	10	43.5	70		1	L	50600267	L	50600268
4.0	27	10	34.5	70		1	L	50600455	L	50600456
5.0	30	10	31.5	70		1	L	50600269	L	50600270
6.0	30	10	30	70		1	L	183149	L	183148
8.0	35	10	22	70		1	L	183151	L	183150

VHW 2042 High-Performance Dowel Bits

Product

Drawing



Machine

Application

Design

Machine / Application

- stationary boring machines
- automatic boring machines
- CNC machining centers
- for drilling of through holes and dowel holes in solid woods, wood-based panels and composite materials

Design

- special cutting edge geometry
- 2 spurs
- spiral with back-guide
- boring part made from solid tungsten carbide

Advantages

- special tooth geometry and spurs for minimal cutting force and cutting pressure
- protection of the hole edge upon exiting thanks to spiral with back guide
- high feed rates and large resharpenable area thanks to solid carbide bit

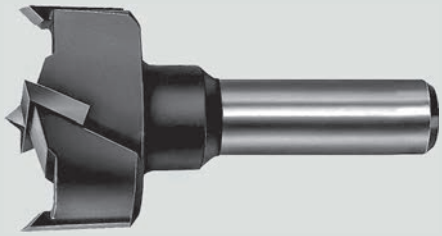
Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-change chuck
- tooth geometry applied for patent
- change of grinding or reduction of diameter ist not possible

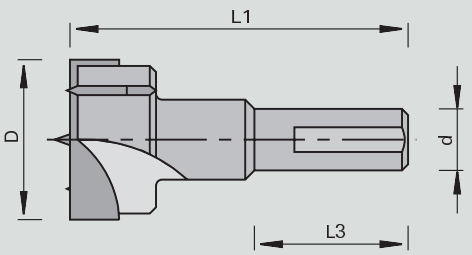
Product features					Order information					
Ø D [mm]	L2 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
5.0	36	10	30	70		1	L	50600691	L	50600690
6.0	36	10	30	70		1	L	185774	L	185773
8.0	36	10	30	70		1	L	50600695	L	50600694
10	36	10	30	70		1	L	185778	L	185777

HW 2050 Cylinder Boring Bits

Product



Drawing



Machine

Application

Design

Machine / Application

- hardware hinge machines
- automatic boring machines
- CNC machining centers
- for chip-free drilling of hinge hardware holes in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped

Advantages

- chip-free holes thanks to scoring cut of the spurs

Notes

- cylindrical shank with clamping surface
- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

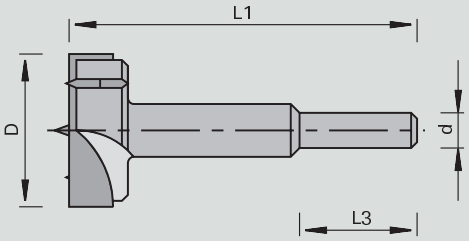
Product features				Order information					
Ø D [mm]	Ø d [mm]	L3 [mm]	L1 [mm]		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
15	10	26	57.5		1	L	50600500	L	50600501
16	10	26	57.5		1	L	003305	L	003304
18	10	26	57.5		1	L	003309	L	003308
20	10	26	57.5		1	L	003313	L	003312
22	10	26	57.5		1	L	003315	L	003314
25	10	26	57.5		1	L	003319	L	003318
26	10	26	57.5		1	L	003321	L	003320
30	10	26	57.5		1	L	50600514	L	50600515
35	10	26	57.5		1	L	50600516	L	50600517
40	10	26	57.5		1	L	003337	L	003336
15	10	26	70		1	L	50600530	L	50600531
20	10	26	70		1	L	50600532	L	50600533
25	10	26	70		1	L	178980	L	172252
26	10	26	70		1	L	182374	L	182375
30	10	26	70		1	L	178981	L	172253
35	10	26	70		1	L	50600540	L	50600541

HW 2051 Cylinder Boring Bits

Long cutting length

Product

Drawing



Machine

Application

Design

Machine / Application

- portable boring machines
- for chip-free drilling in solid woods and wood-based panels

Design

- 2 rakers, 2 spurs and centering point
- HW-tipped
- cylindrical shank

Advantages

- chip-free holes thanks to scoring cut of the spurs

Notes

- clamping element: drill chuck

Product features / **Order information**

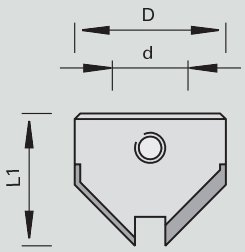
Ø D [mm]	Ø d [mm]	L3 [mm]	L1 [mm]				L/R			PU [pc.]	L	Order-No.
15	10	30	90				R			1	L	160424
17	10	30	90				R			1	L	167686
20	10	30	90				R			1	L	160427
25	10	30	90				R			1	L	160430
30	10	30	90				R			1	L	160433
32	10	60	90				R			1	L	50600571
35	10	60	90				R			1	L	50600575

HW 2061 Countersink Parts

For twist drills and dowel drills

Product

Drawing



Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for installation on twist drills and dowel bits with back-guide on the drill spiral with set screw
- continuous adjustment of the countersink diameter and the boring depth

Product features / Order information

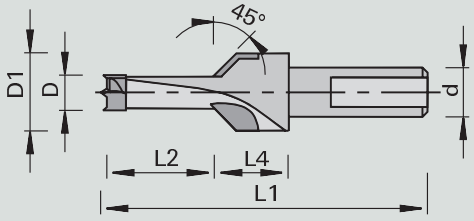
Ø D [mm]	Ø d [mm]	L1 [mm]	PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
16	5,0	15	1	L	183174	L	183175
18	8,0	15	1	L	183180	L	183181

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Cranked Wrench Keys	SW2,5 DIN ISO 2936	1		009671

HW 2060 Boring Countersink

Product

Drawing



Machine / Application

- portable boring machines
- automatic boring machines
- for drilling and countersinking in solid woods and wood-based panels

Design

- spiral PTFE coated
- 2 spurs
- centering point

Advantages

- for drilling and countersinking in one pass
- safe drilling thanks to centering point

Notes

- adjusting screw Order-No. 001600 M5x10 DIN 551 for precise length adjustment included in delivery
- adjusting screw Order-No. 186017 M5x11,5 for Weeke quick clamping chuck must be ordered separately
- clamping elements: combi chuck, quick-clamping chuck

Product features / Order information

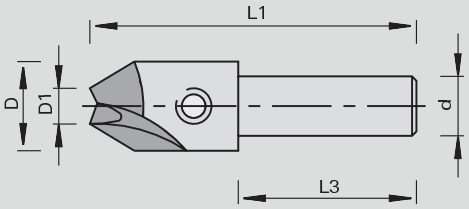
Ø D [mm]	L2 [mm]	Ø D1 [mm]	L4 [mm]	Ø d [mm]	L1 [mm]	PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
8.0	12	16	15	10	57.5	1	L	180847	L	180846
8.0	12	16	15	10	70	1	L	180859	L	180858

HW 2062 Countersink Bits

For twist drills

Product

Drawing



Machine

Application

Design

Machine / Application

- for drilling of countersinks in solid woods and wood-based panels
- for chip-free countersink holes at 90 degree angle

Design

- HW-tipped

Advantages

Notes

- for mounting of twist drills with Ø 3 - 6 mm
- continuous adjustment of the countersink diameter and the boring depth

Product features / **Order information**

Ø D [mm]	Ø D1 [mm]	Ø d [mm]	L3 [mm]	L1 [mm]			L/R		PU [pc.]	L	Order-No.
15	3.0	10	30	58			R		1	L	173190
15	3.5	10	30	58			R		1	L	173192
15	4.0	10	30	58			R		1	L	173194
15	4.5	10	30	58			R		1	L	173196
15	5.0	10	30	58			R		1	L	173198

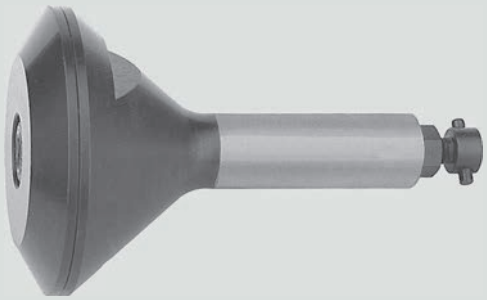
Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Set Screws - with hexagon socket and cup point	M6x6 DIN EN ISO 4029	10	L	180003

CLAMPING SYSTEMS

CONTENTS

Adapters with cylindrical shank

Product



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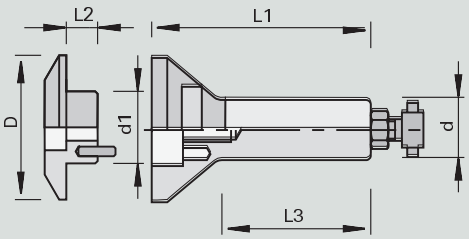


Machine

CNC

Application

Design

R/L

Machine / Application

- for PS 2000-E and draw-in collet chuck for mounting of circular saw blades and grooving cutters

Design

- secured against rotation with drive pin

Advantages

Notes

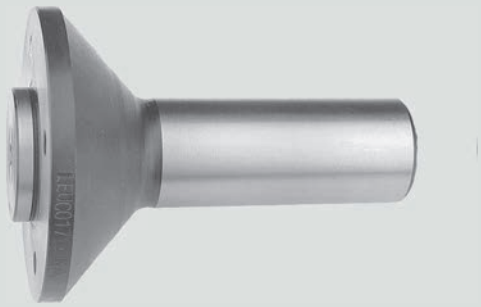
- for clockwise and counter-clockwise rotation
- length adjusting screw Order-No. 172921 is required for PS 2000-E
- included in delivery: clamping arbor, clamping flange, cap screw and length adjusting screw for ps-System for shank Ø 16 Order-No. 172115, shank Ø 25 Order-No. 172113

Product features | **Order information**

Ø D [mm]	Ø d [mm]	L2 [mm]	L1 [mm]	L3 [mm]		PU [pc.]	L	Order-No.
60	16	8,0	78	43	for plate thickness max. 6 mm	1	L	171394
60	25	9,0	94	55	for plate thickness max. 8 mm	1	L	167826

Adapters with cylindrical shank

Product



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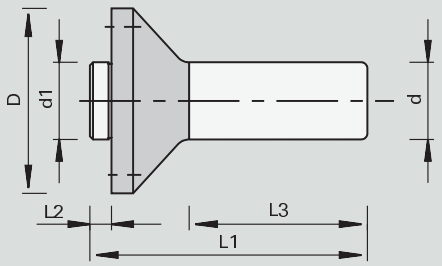


Machine

Application

Design

R/L

Machine / Application

- for PS 2000-E and draw-in collet chuck for the mounting of tools with bore

Design

- tool attached and secured against rotation with screws

Advantages

Notes

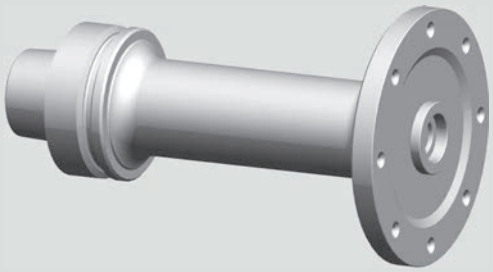
- for right-hand and left-hand rotation
- for PS 2000-E, the length adjusting screw order no. 172921 is required
- clamping length L2 = 30 and 36 mm for one-piece and multi-piece cutters and cutterheads
- clamping length L2 = 4 an 5 mm for circular saw blades and grooving tools
- Scope of delivery: Adapter for Lamello Clamex P® including 4 countersunk screws, all other adapters without countersunk screws. Screws of the required length must be ordered separately depending on the application.

Product features / Order information

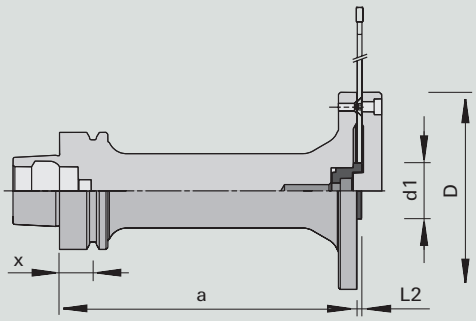
Ø D [mm]	Ø d [mm]	Ø d1 [mm]	L2 [mm]	L1 [mm]	L3 [mm]	NL			PU [pc.]	L	Order-No.
50	16	22	4,0	68	45	4/M5/34 + 4/M4/36			1	L	184277
50	25	22	4,0	92	60	4/M5/34 + 4/M4/36			1	L	184276
60	16	30	4,0	80	60	4/M6/48	Lamello Clamex P®		1	L	184304
60	25	30	4,0	90	70	4/M6/48	Lamello Clamex P®		1	L	184305
60	25	25	30	111	60	6/M6/48			1	S	168814
60	25	30	36	117	60	6/M6/48			1	L	168815
66	25	30	5,0	92	60	4/M5/48			1	L	171386

CNC Combi Saw Blade Adapters HSK 63F

Product



Drawing



Machine

Application

Design

HSK

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of circular saw blades

Design

- interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

- exchangeable centering adapter can be obtained separately; thus saw blades with different bore diameters can be used on the same mounting device
- the mounting of the saw blade can be made with or without lid
- adapter available with different a measures

Notes

- for right-hand and left-hand rotation
- mounting of the saw directly by means of countersunk screws or lid by means of cylinder head screw
- included in delivery: lid, countersunk screws, cylinder head screws and centering adapter for saw blade bore Ø 30 mm with retaining ring
- Recommendation of the max. saw blade diameter: without lid - Dmax = 360 mm, with lid - Dmax = 430 mm

Product features — **Order information**

Ø D [mm]	Ø d [mm]	Ø d1 [mm]	L2 [mm]	a [mm]	x [mm]	NL	PU [pc.]	L	Order-No.
106	HSK 63F	30	2,5	40	18	8/M5/90	1	L	184835
106	HSK 63F	30	2,5	50	18	8/M5/90	1	L	184836
106	HSK 63F	30	2,5	56	18	8/M5/90	1	L	187760 NEW
106	HSK 63F	30	2,5	100	18	8/M5/90	1	L	184837
106	HSK 63F	30	2,5	130	18	8/M5/90	1	L	184838
106	HSK 63F	30	2,5	160	18	8/M5/90	1	L	184839

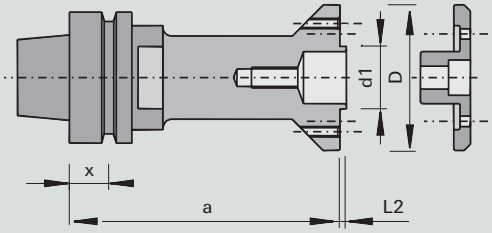
Accessories	Dimension [mm]	PU [pc.]	L	Order-No.
Lid	106x15x20	1	L	184845
Adapter	Ø30	1	L	184840
Adapter	Ø31,75	1	S	184841
Adapter	Ø32	1	L	184842
Adapter	Ø35	1	L	184843
Adapter	Ø40	1	L	184844
Adapter for body thickness 2.0 or 2.2 mm	Ø30	1	L	185666

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Head Cap Screws	M5x16 DIN EN ISO 4762	10	L	001870
Head Cap Screws for adapters	M8x12 DIN 7984	10	L	184846
Locking Rings	8/13x8,4x0,7	1	L	185497
Countersunk Screws	M5x12 T20 D=Ø9,3	10	L	166709

Saw Blade Adapters HSK 63F

Product

Drawing



Machine

Application

Design

HSK

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of circular saw blades and grooving cutters

Design

- interface DIN 69893 HSK 63 F for high-precision adapter to the machine spindle

Advantages

Notes

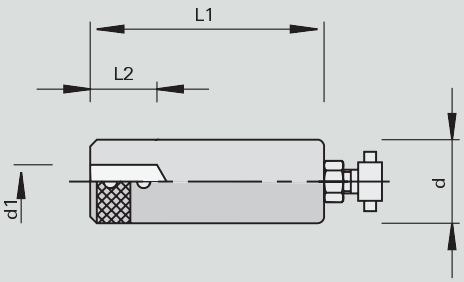
- for right-hand and left-hand rotation
- mounting of the saw directly by means of countersunk screws or with lid 183310 by means of cylinder head screw
- included in delivery:
- support with countersunk screw
- lid with cylinder head screws to be ordered separately, if required
- Recommendation of the max. saw blade diameter: without lid - Dmax = 210 mm, with lid - Dmax = 280 mm

Product features	Ø d [mm]	Ø d1 [mm]	L2 [mm]	a [mm]	x [mm]	NL		PU [pc.]	L	Order-No.
70	HSK 63F	30	1,8	55	18	8/M5/52 + 2/6/42		1	L	187639
70	HSK 63F	30	1,8	70	18	8/M5/52 + 2/6/42		1	L	186083
70	HSK 63F	30	1,8	130	18	8/M5/52 + 2/6/42		1	L	186432

Accessories	Dimension [mm]							PU [pc.]	L	Order-No.
Cover with 2 pins as twist-lock and cylinder head screw M10	70x24x8 (2/6/42)							1	L	183310

Spare parts	Dimension [mm]							PU [pc.]	L	Order-No.
Countersunk Screws	M5x8 T20 D=Ø10							10	L	164005

Adapters with cylindrical shank

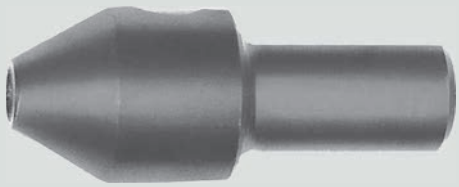
Product	Drawing	Machine	Application	Design
		CNC		R/L

Machine / Application	Design	Advantages	Notes
• for mounting of shank-type tools in PS 2000-E for shank diameter 6 - 12 mm			• the tool shanks must feature a flat clamping area • length adjusting screw Order-No. 172921 is required for PS 2000-E • with length adjusting screw for ps-System Ø 16 mm Order-No. 172115, Ø 25 mm Order-No. 172113

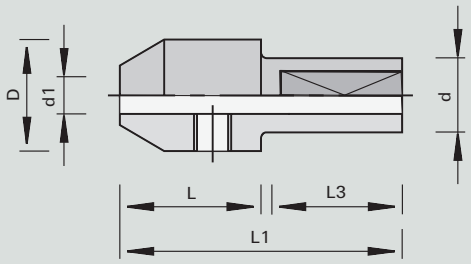
Product features				Order information		
Ø d [mm]	Ø d1 [mm]	L2 [mm]	L1 [mm]	PU [pc.]	L	Order-No.
25	6	20	70	1	L	172103
25	8	20	70	1	L	172104
25	10	20	70	1	L	172101
25	12	20	70	1	L	172102

Adapters

Product



Drawing



Machine

CNC

Application

Design

R/L

Machine / Application

- for mounting of twist drills in combi chuck and Klack chuck

Design

- shank with clamping surface
- thread M5, without screw

Advantages

Notes

- adjusting and attachment screw Order-No. 186017 M5x11.5 for Weeke quick clamping chuck must be ordered separately

Product features / **Order information**

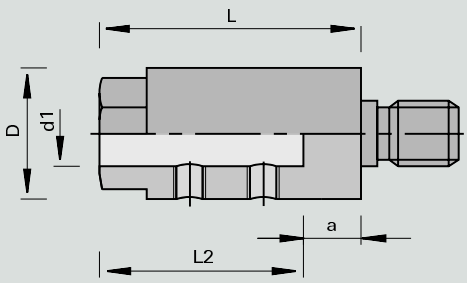
Ø d1 [mm]	L [mm]	Ø d [mm]	L3 [mm]	Ø D [mm]	L1 [mm]	PU [pc.]	L	Order-No.
2	19	10	21	15	41	1	L	183275
2,5	19	10	21	15	41	1	L	183276
3	19	10	21	15	41	1	L	183277
3,5	19	10	21	15	41	1	L	183278
4	19	10	21	15	41	1	L	183279
5	19	10	21	15	41	1	L	183280

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Set Screws	M6x6 DIN EN ISO 4029	10	L	180003
Cranked Wrench Keys	SW3 DIN ISO 2936	1	L	009672

Clamping Chuck Combi Systems

Product

Drawing



Machine

Application

Design

Machine / Application

- for mounting of drill bits with cylindrical shank and clamping surface

Design

- with set screws for the clamping of the drill bit

Advantages

Notes

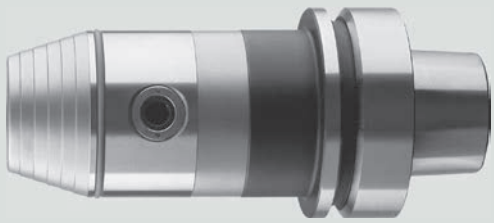
- clamping chucks with "BSS" mark are compatible with quick-changing system for drill bits
- for threaded shank design and appropriate machines see chapter 8 Technical Appendix

Product features / Order information

Ø D [mm]	Ø d1 [mm]	L2 [mm]	L [mm]	a [mm]	Type		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
15	8	20	22	2.0	D		1	O	161282	O	161281
15	8	20	24.5	4.5	A		1	S	010683	S	010677
15	8	20	24.5	4.5	B		1	S	161285	S	161284
15	8	20	24.5	4.5	C		1	S	058412	S	058411
15	8	20	37	17	C		1	L	059300	L	059299
19	10	20	24.5	4.5	A		1	L	003575	L	003574
19	10	20	24.5	4.5	B		1	L	008003	L	008002
19	10	20	24.5	4.5	C		1	L	058414	L	058413
19	10	20	25	5.0	D		1	L	003571	L	003570
19	10	20	25	5.0		cyl. shank Ø 10x30	1	O	183055	O	183055
19	10	20	47	27	G		1	L	161287	L	161286
19	10	20	29.3	9.3	F		1	L	003573	L	003572
19	10	20	28.5	8.5	E		1	S	161987	O	161283
19	10	20	37	17	C		1	L	161681	L	161680
19	10	20	47	27	D	BSS	1	S	170372	S	170371
15	8	20	22	2.0	D		1	O	161281	O	161282
15	8	20	24.5	4.5	A		1	S	010677	S	010683
15	8	20	24.5	4.5	B		1	S	161284	S	161285
15	8	20	24.5	4.5	C		1	S	058411	S	058412
15	8	20	37	17	C		1	L	059299	L	059300
19	10	20	24.5	4.5	A		1	L	003574	L	003575
19	10	20	24.5	4.5	B		1	L	008002	L	008003
19	10	20	24.5	4.5	C		1	L	058413	L	058414
19	10	20	25	5.0	D		1	L	003570	L	003571
19	10	20	47	27	G		1	L	161286	L	161287
19	10	20	29.3	9.3	F		1	L	003572	L	003573
19	10	20	28.5	8.5	E		1	O	161283	L	161987
19	10	20	37	17	C		1	L	161680	L	161681
19	10	20	47	27	D	BSS	1	S	170371	S	170372

Spare parts	Dimension [mm]	PU [pc.]	L	Order-No.
Set Screws	M6x4 DIN EN ISO 4029	10	L	167068
Set Screws	M6x5 DIN EN ISO 4029	10	L	165049
Set Screws	M5x4 DIN EN ISO 4029	10	L	001608

Universal Drill Chucks

Product	Drawing	Machine	Application	Design
		CNC		R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of drill bits with cylindrical shank

Design

- continuously adjustable clamping area between 1-13 mm
- n max = 20,000 min-1
- hardened clamping jaws

Advantages

- fine balance is easy on spindle and spindle bearing
- high clamping accuracy over total lifetime of drill chuck thanks to hardened clamping jaws
- high holding moment
- no chips and dirt in the clamping zone thanks to special clamping jaws

Notes

- for clockwise and counter-clockwise rotation
- included in delivery: clamping key, retaining bolts

Product features

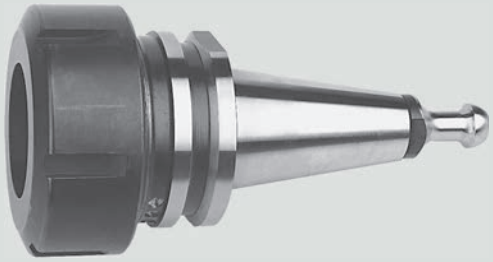
Ø D [mm]	Ø d [mm]	Ø d1 [mm]	L1 [mm]		PU [pc.]	L	Order-No.
50	HSK 63F	1-13	97	Homag, EIMA, Weeke, IMA from 9/94	1	L	187039
57	HSK 63F	2-16	102	Homag, EIMA, Weeke, IMA from 9/94	1	L	187040

Spare parts

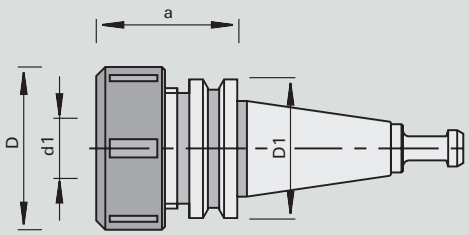
	Dimension [mm]	PU [pc.]	L	Order-No.
Cranked Wrench Keys	SW6x100	1	S	180383

Draw-In Collet Chucks with SK shank

Product



Drawing



Machine

CNC

Application

Design

SK

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of shank-type tools with cylindrical shank

Design

- quick-release taper according to DIN 69871 and ISO (without dog and locating grooves)
- lock nut with sleeve bearing

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

- for clockwise and counter-clockwise rotation
- collet chucks according to Type 470E/ER32 Ø 2..20 mm
- collet chucks according to Type 472E/ER40 Ø 4..25 mm
- included in delivery:collet chuck, clamping nut and retaining bolt (Biesse 173641)

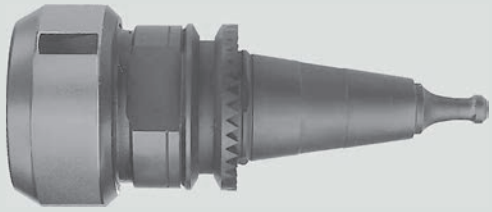
Product features / **Order information**

Ø D [mm]	Ø d [mm]	Ø d1 [mm]	a [mm]	Type					PU [pc.]	L	Order-No.
50	SK 30 (DIN ISO)	2-20	50	470E/ ER32	Biesse				1	L	173639
63	SK 30 (DIN ISO)	4-25	57	472E/ ER40	Biesse				1	L	175790

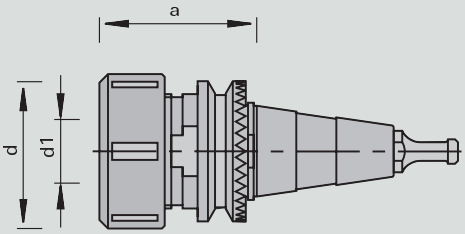
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Clamping Nuts with sleeve bearing	M50x1,5R	for Ø D = 63	1	O	178762
Retaining Bolts		HSD motor for Biesse as from 09/92	1	L	173641
Retaining Bolts		for Biesse up to 08/92	1	O	175637
Hook Wrenches	58/62 DIN 1810	for Ø D = 63	1	L	169299
	58/62 DIN 1810	for Ø D = 63	1	L	186765
Clamping Nuts with sleeve bearing	M40x1,5R	for Ø D = 50	1	L	178761
[f] torque wrench	40-200 Nm		1	L	184890
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	1	L	175851
	45/50 DIN 1810	for Ø D = 50	1	S	186467

Draw-In Collet Chucks with SK shank with ring gear

Product



Drawing



Machine

CNC

Application

Design

SK

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for clamping of shank-type tools with cylindrical shank

Design

- quick-release taper according to SK 30 with ring gear
- lock nut with sleeve bearing

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity

Notes

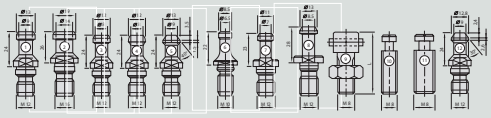
- for clockwise and counter-clockwise rotation
- replaceble retaining bolt
- collet chucks according to Type 462E/OZ25 Ø 4..25 mm
- collet chucks according to Type 470E/ER32 Ø 2..20 mm
- included in delivery: collet chuck, clamping nut and retaining bolt

Product features / Order information

Ø D [mm]	Ø d [mm]	Ø d1 [mm]	a [mm]	Type			PU [pc.]	L	Order-No.
50	SK 30	2-20	55	470E/ ER32		SCM, Morbidelli	1	L	173644
60	SK 30	4-25	72	462E/ OZ25		SCM, Morbidelli	1	L	175792

Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Clamping Nuts with sleeve bearing	M48x2R	for Ø D = 60	1	L	178764
Clamping Nuts with sleeve bearing	M40x1,5R	for Ø D = 50	1	L	178761
Retaining Bolts	Ø8,5		1	L	173646
Hook Wrenches	58/62 DIN 1810	for Ø D = 60	1	L	169299
Hook Wrenches	45/50 DIN 1810	for Ø D = 50	1	L	175851
Single-Head Engineers Wrenches	SW46x10 DIN 894	for Ø D = 60	1	L	178760
Single-Head Engineers Wrenches	SW36 DIN 894	for Ø D = 50	1	O	169296

Retaining Bolts

Product	Drawing	Machine	Application	Design
		CNC		BT SK

Machine / Application

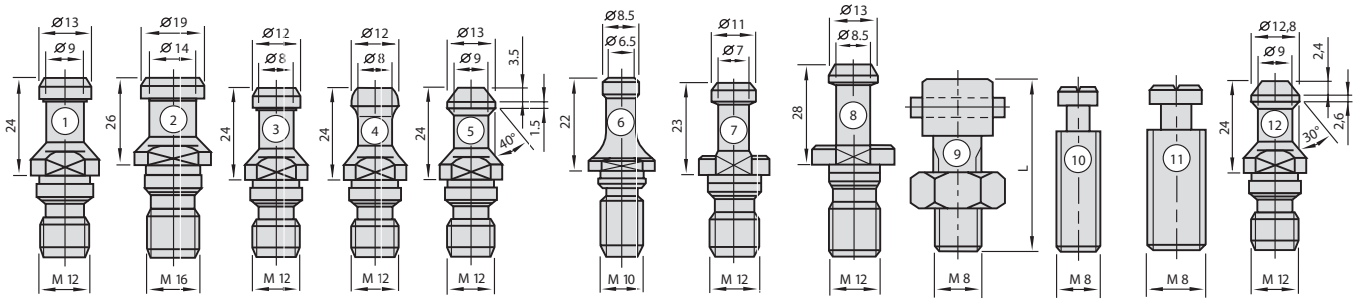
- for use in Hydro clamping chuck PS 2000-E, adapter and draw-in collet chuck with SK + BT-shank

Design

Advantages

Notes

- attachment screw for tools with shank diameter 25 mm

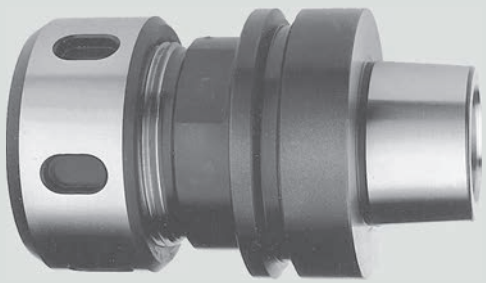


Product features / **Order information**

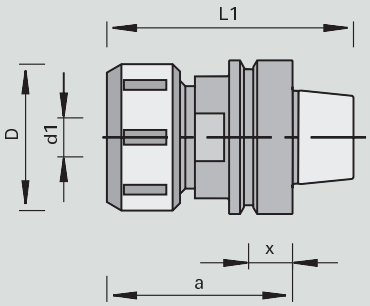
	Type		PU [pc.]	L	Order-No.
for SK 30	1	IMA, Maka, Reichenbacher, Weeke	1	L	169293
for SK 40 with ventilation	2	IMA, Reichenbacher, Stegherr	1	S	169294
for SK 40	2	IMA, Reichenbacher, Stegherr, Maka	1	L	179339
for SK 30	3	Rover old, Biesse up to 08/92	1	O	175637
for SK 30	4	Rover new, Biesse (HSD motor) from 09/92, Masterwood (Colombo motor)	1	L	173641
for SK 30	5	Alberti	1	O	177020
for CMS	12	CMS, Masterwood	1	L	177021
Retaining Bolt Ø 8.5 mm	6	Morbidelli, SCM	1	L	173646
for BT 30	7	Shoda	1	S	176200
for BT 35	8	Heian	1	L	176103
for ps-System 25 mm Ident-No. 173752	9	ps-System	1	L	172113
for PS-2000 E Ident-No. 173352	10	PS 2000-E	1	L	172921
stop screw	11	draw-in collet chuck	10	L	172828

Draw-In Collet Chucks with HSK shank

Product



Drawing



Machine

Application

Design

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- interface according to DIN 69893 HSK 50F, HSK 63F and HSK 63E
- lock nut with sleeve bearing

Advantages

- flexible utilization by collet chucks

Notes

- for right- and lefthand rotation
- Ø d1 = collet chuck diameter 2 - 25 mm
- collet chucks according to DIN 6388 type 462E/OZ25
- included in delivery: collet chuck, clamping nut without spanner wrench
- Attention: different interfaces in case of CMS machines, according to spindle performance (KW)

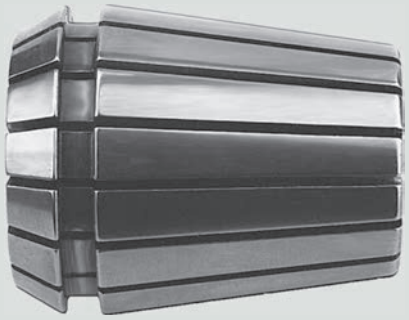
Product features / **Order information**

Ø D [mm]	Ø d1 [mm]	Ø d [mm]	L1 [mm]	a [mm]	x [mm]		PU [pc.]	L	Order-No.
60	2-25	HSK 63F	101	76	18	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, SCM, CMS (12+15 KW)	1	L	50811234
60	2-25	HSK 63F	140	115	18	Homag, IMA from 01/95, Weeke from 03/98, HOLZ-HER, CMS (12+15 KW)	1	L	179170

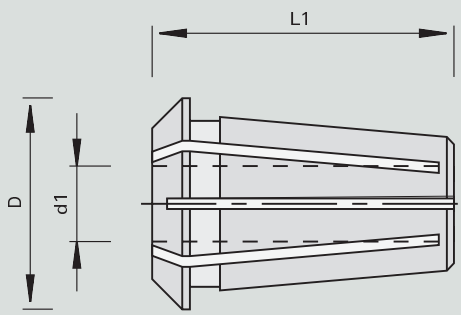
Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Clamping Nuts	M48x2R		1	L	178764
Hook Wrenches	58/62 DIN 1810		1	L	169299
Hook wrenches adapter	58/62 DIN 1810		1	L	186765
Torque wrench	40-200 Nm		1	L	184890
Single-Head Engineers Wrenches	SW46x10 DIN 894		1	L	178760
Blind plug with screw	11,9x6,9xM5		1	L	185610

Precision collets - 462E/OZ25

Product



Drawing



Machine

Application

Design

Machine / Application

- for use in draw-in collet chuck Type 462E/OZ25

Design

- clamping tolerance 0.5 mm
- according to DIN 6388 Type 462E/OZ25

Advantages

- optimum transmission of clamping force thanks to 12 slots from top and bottom

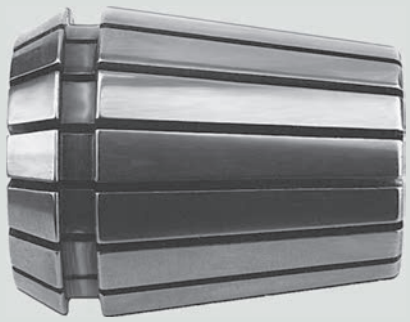
Notes

Product features / **Order information**

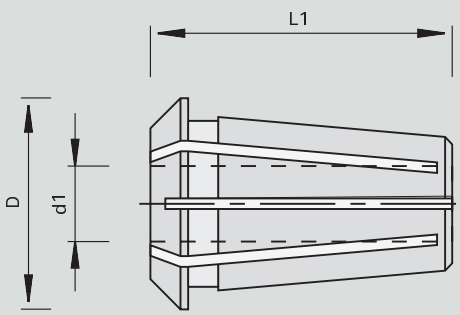
Ø d1 [mm]	Ø d1 [inch]	L1 [mm]	PU [pc.]	L	Order-No.
2		52	1	O	183803
3		52	1	L	183804
4		52	1	L	183805
5		52	1	L	183806
6		52	1	L	180213
	1/4″	52	1	L	175815
7		52	1	O	183807
8		52	1	L	180358
	3/8″	52	1	L	185275
10		52	1	L	170782
12		52	1	L	168742
	1/2″	52	1	L	175820
13		52	1	L	180215
14		52	1	L	170783
	5/8″	52	1	L	175823
15		52	1	O	183808
16		52	1	L	168743
18		52	1	L	180216
	3/4″	52	1	L	175826
20		52	1	L	168744
25		52	1	L	168745

Precision collets - 415E/OZ16

Product



Drawing



Machine

Application

Design

Machine / Application

- for use in draw-in collet chuck Type 415E/OZ16

Design

- slotted from top and bottom
- clamping tolerance 0.5 mm
- according to DIN 6388 Type 415E/OZ16

Advantages

Notes

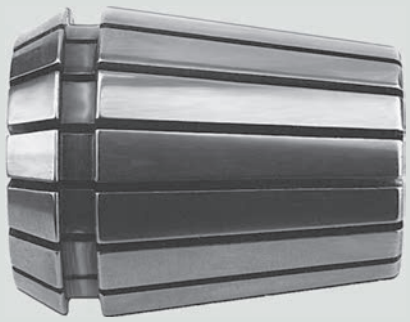
Product features

Order information

Ø d1 [mm]	Ø D [mm]	L1 [mm]	PU [pc.]	L	Order-No.
2,5	25.5	40	1	O	820753
3	25.5	40	1	S	820754
4	25.5	40	1	S	820494
4,5	25.5	40	1	S	830236
5	25.5	40	1	O	820495
6	25.5	40	1	O	170779
6,35	25.5	40	1	S	821421
7	25.5	40	1	S	829692
8	25.5	40	1	L	170780
9	25.5	40	1	S	825190
9,5	25.5	40	1	S	168739
10	25.5	40	1	L	170781
12	25.5	40	1	L	168740
12,7	25.5	40	1	S	830156
13	25.5	40	1	O	821221
16	25.5	40	1	L	168741

Precision collets - 430E/ER25, 470E/ER32, 472E/ER40

Product



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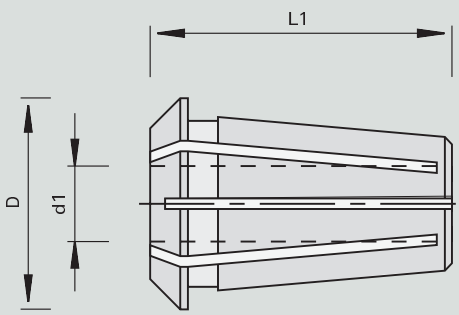


Machine

Application

Design

Machine / Application

- for use in draw-in collet chuck Type 430E/ER25, 470E/ER32, 472E/ER40

Design

- slotted from top and bottom
- clamping tolerance 1 mm

Advantages

Notes

- type 430E/ER25 Ø 6 - 16 mm for special chuck
- type 470E/ER32 Ø 3 - 20 mm
- type 472E/ER40 Ø 6 - 25 mm

Product features

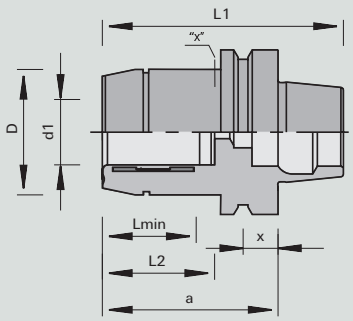
Order information

Ø d1 [mm]	Ø d1 [inch]	Ø D [mm]	L1 [mm]	Type	PU [pc.]	L	Order-No.
3		33	40	470E/ER32	1	S	173647
4		33	40	470E/ER32	1	S	173648
5		33	40	470E/ER32	1	S	173649
6		33	40	470E/ER32	1	L	173650
7		33	40	470E/ER32	1	S	173651
8		33	40	470E/ER32	1	L	173652
10		33	40	470E/ER32	1	L	173653
12		33	40	470E/ER32	1	L	173654
13		33	40	470E/ER32	1	S	173655
14		33	40	470E/ER32	1	S	173656
16		33	40	470E/ER32	1	L	173657
18		33	40	470E/ER32	1	S	173658
19		33	40	470E/ER32	1	S	173659
20		33	40	470E/ER32	1	L	173660
	1/4"	33	40	470E/ER32	1	L	175829
	1/2"	33	40	470E/ER32	1	L	175830
	5/8"	33	40	470E/ER32	1	S	175831
	3/4"	33	40	470E/ER32	1	S	175832
6		41	46	472E/ER40	1	O	180912
8		41	46	472E/ER40	1	L	180913
10		41	46	472E/ER40	1	O	180914
12		41	46	472E/ER40	1	L	175833
16		41	46	472E/ER40	1	L	175834
18		41	46	472E/ER40	1	O	175835
20		41	46	472E/ER40	1	L	175836
25		41	46	472E/ER40	1	L	175837
	1/4"	41	46	472E/ER40	1	S	175838
	1/2"	41	46	472E/ER40	1	O	175839
	5/8"	41	46	472E/ER40	1	S	175840
	3/4"	41	46	472E/ER40	1	S	175841
	1"	41	46	472E/ER40	1	S	175842
6		26	34	430E/ER25	1	S	181986
8		26	34	430E/ER25	1	L	181987
10		26	34	430E/ER25	1	L	181988
12		26	34	430E/ER25	1	L	181989
14		26	34	430E/ER25	1	S	181990
16		26	34	430E/ER25	1	L	181991

Hydro Clamping Chucks ps-System with HSK 63F shank

Product

Drawing



Machine

CNC

Application

Design

HSK

max. 30.000 U/min

MC

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 30,000 min -1
- interface DIN 69893 HSK 63 F

Advantages

- minimization of setup-times thanks to easy and quick tool change
- high cutting quality and long edge lives thanks to high concentricity
- optimum torque transfer

Notes

- for right- and lefthand rotation
- with bore for installation of micro chips for electronic tool detection
- x = pressurization by means of screwdriver
- hexagonal screwdriver is not included in delivery
- Lmin minimum clamping length = minimum shaft length

Product features									Order information			
Ø d1 [mm]	Lmin [mm]	L2 [mm]	Ø d [mm]	Ø D [mm]	L1 [mm]	a [mm]	x [mm]	Weight [kg]		PU [pc.]	L	Order-No.
10	31	41	HSK 63F	30	105	80	18	1.2		1	L	184725
12	36	46	HSK 63F	32	105	80	18	1.16		1	L	184306
16	39	49	HSK 63F	38	105	80	18	1.20		1	L	184307
20	41	51	HSK 63F	52.5	105	80	18	1.30		1	L	184308
25	47	57	HSK 63F	52.5	109	84	18	1.28		1	L	184309

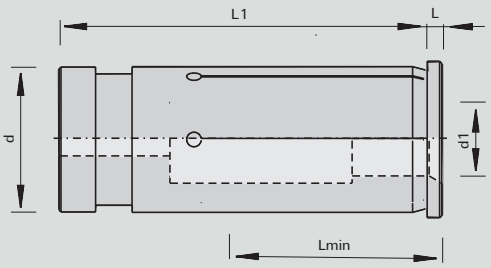
Product features									Order information			
Ø d1 [inch]	Lmin [mm]	L2 [mm]	Ø d [mm]	Ø D [mm]	L1 [mm]	a [mm]	x [mm]	Weight [kg]		PU [pc.]	L	Order-No.
3/8"	31	41	HSK 63F	30	105	80	18	1.2		1	L	184724
1/2"	36	47,5	HSK 63F	32	105	80	18	1.2		1	L	184726

Spare parts	Dimension [mm]	Suitable for		PU [pc.]	L	Order-No.
Screwdrivers	SW4x100	184306, 184724, 184725, 184726		1	L	166091
Screwdrivers	SW5x150	184307, 184308, 184309		1	L	168703

Universal Reducing Bushings

Product

Drawing



Machine

Application

Design

Machine / Application

- for mounting of shank-type tools in Sino, TRIBOS, ps-System

Design

- shank diameter tolerance h7 or g7

Advantages

Notes

- Lmin minimum clamping length = minimum shaft length

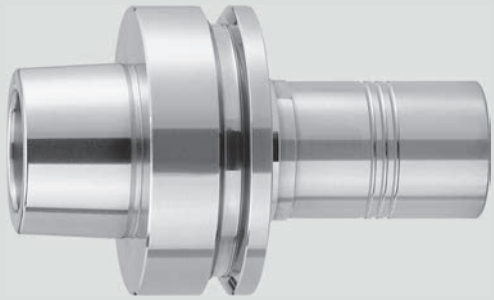
Product features

Order information

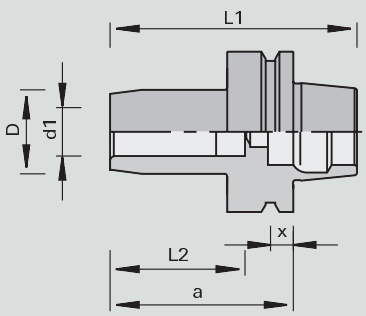
Ø d1 [mm]	Ø d1 [inch]	Lmin [mm]	Ø d [mm]	L1 [mm]	PU [pc.]	L	Order-No.
3		27	12	45	1	O	183022
4		27	12	45	1	S	183023
5		27	12	45	1	O	183024
6		27	12	45	1	L	183025
8		27	12	45	1	L	183026
3		27	20	50.5	1	O	183027
	1/8	27	20	50.5	1	O	186914
4		27	20	50.5	1	O	183028
5		27	20	50.5	1	O	183029
6		27	20	50.5	1	S	183030
8		27	20	50.5	1	L	183032
10		32	20	50.5	1	L	183034
12		37	20	50.5	1	L	183036
14		37	20	50.5	1	O	183038
16		38	20	50.5	1	L	183040
6		27	25	54.5	1	L	182304
8		27	25	54.5	1	L	182305
10		32	25	54.5	1	L	182306
12		37	25	54.5	1	L	182307
14		37	25	54.5	1	L	182308
16		38	25	54.5	1	L	182309
18		38	25	54.5	1	L	182310
20		42	25	54.5	1	L	182311
	1/2"	37	25	54.5	1	L	182653
	3/4"	42	25	54.5	1	L	182655
10		32	16	47.5	1	L	186100
12		37	16	47.5	1	L	186101
8		27	16	47.5	1	L	186099

TRIBOS Power Shrink Chucks

Product



Drawing



Machine

CNC

Application

Design

HSK

max. 40.000 U/min

MC

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 40,000 min-1

Advantages

- low weight is easy on machine bearing
- suitable for high RPM´s
- optimum chip extraction thanks to slim design
- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

- for right- and lefthand rotation
- different diameters upon request
- allowed projection: 4 x d1
- clamping of the tools by means of the clamping device
- can also be done at Stehle upon request
- TRIBOS chuck with reinforced design especially for heavy roughing can be delivered upon request
- delivery without retaining bolts; please choose retaining bolts according to the machine (see page with retaining bolts)

Product features / Order information

Ø d1 [mm]	L2 [mm]	Ø d [mm]	Ø D [mm]	L1 [mm]	a [mm]	x [mm]	Weight [kg]	PU [pc.]	L	Order-No.
12	48,5	HSK 63F	19	100	75	18	0.69	1	L	180257
16	48,5	HSK 63F	26	100	75	18	0.74	1	L	180899
20	52,9	HSK 63F	30	100	75	18	0.77	1	L	180258
25	55	HSK 63F	35	100	75	18	0.79	1	L	180710

Product features / Order information

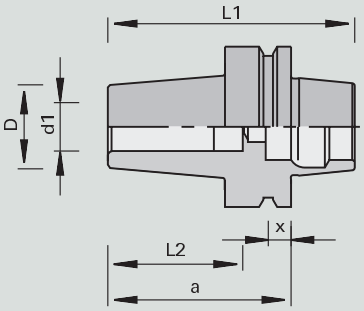
Ø d1 [mm]	L2 [mm]	Ø d [mm]	Ø D [mm]	L1 [mm]	a [mm]	PU [pc.]	L	Order-No.
20	55	SK 30 (DIN)	30	127	80	1	L	180888
25	55	SK 30 (DIN)	35	127	80	1	L	180836

Accessories		PU [pc.]	L	Order-No.
Mounting Devices (manual)		1	L	180261
Mounting Devices (automatic)		1	S	181159
Reducing inserts for Mounting Device	for Ø d = 16	1	L	180902
Reducing inserts for Mounting Device	for Ø d = 6	1	S	183719
Length Adjustment Gauge TRIBOS system	without interface cable	1	S	180828
Reducing inserts for Mounting Device	for Ø d = 8	1	S	183720
Interface Cables for Adjusting Gauges	for RS 232C interface	1	S	180829
Reducing inserts for Mounting Device	for Ø d = 10	1	S	183721
Reducing inserts for Mounting Device	for Ø d = 12	1	L	180263
Reducing inserts for Mounting Device	for Ø d = 20	1	L	180264
Reducing inserts for Mounting Device	for Ø d = 25	1	S	180711

Heat-Shrinking Chucks

Product

Drawing



Machine

Application

Design

HSK

max. 30.000 U/min

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise clamping of shank-type tools with cylindrical shank

Design

- n max = 30,000 min-1
- interface DIN 69893 HSK 63 F
- from high-quality hot work tool steel

Advantages

- increased process safety, long edge lives and high machining quality thanks to very high concentricity and repeating accuracy (< 0.003 mm)

Notes

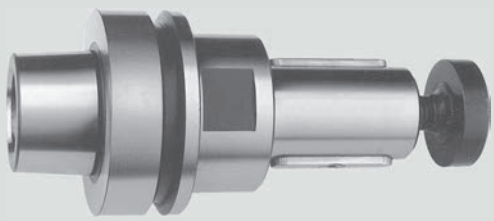
- for clockwise and counter-clockwise rotation
- can be clamped and unclamped with all conventional shrinking devices

Product features / Order information

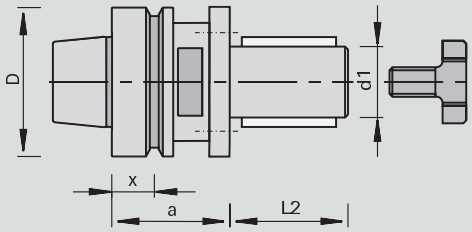
Ø d1 [mm]	L2 [mm]	Ø d [mm]	Ø D [mm]	L1 [mm]	a [mm]	x [mm]	Weight [kg]	PU [pc.]	L	Order-No.
6,0	36	HSK 63F	20	100	75	18	0.797	1	L	186684
8,0	36	HSK 63F	20	100	75	18	0.790	1	L	186685
10	41	HSK 63F	26	100	75	18	0.840	1	L	183081
12	47	HSK 63F	28	100	75	18	0.830	1	L	183082
14	47	HSK 63F	28	100	75	18	0.870	1	L	183083
16	51	HSK 63F	28	100	75	18	0.850	1	L	183084
18	51	HSK 63F	30	100	75	18	0.960	1	L	183085
20	51	HSK 63F	30	100	75	18	0.930	1	L	183086
25	51	HSK 63F	30	100	75	18	0.860	1	L	183087
25	134	HSK 63F	36	185	160	18	1.943	1	L	185520

Mounting Arbors with HSK shank

Product



Drawing



Machine

Application

Design

HSK

R/L

Machine / Application

- CNC machining centers with automatic tool changer
- for precise mounting of tools with bore with double keyway

Design

- with 6 pin holes M6 - 8 mm deep TK 48 mm
- interface DIN 69893 HSK 63 F
- clamping length L2 = 50 mm for multiple-part cutters and cutterheads
- secured against rotation with double key

Advantages

- high feed rates thanks to optimum torque transfer

Notes

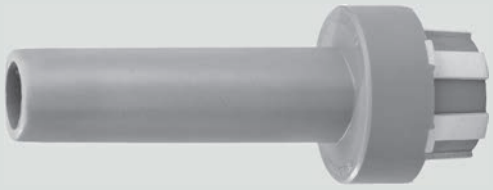
- for clockwise and counter-clockwise rotation
- spacer ring Order-No. 181193 consists of: 1 piece 20 mm thick, 1 piece 10 mm thick, 3 piece 5 mm thick, 2 piece 2 mm thick, 1 piece 1 mm thick
- spacer ring set Order-No. 181194 additionally 1 piece 20 mm thick, 1 piece 10 mm thick
- tool attached with retaining bolt
- included in delivery: clamping arbor with retaining bolt

Product features / Order information

Ø D [mm]	Ø d [mm]	Ø d1 [mm]	L2 [mm]	a [mm]	x [mm]	DKN [mm]		PU [pc.]	L	Order-No.
63	HSK 63F	30	50	45	18	8x3	Homag, IMA from 01/95	1	L	183748
63	HSK 63F	30	80	45	18	8x3	Homag, IMA from 01/95, HOLZ-HER	1	L	183749
63	HSK 63F	30	110	45	18	8x3	Homag, IMA from 01/95, HOLZ-HER	1	L	183747

Spare parts	Dimension [mm]		PU [pc.]	L	Order-No.
Spacer Sets	60x50x30		1	L	181193
Spacer Sets	60x80x30		1	L	181194
Cutter Retaining Bolts with centering ring	M16x38xØ48		1	L	184061
Single-Head Engineers Wrenches	SW46x10 DIN 894		1	L	178760

Cone wiper

Product	Drawing	Machine	Application	Design
		CNC		HSK

Machine / Application	Design	Advantages	Notes
• for cleaning of the inner cones of the cone tool adaptors			• the higly precise machine spindle and clamping chuck needs dust-free fit

Product features	Order information		
Ø d [mm]	PU [pc.]	L	Order-No.
HSK 63	1	L	180911

Mounting device without clamping lever

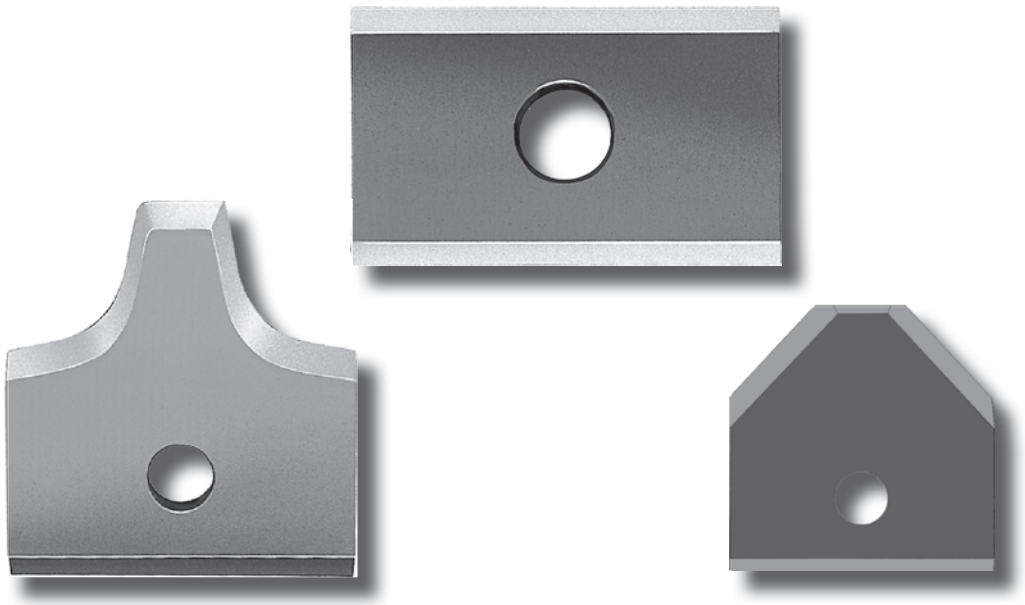
Product	Drawing	Machine	Application	Design
		CNC		HSK

Machine / Application	Design	Advantages	Notes
• for quick and simple mounting and adjusting of cutting tools in draw-in collet chucks or on arbors and tool holders	• mounted on stable pedestal which can be fixed onto workbench	• simplest handling offering highest comfort thanks to roll clamping system, no clamping or jamming necessary	• for all adapters HSK 63 F

Product features	Order information		
Ø d1 [mm]	PU [pc.]	L	Order-No.
HSK 63F	1	L	182467

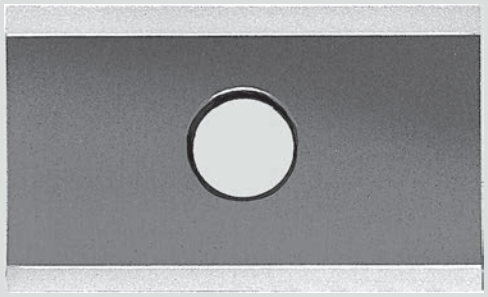
EXCHANGEABLE KNIVES / KNIVES

CONTENTS

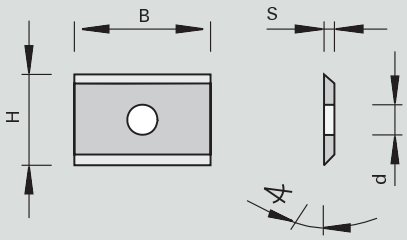


HW Raker Turnover Knives

Product



Drawing



Machine

Application

Design

Machine / Application

Design

- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

- packing unit 10 pieces

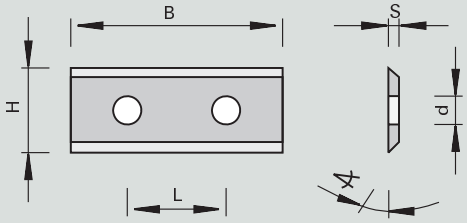
Product features / Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	Wedge∢ [°]	Cutting material		PU [pc.]	L	Order-No.
7,5	12	1.5	4,0	55	TC05		10	L	052543
9,6	12	1.5	4,0	55	TC05		10	L	171163
10,5	12	1.5	4,0	55	TC05		10	L	162636
11	12	1.5	4,0	55	TC05		10	L	162637
11,6	12	1.5	4,0	55	TC05		10	S	50820011
13	12	1.5	4,0	55	TC05		10	L	162638
15,7	12	1.5	4,0	55	TC05		10	L	163846
17	12	1.5	4,0	55	TC05		10	L	162639
18	12	1.5	4,0	55	TC05		10	L	162520
20	12	1.5	4,0	55	TC05		10	L	003082

HW Raker Turnover Knives

Product

Drawing



Machine

Application

Design

Machine / Application

Design

- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

- packing unit 10 pieces

Product features / Order information

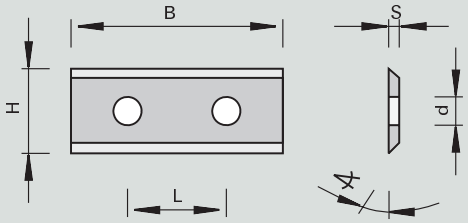
B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge∢ [°]	Cutting material		PU [pc.]	L	Order-No.
30	12	1.5	4,0	14	55	TC05		10	L	003083
40	12	1.5	4,0	26	55	TC05		10	L	164078
50	12	1.5	4,0	26	55	TC05		10	L	003085
60	12	1.5	4,0	26	55	TC05		10	L	003086

HW Raker Turnover Knives

Micrograin quality for extremely long edge lives

Product

Drawing



Machine

Application

Design

2

LONG LIFE

HW **TC02**

Machine / Application

Design

- cutting material: HW
- TC02 for very long edge lives

Advantages

- long edge lives and optimum cutting quality in wood-based panels

Notes

- packing unit 10 pieces

Product features

Order information

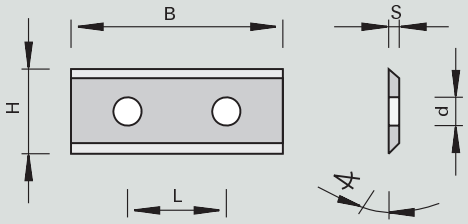
B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge◁ [°]	Cutting material		PU [pc.]	L	Order-No.
30	12	1.5	4,0	14	55	TC02		10	L	176470
50	12	1.5	4,0	26	55	TC02		10	L	176471

HW Raker Turnover Knives

HW micrograin quality for wood-based panels

Product

Drawing



Machine

Application

Design

2

4

HW **TC06**

Machine / Application

Design

- cutting material: HW
- TC06 for wood-based panels

Advantages

- long edge lives and optimum cutting quality in solid woods

Notes

- packing unit 10 pieces

Product features

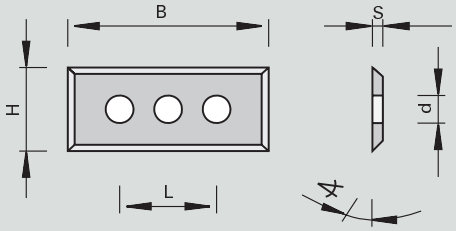
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge◁ [°]	Cutting material		PU [pc.]	L	Order-No.
30	12	1.5	4,0	14	55	TC06		10	L	178288
50	12	1.5	4,0	26	55	TC06		10	L	178289
120	13	2.2	4,0	59-61	55	TC06		10	L	003089

HW Raker Turnover Knives
End sharpened

Product

Drawing



Machine

Application

Design

HW
TC05

Machine / Application

Design
- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

Product features

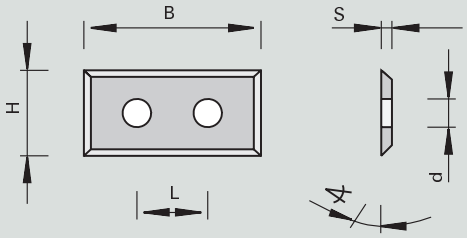
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge∢ [°]	Cutting material		PU [pc.]	L	Order-No.
50	12	1.7	4,0	37	55	TC05		10	L	179994

HW Raker Turnover Knives
For shank-type tools end sharpened

Product

Drawing



Machine

Application

Design

HW
TC05

HW
TC06

Machine / Application
- for use in shank-type cutters

Design
- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

Notes
- packing unit: 10 pieces

Product features

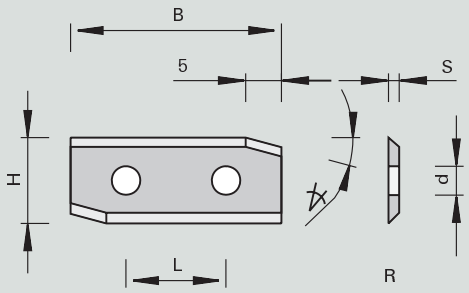
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge∢ [°]	Cutting material		PU [pc.]	L	Order-No.
29,5	12	1.5	4,0	14	55	TC05		10	L	180825
50	12	1.5	4,0	26	55	TC06		10	L	178289

HW Raker Turnover Knives
With chamfer - HOLZ-HER

Product

Drawing



Machine / Application

- machines HOLZ-HER
- for use in edge banding / jointing cutterheads

Design

- grinding angle 55 degrees
- cutting material: HW
- TC06 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

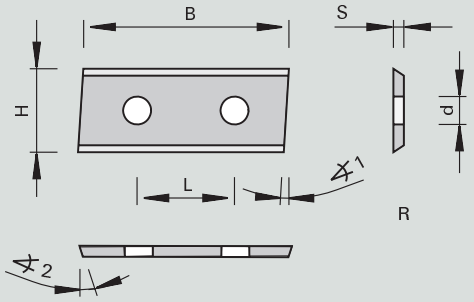
Product features / Order information

Chamfer ◁ [°]	B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Cutting material		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
15	29,5	12	1.5	4,0	14	TC06		10	L	160618	L	160118

HW Raker Turnover Knives
End bevel and end sharpened

Product

Drawing



Machine / Application

- for use in V-grooving cutterheads and prism cutterheads

Design

- grinding angle 55 degrees
- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

Notes

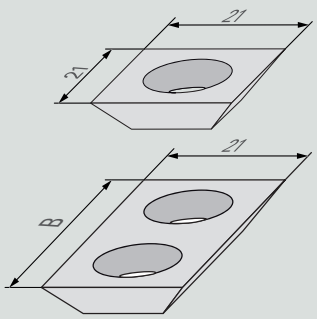
- packing unit: 10 pieces

Product features / Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Clearance ◁1 [°]	Clearance ◁2 [°]	Cutting material		PU [pc.]	L	Order-No. [L]	L	Order-No. [R]
19,5	12	1.5	4,0		3.5	10	TC05		10	L	160626	L	160625
29,5	12	1.5	4,0	14	5		TC05		10	L	003119	L	003118
49,2	12	1.5	4,0	26	5		TC05		10	L	003121	L	003120

HW Turnover Knives

Product | Drawing | Machine | Application | Design





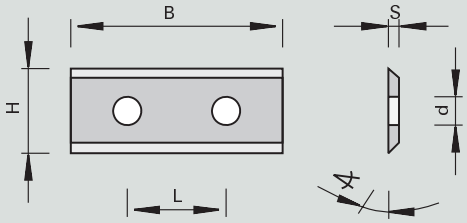
Machine / Application	Design	Advantages	Notes
• for use in cutterheads	• cutting material: HW • TCw30 for hard woods and soft woods		

Product features | Order information

		Cutting material		PU [pc.]	L	Order-No.
HWM221 Turnover Knives HW (hard wood)	21x21x5,5 4 cutting edges	TCw30		10	L	186668
HWM222 Turnover Knives HW (hard wood)	30x21x5,5 4 cutting edges	TCw30		6	L	50651530
HWM223 Turnover Knives HW (hard wood)	40x21x5,5 2 cutting edges	TCw30		6	L	50651540
HWM224 Turnover Knives HW (hard wood)	50x21x5,5 2 cutting edges	TCw30		6	L	50651550

HW Raker Turnover Knives
micrograin quality for solid wood

Product | Drawing | Machine | Application | Design





LONG LIFE

HW TCw20

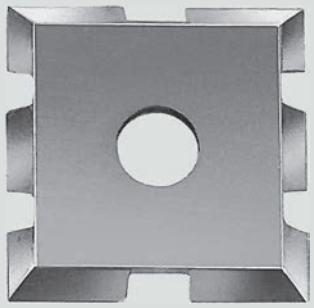
Machine / Application	Design	Advantages	Notes
	• cutting material: HW • TCw20 for solid woods	• long edge lives and optimum cutting quality in solid woods	• packing unit 10 pieces

Product features | Order information

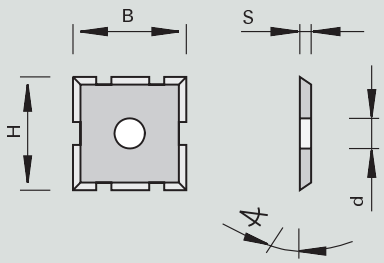
B [mm]	H [mm]	S [mm]	Ø d [mm]	L [mm]	Wedge◁ [°]	Cutting material			PU [pc.]	L	Order-No.
30	12	1.5	4,0	14	45	TCw20			10	L	176266
40	12	1.5	4,0	26	45	TCw20			10	L	176267
50	12	1.5	4,0	26	45	TCw20			10	L	176268
60	12	1.5	4,0	26	45	TCw20			10	L	176269

HW Raker Turnover Knives

Product



Drawing



Machine

Application

Design

Machine / Application

Design

- chip breakers for optimum cut division
- cutting material: HW
- TCw20 for hard woods and soft woods

Advantages

Notes

- packing unit: 10 pieces

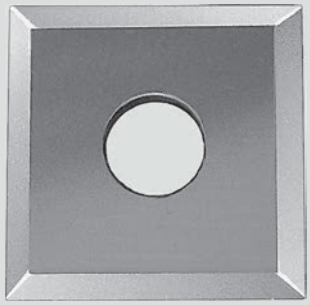
Product features

Order information

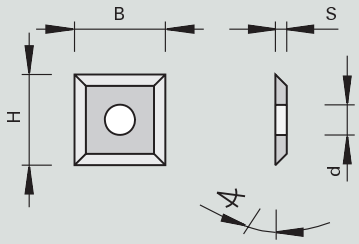
B [mm]	H [mm]	S [mm]	Ø d [mm]		Wedge◁ [°]	Cutting material			PU [pc.]	L	Order-No.
15	15	2.0	4,0		55	TCw20			10	L	167873

HW Turnover Knives

Product



Drawing



Machine

Application

Design

Machine / Application

Design

- cutting material: HW
- TC03 for wood-based panels and plastics
- TC05 for wood-based panels, plastics and hard woods
- TCw30 for hard woods and soft woods
- TCw40 for hard and soft woods

Advantages

Notes

- packing unit: 10 pieces

Product features

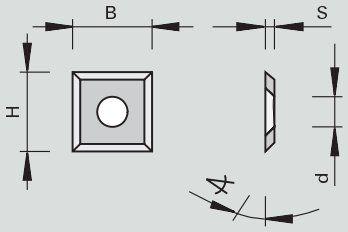
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]		Wedge◁ [°]	Cutting material			PU [pc.]	L	Order-No.
12	12	1.5	4,0		55	TC05			10	L	003080
17	17	2.0	4,0		35	TC05			10	L	50450212
10,5	10.5	1.5	4,0		55	TCw30			10	L	162316
12	12	1.5	4,0		55	TC03			10	L	180820
19	19	2.0	4,0		55	TC05			10	L	162582
27	9	1.5	4,0			TCw05			10	S	50811818
14	14	2.0	6,3		60	TCw30			10	L	003079

HW Turnover Knives
bore with countersink

Product

Drawing



Machine

Application

Design

Machine / Application
- for use in cutterheads

Design
- cutting material: HW
- TCw25 for hard woods and soft woods
- TCw40 for hard and soft woods

Advantages

Notes
- packing unit: 10 pieces

Product features

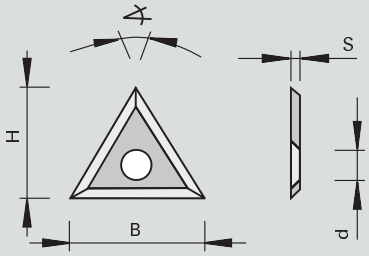
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]	Wedge◁ [°]	Cutting material			PU [pc.]	L	Order-No.
13,6	13.6	2.0	6,3	45	TCw40	Fischer Brugg		10	L	163829
14,3	14.3	2.5	6,3	55	TCw20	Homag (FA20 + FA21)		10	L	170248
15	15	2.5	6,4	60	TCw20	with rounded edges (R=150)		10	L	185274
15	15	2.5	6,2	60	TCw20	with rounded edges (R=50 mm for Spiral Cutterheads)		10	L	180454
15	15	2.5	6,4	60	TCw60	with rounded edges (R=115 mm)		10	S	185950

HW Triangular Spurs

Product

Drawing



Machine

Application

Design

Machine / Application
- for use in Leitz cutterheads

Design
- cutting material: HW
- TCw20 for hard woods and soft woods

Advantages

Notes
- packing unit: 10 pieces

Product features

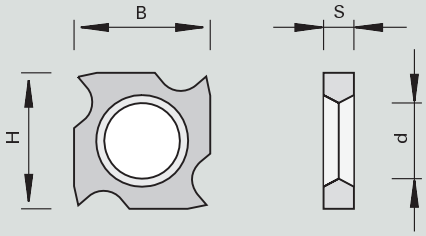
Order information

B [mm]	H [mm]	S [mm]	Ø d [mm]		Corner◁ [°]	Cutting material			PU [pc.]	L	Order-No.
22	19.05	2.0	6,5		60	TCw20			10	L	180779

HW Grooving Turnover Knives

Product

Drawing



Machine

Application

Design

Machine / Application

- for use in grooving cutterheads

Design

- cutting material: HW
- TCw20 for wood-based panels, hard and soft woods

Advantages

Notes

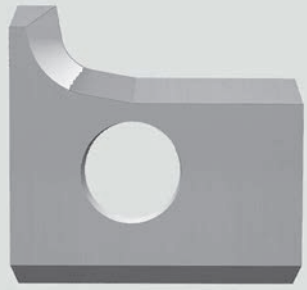
- Order-No. 50450220 for groove width 4 mm
- Order-No. 50450221 for groove width 5 mm
- Order-No. 50450223 for groove width > 7 mm
- packing unit 10 pieces

Product features / **Order information**

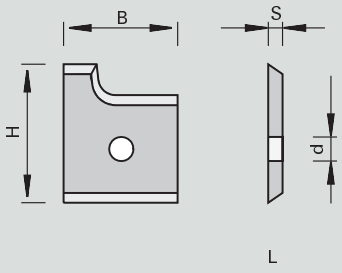
B [mm]	H [mm]	S [mm]	Ø d [mm]	Cutting material	PU [pc.]	L	Order-No.
18	18	1.95	10	TCw20	10	L	50450220
18	18	2.5	10	TCw20	10	L	165906
18	18	3.7	10	TCw20	10	L	169250

HW Radius Profile Knives HW with 1 cutting radius and bottom chamfer

Product



Drawing



Machine

Application

Design

Machine / Application

- for use in edge rounding cutterheads

Design

- cutting material: HW
- TC 06 for wood-based panels, plastics and hard woods

Advantages

Notes

- packing unit: 10 pieces

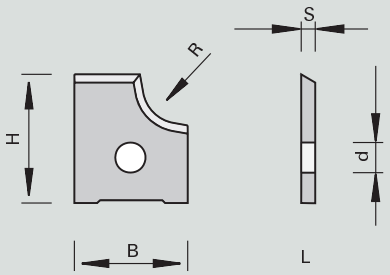
Product features / **Order information**

R [mm]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Cutting material	PU [pc.]	L	Order-No.	L	
2,0	14,5	14.5	2.0	5,0	TC06	10	L	185377	L	185376 NEW
2,5	14,5	14.5	2.0	5,0	TC06	10	L	181657	L	181658 NEW

HW Radius Profile Knives HW with 1 cutting radius

Product

Drawing



Machine

Application

Design

Machine / Application

- for use in rounding cutterheads

Design

- cutting material: HW
- TC 05 for wood-based panels, plastics and hard woods

Advantages

Notes

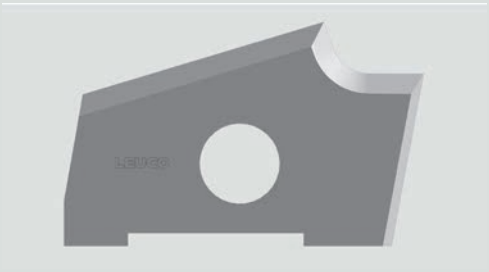
- packing unit: 10 pieces

Product features / Order information

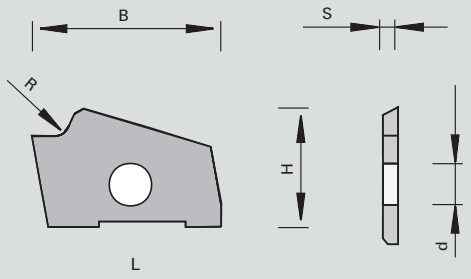
R [mm]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Cutting material		PU [pc.]	L	Order-No.	L	
2,0	15	14.5	2.0	4,0	TC05		10	L	177317	L	177318 NEW

HW Radius Profile Knives HW - Brandt

Product



Drawing



Machine

Application

Design

Machine / Application

- for use in rounding cutterheads with special chip removing design

Design

- cutting material: HW
- TC 06 for wood-based panels, plastics and hard woods

Advantages

Notes

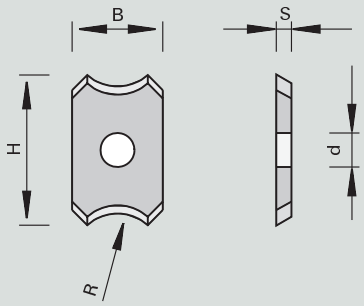
Product features / Order information

R [mm]	B [mm]	H [mm]	S [mm]	Ø d [mm]	LEUCO-DUR		PU [pc.]	L	Order-No.	L	
2,0	22,32	14	2.0	5,0	HL Board 06		10	L	182332	L	182331 NEW

HW Radius Scraper Turnover Knives - Homag, HOLZ-HER

Product

Drawing



Machine

Application

Design

Machine / Application

- edge banding machines Homag PN10, Homag PN20 (to 2015-12-31), HOLZ-HER 1927/1929
- for use in scraper holders

Design

- 6 degree profile run-out
- cutting material: HW
- TC05 for wood-based panels, plastics and hard woods

Advantages

Notes

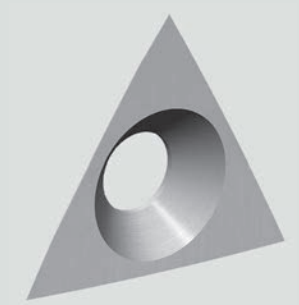
- packing unit: 10 pieces

Product features / **Order information**

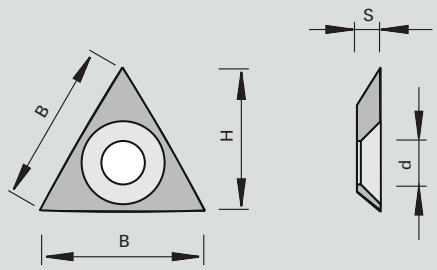
R [mm]	B [mm]	H [mm]	S [mm]	Ø d [mm]	Cutting material				PU [pc.]	L	Order-No.
2,0	12	20	2.0	4,0	TC05				2	L	169255 NEW

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

Product



Drawing



Machine

Application

Design

Machine / Application

- for use in t3-System cutterheads

Design

- Cutting material: HW
- TCW20 for hard wood and soft wood
- TC06 for wood-based materials, plastics and hard woods
- topcoat coating for increased edge lives

Advantages

Notes

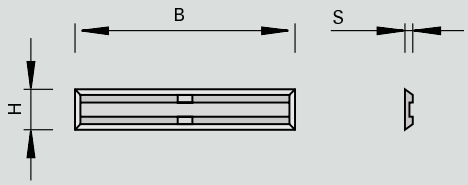
- Turnover knife 9209773 scoring without projection, suitable for jointing without groove

Product features / **Order information**

B [mm]	H [mm]	S [mm]	Ø d [mm]	Cutting material				PU [pc.]	L	Order-No.
20,88	18.3	3.0	5,5	TCw20				10	L	187251
20,88	18.3	3.0	5,5	TC06				10	L	187692 NEW
20,88	18.3	3.0	5,5	HL Solid 20 topcoat				10	L	187694 NEW
20,38	17.9	3.0	5,5	TCw20				10	O	9209773 NEW

HW Mini Turnover Knives

With back- and cross groove

Product	Drawing	Machine	Application	Design
				 HW TC05

Machine / Application	Design	Advantages	Notes
• for use in shank-type cutters	• cutting material: HW • TC05 for wood-based panels, plastics and hard woods		• packing unit: 10 pieces

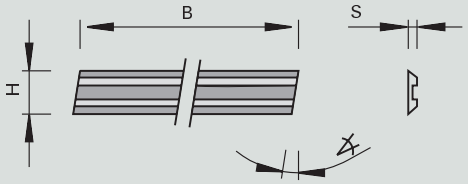
Product features				Order information			
B [mm]	H [mm]	S [mm]		PU [pc.]	L	Order-No.
20	5.5	1.1		10	S	50450151
40	5.5	1.1		10	S	50450154
20	4.1	1.1		10	L	173480
25	5.5	1.1		10	L	173793
50	5.5	1.1		10	L	173483
30	5.5	1.1		10	L	173482

HW Portable Planer Turnover Knives

edge bevel

Product

Drawing



Machine

Application

Design

Machine / Application

- portable planers

Design

- cutting material: HW
- TCw40 for hard and soft woods

Advantages

Notes

- Order-No. 50400212 can only be used in the original ELU clamping element
- minimum order quantity 10 pieces
- packing unit 2 pieces in a bag

Product features / **Order information**

B [mm]	H [mm]	S [mm]	Clearance ◁ 1 [°]			PU [pc.]	L	Order-No.
75,5	5.5	1.1	1.5	AEG HTH 75, Bosch 0590, P400, 1590, 1591, Festo REP 75, Haffner FH 222, HOLZ-HER 2223, 2286, 2320, Kress Jet Star 6701, Mafell HU 75, Metabo 6375, Scheer MH 80, MH 75/3, Skil 98 H		2	S	58400210
80,5	5.9	1.2	8	ELU MFF 80		2	L	58400212
82	5.5	1.1	3	AEG, Fein, Haffner, Hitachi, Mafell, Makita, Metabo, Bosch		2	L	58400214
102	5.5	1.1	3	AEG EH 102, HB 750		2	L	50400215

ABRASIVE

APPLICATION INFORMATION

1 Tools which are marked with a red  in the table head of the products are generally suited for the use in abrasive materials.

2 Acrylic bound mineral fiber boards (artificial marble) can be machined with HW and DP.

3 For materials with large mineral particles, due to the risk of tooth breaking, HW can be used.

4 Machining information for selected materials (The respective formulas and further information can be found in the prefix chapter "Technical Appendix"):

- Cutting speed V_c:
  - Fibre cement board: 40 – 60 m/s
  - Gypsum plaster board: 45 – 65 m/s
  - Gypsum plaster board: 45 – 65 m/s
  - HPL: 50 – 70 m/s
  - GFK: 20 – 50 m/s

- Feed rate per tooth f_z / saw blades:
  - Fibre cement board: 0.02 – 0.05 mm
  - Gypsum fibre board: 0,1 – 0,25 mm
  - Thermoset: 0.03 – 0.05 mm
  - Acrylic based mineral fibre board: 0.03 – 0.05 mm
  - GFK: 0.01 – 0.03 mm

- Feed rate per tooth f_z:
  - Shank-type cutters: > saw blades
  - Cutters with bore: >> shank-type cutters

- Please observe the information of further influences on V_c und f_z by materials, the tool choice and the machine condition in the prefix "General Machining Information". They help to define if you should orient yourself towards the lower or upper area of the indicated range.

5 In the case of composite materials, often one or more abrasive components are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component" which is normally the most abrasive component.

CONSTRUCTION

APPLICATION INFORMATION

1 Tools marked with an orange  in the table head of the products are generally suitable for the application on the construction site. Saw blades marked with orange on the package according to the colour coding system are suitable for soiled materials as well as wood with nails etc.

2 The calculation of V_c and f_z for handheld machines pointless as the mobile machines are normally operated with manual feed and the parameter (e.g. RPM) are not adjustable. In this case you have to test and follow your "feeling" as the machine operator feels the cutting pressure and noise level directly. This is why the prefix lists only a few concrete application parameter. Nevertheless, here too, the same basic principles apply which can be read in the respective chapter prefix.

3 For the machining of soft materials for insulation and sound insulation, tools with high number of teeth should be chosen.

4 Areatec concrete blocks can be easily cut by means of the DP portable saw blades.

5 Application parameter for materials in the area facade, roofing, walls, ceiling, acoustics, sound insulation, flooring, residential construction can be found in the chapters Abrasive, Wood, Panels, Aluminium or Plastic. This is why they are not listed separately.

6 Cutting speed V_c:

- The harder the material to be machined, the lower V_c
- The softer the material to be machined, the higher V_c
- Deviating examples:
  - Rock wool panels: 2 – 8

7 In the case of composite materials, often one or more abrasive components are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component".

1 Solid wood is the basis of the woodworking sector. This chapter lists tools (with few exceptions) for the machining of dried wood, i.e. after saw mill processing. If you need tools for saw mills, please contact the specialist Stehle staff directly.

2 Tools which are marked with a yellow  in the table head of the products are generally suited for the use in solid wood and similar materials.

3 This catalogue does not include our extensive range of finger joint products which Stehle produce for the production of uality laminated timber, gluelam construction timber and solid wood boards. In this instance, please contact our specialists.

4 General machining information for solid wood:

- Wet wood should be sawn with a low number of teeth (cutting quality is normally no criterion).
- Glued laminated timber (BSH/KVH) can be machined like solid wood.
- The feed rate per tooth f_z for thermotreated wood should follow the f_z of the original wood.
- The f_z for cork can be like the f_z of soft wood.
- Cutting with the grain requires a higher f_z than cutting across the grain.
- Continuous cutting edges lead to a better cutting quality in homogeneous materials (e.g. finish cut in solid wood) than interrupted cutting edges.
- As there is no pre-splitting effect, milling with the feed in solid wood leads to an improved surface quality compared to milling against the feed; however, there are more problems with dust extraction and cutting pressure (increase in power consumption. (Milling with the feed is not permitted on spindle shapers)
- Milling with the feed is applied in the case of finishing of solid wood edges or in grooving operations

WOOD

APPLICATION INFORMATION

5 Machining information for selected materials (The respective formulas and further information can be found in the prefix: „Technical Appendix"):

- cutting speed V_c:
  - Soft wood: 60 – 100 m/s
  - Hard wood: 60 – 100 m/s
  - Exotic hard wood: 50 – 85 m/s
  - Veneer: 70 – 100 m/s
  - Highly compressed wood: 40 – 65 m/s
- Feed rate per tooth f_z / saw blades:
  - Hard wood longitudinal cut: 0.1 – 0.4 mm
  - Hard wood cross cut: 0.05– 0.09 mm
  - Soft woods
  - Longitudinal cut: 0.15 – 0.7 mm
  - Wet soft wood longitudinal cut: 0.3 – .0.9 mm
  - Soft wood cross cut: 0.1 – 0.2 mm
- Feedrate per tooth f_z /planing cutterheads:
  - Finishing quality: 1.0 – 1.5 mm
  - Middle quality: 1.5 – 2.5 mm
  - Roughing quality: 2.5 – 5.0 mm
- Feedrate per tooth f_z /universal milling:
  - Finishing quality: 1.0 – 1.5 mm
  - Middle quality: 1.5 – 2.5 mm
  - Roughing quality: 2.5 – 5.0 mm
- Feedrate per tooth f_z /CNC shank-type cutters:
  - Solid wood: 0,2 – 0,3 mm

6 In the case of composite materials, often one or more components with specific requirements are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component". Normally, this is not solid wood.

1 In the meantime, panel processing is the focus of activity for residential construction, shopbuilders, trade show display manufacturers and furniture manufacturers. Many machines are perfectly adapted for this task.

2 Tools which are marked with a green  in the table head of the products are generally suited for the use in wood-based panels

3 General machining information for wood-based panels:

- In general, wood-based panels can be machined with HW cutting edges; DP cutting edges are ideal if the volume to be machined or abrasive coatings or components make them economical.
- Due to the production process, wood-based panels often include sand and other dirt particles. As these lead to faster blunting of the tools DP cutting edges are increasingly used in series production.
- For the production of wood-based panels old wood is recycled to an increasing extent. Pollution and other residuals can cause chipped edges on DP tools.
- Continuous cutting edges lead to a better cutting quality in homogeneous materials (MDF) than interrupted cutting edges.
- Plywood requires tools which are suitable for cutting along and across the grain at the same time. The cutting edges normally wear due to the high amount of glue.
- In the case of laminated wood-based panels the tool choice depends on the coatings.
- An increase of cutting quality of the top and bottom edge of laminated wood-based panels can be reached thanks to opposing shear angles.
- The thinner the coating of a wood-based panel the more aggressive tooth configurations should be chosen for saw blades and the larger the shear angle should be chosen for milling tools.

PANELS

APPLICATION INFORMATION

4 Machining information for selected materials (The respective formulas and further information can be found in the prefix: „Technical Appendix"):

- **Cutting speed V_c:**
  - Particle board veneered on both sides: 60 – 90 m/s
  - Multiplex: 40 – 65 m/s
  - Directly laminated melamine particle board: 60 – 80 m/s
  - Raw particle board: 50 – 80 m/s
  - Hardboard: 50 – 80 m/s
  - Softboard: 60 – 100 m/s
  - Foil coated particle board: 60 – 80 m/s
  - MDF: 60 – 80 m/s

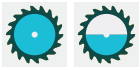
- **Feed rate per tooth f_z / saw blades:**
  - OSB board: 0.12 – 0.2 mm
  - Veneered panel: 0,02 – 0,09 mm
  - Wood core plywood: 0.03 – 0.12 mm
  - Melamine coated particle board: 0.04 – 0.06 mm
  - HPL coated particle board: 0.02 – 0.1 mm
  - Plywood: 0.04 – 0.1 mm
  - Hardboard: 0.03 – 0.07 mm
  - Pressed laminated wood: 0.02 – 0.05 mm

- **Feedrate per tooth f_z / grooving tools:**
  - Raw particle board: 0.4 – 0.75 mm
  - Veneered particle board: 0.1 – 0.15 mm
  - Laminated particle: 0,18 – 0,38 mm
  - Middle layer wood-based panels: 0.3 – 0.65 mm

- **Feedrate per tooth f_z /universal milling:**
  - Finishing quality: 1.0 – 1.5 mm
  - Middle quality: 1.5 – 2.5 mm
  - Roughing quality: 2.5 – 5.0 mm

- **Feedrate per tooth f_z /CNC shank-type cutters:**
  - Solid wood and veneered-panels: 0.2 – 0.3 mm
  - Wood particle boards: 0.25 – 0.35 mm
  - Wood fibre boards: 0.25 – 0.3 mm

5 In the case of composite materials, often one or more abrasive or deviating components are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component". Normally, this is not the wood-based panel.

1 Tools which are marked with a bluein  the table head of the products are generally suited for the use in NF-metals.

2 General machining information for aluminum and NF-metals:

- When processing NF metals, pay attention to hot chips.
- Aluminum with a low percentage of silicate can be machined with HW cutting edges. An increasing silicate share causes high wear and makes DP cutting edges more efficient.
- When cutting aluminum, due to the danger of rebound, handheld chop and table saws should be equipped with saw blades with negative hook angle. Positive hook angles should be used only with tight material clamping and an appropriate entrance angle.
- Continuous cutting edges lead to a better cutting quality in homogeneous materials (aluminum) than interrupted cutting edges.
- The cutting speed of shank-type cutters depend on the cutter diameter; the larger the Ø, the higher the cutting speed.
- The cutting speed of shank-type cutters also depends on the mode of application. In the case of finish-cutting it should be higher than in the case of roughing.
- Compared to finish-cutting, high-speed processing requires cutting speeds increased by approx. 12%and a decidedly lower feedrate per tooth f_z.
- The harder anodized aluminum, the < f_z
- The higher the hogger volume, the < f_z

ALUMINUM

APPLICATION INFORMATION

3 Machining information for selected materials (The respective formulas and further information can be found in the prefix: „Technical Appendix"):

- **Cutting speed V_c/saw blades:**
  - Pure aluminum: 60 – 80 m/s
  - Anodized aluminum: 40 – 60 m/s
  - Al-Si alloy: 15 – 40 m/s

- **Cutting speedV_c / shank-type cutters:**
  - Pure aluminum: 3 - 7.5 m/s
  - Al-Si alloy (< 10% Si content): 6 – 9.5 m/s
  - Al-Si alloy
  - (< 10% Si content): 5 – 8 m/s
  - Copper / brass / bronze: 2.5 – 5.8 m/s

- **Feed rate per tooth f_z / saw blades:**
  - Aluminum wrought alloy: 0.02 – 0.1 mm
  - Aluminum casting alloy: 0.01 – 0.05 mm
  - Thin-walled profiles / sheets (< 2mm): 0.02 – 0.04 mm
  - Thick-walled profiles / sheets: 0.04 – 0.18 mm

- **Feedrate per tooth f_z / grooving tools:**
  - NF metals: 0.02 – 0.05 mm

- **Feedrate per tooth f_z / shank-type tools:**
  - Pure aluminum: 0.12 – 0.3 mm
  - Al-Si alloy (< 10 % Si content): 0.01 – 0.3 mm
  - Al-Si alloy (> 10 % Si content): 0.02 – 0.3 mm
  - Copper / brass / bronze: 0.03 – 0.24 mm

4 In the case of composite materials, often aluminum or NF metal components are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component". As this is often aluminium, tools from this chapter are also used for composite materials.

STEEL

APPLICATION INFORMATION

1 Tools listed in the catalog are suitable for residential construction companies, shop builders and trade show display manufacturers who deal with steel now and then or for the machining of composite materials with steel / stainless steel components. They are not suitable for pure metal working companies.

2 Even if some of the saw blades can be used on Dry-Cut machine, they are mainly designed for woodworking machines.

3 Ferrous metals / steel are certainly the limiting factor for the use of woodworking tools. Thus, for this combined use, cutting materials and tooth geometries were chosen which meet more or less the demands of wood-based panels as well as steel.

4 Block material should not be processed with these tools. The thickness of profiles and metal sheets should not exceed 3 mm.

5 Tools which are marked with a grey  in the table head of the products are suited on a limited basis for the use in steel and stainless steel.

6 Machining information for selected materials (The respective formulas and further information can be found in the prefix: „Technical Appendix"):

- **Cutting speed V_c / saw blades:**
  - Steel: 40 – 60 m/s
  - Stainless steel: 30 – 45 m/s
  - Designed for manual feed (2 – 7 m/min)

7 recommended RPM for our programm:

- 1/min (RPM):
  - Ø160 = 2750 min-1
  - Ø190 = 2350 min-1
  - Ø216 = 2050 min-1
  - Ø230 = 1950 min-1

- 1/min (RPM):
  - Ø250 = 1750 min-1
  - Ø305 = 1500 min-1
  - Ø355 = 1250 min-1

8 In the case of composite materials, often steel or stainless steel components are included in one or the other way. The basic rule to choose the most difficult to machine component for orientation is most relevant in this case. If steel / stainless steel components are included, they will be the decisive component as pure woodworking tools are damaged when they come into contact with steel. This is why tools listed in this chapter are also used for composite materials.

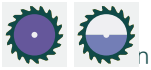
PLASTIC

APPLICATION INFORMATION

1 Plastics have become an integral part of the woodworking trade. They appear in pure form and in composite materials.

2 Often plastics are so much integrated in composite materials that they are no longer even perceived as such. Just think of laminated panels or porch panels made from WPC. The application parameter for HPL laminated particle boards can be found in the chapter PANEL, however, they can also be derivated from the pure form in the chapter PLAST.

3 Plastics can be distinguished in three groups with different machining conditions: the thermoplastics, the thermosets as well as the elastomeres. In addition, there are composite materials, whose variety is almost unlimited by now, not only combined with wood-based panels, metals, glass, etc. but also in combination with each other.

4 Tools which are marked with a purple  in the table head of the products are generally suited for the use in plastics (however the differences between plastics e.g. thermoset and thermoplastic are so huge that they are not necessarily ideal for both)

5 General machining information for plastics:

- Thermoplastic and elastomeres can generally be machined with HW cutting edge.
- From the economic point of view, Thermosets should be machined with DP cutting edges.
- Thermoplastic can be machined with low cutting speed.
- As soon as plastics begin to smear or agglutinate: reduce RPM.
- Continuous cutting edges lead to a better cutting quality in homogeneous materials such as block plastics than interrupted cutting edges.
- Fibre-reinforced plastics (GFK, CFK, AFK) require very stable tools. In the case of shank-type cutters generally choose a VHW tool body.
- In the case of fibre-reinforced plastics (GFK, CFK, AFK) reduce RPM on CNC machining centers to 8,000 - 12,000 1/min if possible.
- The machining of polypropylene (PP) creates voluminous chips; thus, tools with large gullets and a low number of teeth should be chosen.
- Postprocessing of brilliant surfaces and block materials such as acrylic glass (PMMA) can be made with Monodia tools with optimal finish.

6 Machining information for selected materials (The respective formulas and further information can be found in the prefix: „Technical Appendix"):

- **Cutting speed V_c:**
  - Polycarbonate / acetate: 6 – 8 m/s
  - PVC: 2,5 – 4 m/s
  - PMMA: 6 – 8 m/s
  - HPL solid core panels: 15 – 50 m/s
  - Phenolic resin material: 1.5 – 3.5 m/s
  - High-pressure laminated boards: 50 – 70 m/s
  - HPL: 50 – 70 m/s
  - GFK: 20 – 50 m/s

- **Feed rate per tooth f_z / saw blades:**
  - Thermoplastic-solid core panels 0.05 – 0.1 mm
  - HPL solid core panels: 0.01 – 0.05 mm
  - Acrylic based mineral fiber board: 0.03 – 0.05 mm
  - GFK: 0.01 – 0.03 mm

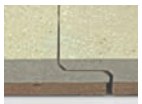
- **Feed rate per tooth f_z / grooving tools:**
  - Thermoplastics: 0.2 – 0.5 mm
  - Thermoset: 0.03 – 0.05 mm

- **Feed rate per tooth f_z /CNC shank-type cutters:**
  - Thermoplastics: 0.,2 – 0.3 mm
  - Polycarbonate / acetate: 0.12 – 0.6 mm
  - PVC: 0.12 – 0.6 mm
  - PMMA: 0.12 – 0.6 mm
  - Phenolic resin material: 0.12 – 0.6 mm
  - Laminate: 0.2 – 0.3 mm
  - HPL solid core panels: 0.,2 – 0.3 mm
  - Acrylic bound mineral fibre board: 0.01 – 0.25 mm
  - GFK, CFK, AFK: 0.05 – 0.15 mm
  - Elastomeres: 0.2 – 0.3 mm

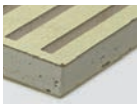
7 In the case of composite materials, often one or more plastic components are included. If the optimal machining parameter are unknown it is useful to chose "the most difficult to machine component". This can be plastic, e.g. if GFK components are included, thermoplastic melts or an elastomer tears instead of being cleanly cut.

MATERIAL SUITABILITY


Gypsum fibre board


Gypsum fibre board with MDF


Gipsfaserplatte mit Furnier


Gypsum plaster board


Fibre cement board

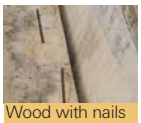

Wood fibre


Mineral wool / clay

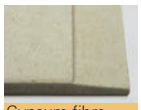

GFK Gitterrost


Gasbetonstein

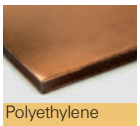
ABRASIVE


Wood with nails


Mineral wool / clay


Gypsum fibre board

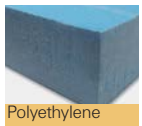

Fibre cement


Polyethylene


Wood fibre


Cement soiled boards


Gasbetonstein


Polyethylene

CONST-RUCTION

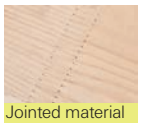

Round wood

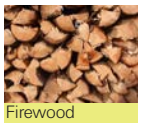

Board material


Beams


Battens

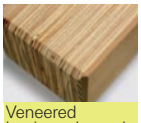

Planed material


Jointed material


Firewood


Gluelam con-struction timber


Quality laminated timber


Veneered laminated wood


Glued laminated timber boards


Oak


Beech


Larch


Bangkirai


Coconut


Spruce


Poplar


Balsa


Ash


Fir


Cork

WOOD

Plywood

Multiplex

Wood core plywood

OSB/ Particle board

Raw particle board

Veneered particle board

Melamine lamina-ted particle board

CPL laminated acous-tic particle board

HPL laminated particle board

High gloss foiled particle board

(Soft) Fibre board

Raw MDF

Lacquered MDF

Twin-wall panel

Lacquered MDF profile

Hardboard

Flooring panel

Construction profile

Honeycomb panel

Blockboard

MDF-Polystyrene panel

Holz-PMMA

Wood core plywood

PANELS

Block material

Hollow profile

Honeycomb panel

Foam

Zinc

Copper

Alu polyethylene

Ali HPL

Ali sandwich board with PU filling

ALUMI-NIUM

Steel

Steel

Stainless steel wall board

Square tube

Stainless steel sun protection

Steel grid

Iron covered particle board

Steel sandwich board with PU filling

Steel-plastic acoustic element

STEEL

PMMA - block material

PMMA - acrylic glass

PC (polycarbo-nate)

PE block material

PS (polystyrene)

PVC - vinyl flooring

PET honeycomb core

HPL laminate

Rubber

PLASTIC

TECHNICAL APPENDIX

Product Information / Technical Information

1 CUTTING MATERIAL

— TUNGSTEN CARBIDE (HW)

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

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

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

— POLYCRYSTALLINE DIAMOND (DP)

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

— MONOCRYSTALLINE DIAMOND (DM)

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

— HIGH-SPEED STEEL (HS)

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

2 To reach optimal **cutting quality** and excellent **edge lives** the machining parameter must be adapted to the workpiece materials. An experienced machine operator will feel it in his bones whether the application parameters used are correct. Watching the shape and size of the chips, vibrations and noise levels often is the easiest way in order to approach optimum parameters and use of the tool on the particular machine.

3 Guidelines for an optimal result can be derived from the **cutting speed** and the **feed rate per tooth**. These depend on the type of tool (mode of application), the diameter of the tool and the material to be machined. On this basis the parameters which the machine operator can influence, the RPM and the feed rate, can be calculated usually. They also serve as an aid for the selection of the right tool.

4 Basis **cutting speed V_c** (in m/sec):
The cutting speed calculation determines the optimal RPM for a specific material with a given tool diameter.
The formula is as follows:

$$n = \frac{V_c \times 1.000 \times 60}{\pi \times D}$$

- Calculation example:
  - Workpiece material: melamine-laminated particle board
    V_c = 60–80 m/sec
  - Machine/application: sizing cut on table saw
  - Applied tool: saw blade with diameter 300 mm
  - Calculation:
    $$n = \frac{70 \times 1.000 \times 60}{3{,}14 \times 300} = 4.458\ 1/\text{min}$$
  - Result:
    The ideal RPM for excellent cutting quality and edge life is approx. 4,500 1/min, which is typical for a table saw.

- The only variable which can be changed with a given material is the tool diameter.

- For the cutting speed there are no rigid figures but a recommended range based on experience. These ranges are listed in the respective tables. The figures apply for HW saw blades. For HW cutters the figures are lower by 10-15%.

- Factors influencing V_c :
  - The harder the material to be machined, the lower V_c
  - The softer the material to be machined, the higher V_c

5 Basis **feed rate per tooth f_z** (in mm):

The calculation of the feed rate per tooth determines the optimal feed V_f for a specific material with given RPM and number of teeth. The formula is as follows:

$$V_f = \frac{f_z \times n \times Z}{1{,}000}$$

- Calculation example:
  - Material to be machined: solid oak f_z = 0,2 mm
  - Machine/Application: grooving on CNC machining center n = 18,000
  - Applied tool: saw blade with diameter 300 mm
  - Calculation:

$$V_f = \frac{0{,}2 \times 18.000 \times 2}{1.000} = 7{,}2 \text{ m/min}$$

  - Result:
    With Z = 2 a feed or approx. 7 m/min is recommended. If a higher feed is desired it can be obtained by means of a higher RPM, e.g. 24,000 1/min. With this RPM the feed would reach 9.6, i.e. approx. 10 m/min with constant cutting quality and edge life. In addition (or alternatively) a tool with 3 cutting edges can be used. Then the feed reaches approx. 15 m/min.

- The changeable variables with a given material are thus the RPM and the number of cutting edges of the tool. Ideally, the RPM should be defined previously by the calculation of cutting speed.

- As for the cutting speed there are no rigid figures for f_z as well but a recommended range based on experience. These ranges are listed in the respective tables. The chapter introductions give recommendations with regard to f_z for the different materials. They also list the factors which can influence these values.

6 Factors influencing f_z:

- Within a material category there can be clear differences depending on the material consistency; thus the standard values are not binding.
- The "heavier" the machining process, the < f_z.
- In the case of composite materials, the most abrasive, toughest, hardest" material determines f_z.
- An increasing f_z reduces the edge life of the cutting edge.

7 General influences on the cutting quality:

- The < f_z the > the cutting quality
- The > the shear angle of the cutting edge the > the cutting quality
- The better the chip transportation the > the cutting quality (spiral shank design, shear angle and chip directed design are better than straight shank/cutting edge)
- The < the cutting pressure the > the cutting quality (< f_z, shear angle, > hook angle and chip breaker result in < cutting pressure)
- Continuous cutting edges lead to a better cutting quality in homogeneous materials than interrupted cutting edges.

8 SAWS

— **DUE TO NARROWER TOLERANCES, DP saw blades can be applied with higher feed rate f_z than HW saw blades.**

— **Increasing material thickness requires the reduction of the number of teeth.**

— **PIN HOLES and KEYWAY**

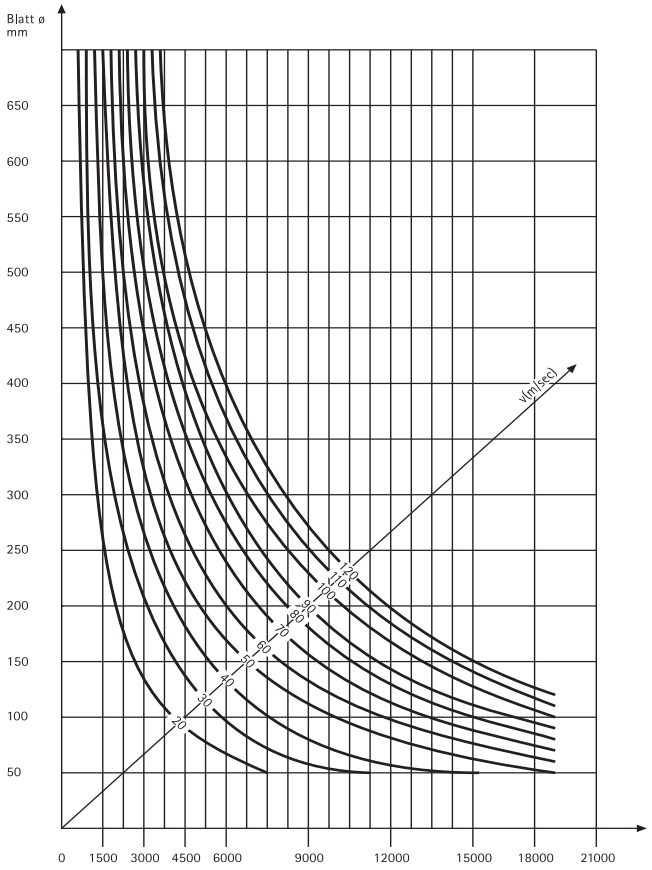
Pin Holes
Ex.: 2/10/60

Combi pin holes

Double Keyway (DKW)

Keyway
(KW)

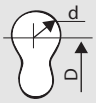
— **Recommended cutting speed in m/sec**



COMBI1

2/10/60
+ 2/7/742

COMBI2



2/10/60
+ 2/9/46
+ 2/7/42

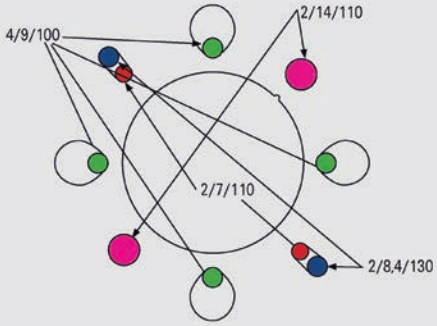
COMBI3

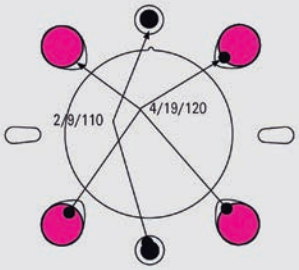
2/10/60
+ 2/9/46
+ 2/9,5/46,5
+2/7/42

COMBI4

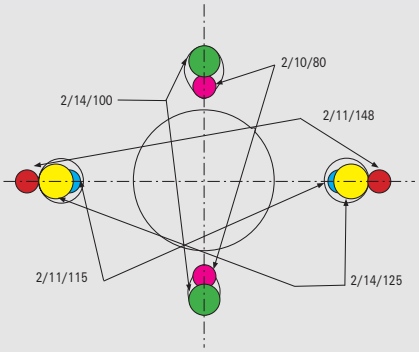
2/2/99,5
+ 2/3,3/48

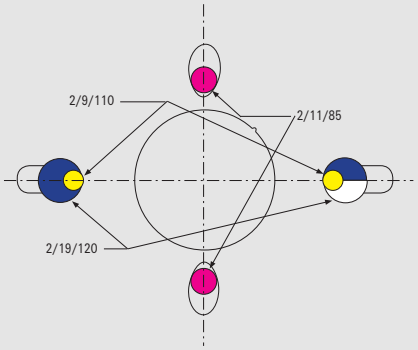
COMBI5





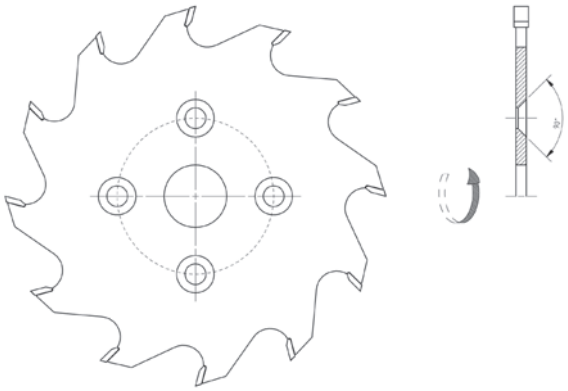
COMBI7



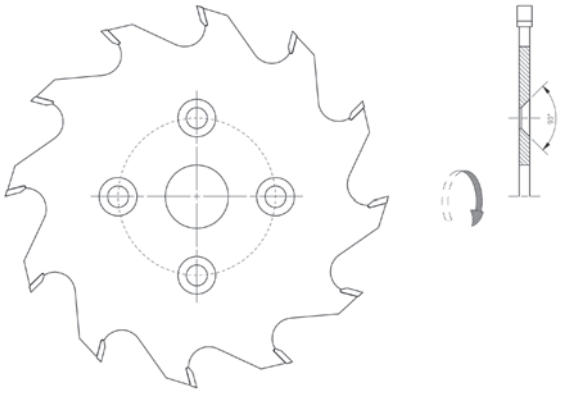


— COUNTERSINK FOR PINHOLES

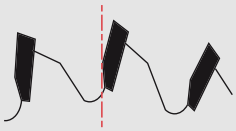
Countersink from clockwise
= Countersink left hand



Countersink from anticlockwise
= Countersink right hand

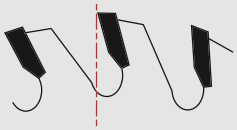


— HOOK ANGLE



Negative hook angle

Negative hook angle: generally for cross-cut saws, pendulum saws in wood, wood-based panels, NF metals and plastics as well as for materials prone to rebound with good workpiece clamping.



Positive hook angle

The softer the material, the larger the hook angle - typically 20° for cutting with the grain in soft wood, 15° for cutting with the grain in hard wood, 10° for wood-based panels and cross cuts in wood and 8° for NF metals and plastics.

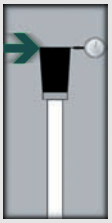
— CUTTING MATERIAL:

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

- Cutting materials for wood–based panels, composite materials and universal application:
  TC03 TC20
  TC04 plus TC25
  TC06
  TC10
- Cutting materials for solid wood:
  TCw15
- Cutting materials for metal working:
  TCx03
  TCm17

— QUALITY LEVEL OF SAW BLADES

HW Grade, Grain size

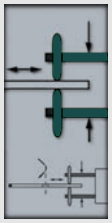


Runout Tolerance

Concentricity Tolerance

Symmetry

Bore Tolerance

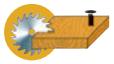
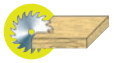
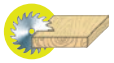
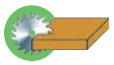
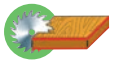
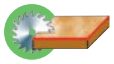
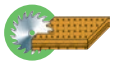


Machine - Controlled Adjustment and Alignment

Hand- and Machine-Controlled Adjustment and Alignment

• **Quality level 1-0-1**	The standard quality especially for portable saws	▸ Laser cut body ▸ Optimal cutting material for the respective application ▸ Precise production tolerances ▸ Large tungsten carbide tips for maximum regrinds ▸ Machine-controlled adjustment and alignment
• **Quality level 2-0-6**	The standard quality for table machines, clipping and miter saws with excellent price-performance-ratio	▸ Laser cut body ▸ Application-specific tungsten carbide ▸ Tight production tolerances ▸ High concentric and runout precision ▸ Application-specific noise reduced design ▸ Machine-controlled adjustment and alignment
• **Quality level 3-0-1**	The highest quality level especially for industrial application on stationary machines.	▸ Laser cut body ▸ Application-specific micrograin carbide ▸ Extremely tight production tolerances ▸ Highest concentric and runout precision ▸ Noise reduced design ▸ Hand- and machine-controlled adjustment and alignment

— MATERIAL SUITABILITY SAW BLADES

MATERIAL		
ABRASIV ABRASIV	Mineral wood-based panels (e.g. gypsum fibre boards and fiber cement boards)	
	Hard and abrasive plastics and composite materials	
BAU CONSTRUCTION	Construction woods Formwork panels Wood with nails Cement soiled boards	
HOLZ WOOD	Longitudinal cut in hard and soft woods, wet and dry	
	Longitudinal cut in woods with long fibers Cross cut in solid wood and wood-based panels	
PLATTE PANELS	Raw particle boards Solid wood, wood core plywood and plywood	
	Veneered and paper-laminated panels	
	Melamine laminated and foil coated panels	
	HPL / CPL laminated panels Abrasive composite materials	
	Solid wood edges, plastic and veneer edges	
ALU ALU	Profiles, metal sheets and NF composite materials Aluminum and NF metals	
STAHL STEEL	Dividing cuts in metal sheets, profiles, NF metals and cast iron	
	Stainless steel sheets, composite material with stainless steel coating / steel reinforcement	
PLAST PLAST	Dividing and miter cuts in profiles made from thermoset, thermoplastic (e.g. Acrylics, PMMA, PE, PP, ...)	
	Dividing and sizing cuts in boards made from hard and abrasive plastics and composite materials (e.g. Corian®, Trespa®, CFK, GFK, AFK, ...)	

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

TOOTH CONFIGURATIONS

F

F-FA

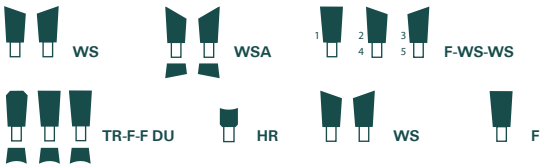
F

WS

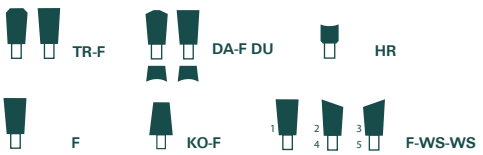
WSA

HR

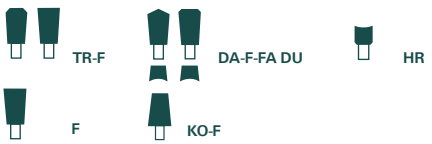
Main saw blades: **WS** [SQ ▲▲ | SW ▲▲ with RS], **WSA** [SQ ▲▲▲▲ | SW ▲▲▲]
F-WS-WS [SQ ▲▲▲ | SW ▲▲ with / without RS]
TR-F-F DU [SQ ▲▲▲ | SW ▲▲ with / without RS]
HR [SQ ▲▲▲▲ | SW ▲▲▲▲ with / without RS]
Scoring saw blaes: **WS** [SQ ▲▲ | SW ▲▲]
Grooving saw blades: **F** [SQ ▲▲ | SW ▲▲▲]



Main saw blades: **TR-F** [SQ ▲▲ | SW ▲▲ with RS]
DA-F DU [SQ ▲▲▲ | SW ▲▲ with / without RS]
HR [SQ ▲▲▲▲ | SW ▲▲▲▲ with / without RS]
Scoring saw blaes: **F** [SQ ▲▲ | SW ▲▲], **KO-F** [SQ ▲▲ | SW ▲▲▲]
Grooving saw blades: **F** [SQ ▲▲ | SW ▲▲]
F-WS-WS [SQ ▲▲▲ | SW ▲▲]

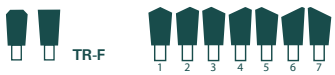


Main saw blades: **TR-F** [SQ ▲▲ | SW ▲▲ with RS]
DA-F-FA DU [SQ ▲▲▲ | SW ▲▲▲ with / without RS]
HR [SQ ▲▲▲▲ | SW ▲▲▲▲ with / without RS]
Scoring saw blaes: **F** [SQ ▲▲ | SW ▲], **KO-F** [SQ ▲▲▲ | SW ▲▲]
Grooving saw blade: **F** [SQ ▲▲ | SW ▲]



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

TR-F



TR-F

F-WFA

WS-FA

TR-F-FA

9 CUTTERS WITH BORE

— **It has to be distinguished between manual feed and mechanical feed. The regulations of the trade association BGHM have to be observed. The table head indicates if tools are designed for manual feed (man).**

— **Tools for manual feed (man) are normally turnover knife tools wich allow a cutting speed V_c of max 80 m/s.**

— **Cutting material:**
Cutterheads can be equipped with different turnover knives and cutting edges and thus can be optimized for different applications. The indications in the catalogue refer to the cutting edges which are installed in and supplied with new tools. (For possible cutting materials see "Cutting edges / HW / DP / DM grades")

10 SHANK-TYPE TOOLS

— **General influences on f_z**

- Stability (the more stable, the > f_z)

▸ The > the shank diameter, the > f_z
(f_z-indications refer to d=20 mm)
▸ The > the density of the tool body, the > f_z
(f_z-indications refer to steel bodies; heavy metal and solid tungsten carbide bodies give > f_z)
▸ The heavier the machine bed the > f_z

▸ Machine construction:
portal is more stable than cantilever machine
▸ No. of the axes: 3 axis machine is more stable than a comparable 5 axis machine
▸ Tool interface: HSK is more stable than SK or BT
▸ Workpiece clamping: the higher the suction power / clamping power near the milling edge, the more stable the workpiece clamping is.

- Material thickness:
The > the material, the > the hogging volume, the < f_z
(f_z-indications refer to a material thickness of approx. 25 mm)

- Mode of application:
The > the hogging volume, the < f_z
(f_z-indication refer to grooving, for dividing < f_z ; for grooving > f_z)

— **With shank-type cutters, the recommended cutting speed can normally not be reached due to the smaller tool diameters and the limited RPM. This is why usually the power spectrum of the CNC machine is not reached (normally 18,000 or 24,000 t/min).**

11 DRILL BITS

— **The range of RPM for drill bits depends on the tool diameter and lies between 2,500 and 9,000 1/min. The feed is derived from the RPM.**

— **Feed V_f for raw particle board**

- Twist drill: 0.6 – 5.0 m/min
- Through hole bit HW: 0.6 – 3.1 m/min
- Through hole bit with VHW shank 1.0 – 3.8 m/min
- Through hole bit DP: 0.6 – 2.5 m/min

- Dowel bit: 1.25 – 5.0 m/min
- Dowel bit with VHW shank: 1.25 – 7.5 m/min
- Hardware hinge drill bit HW: 1.2 – 3.8 m/min
- Hardware hinge drill bit DP: 0.6 – 3.1 m/min

— Feed V_f for melamine laminated particle board

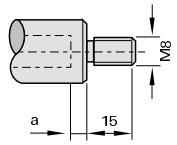
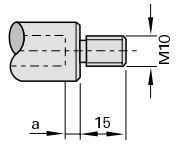
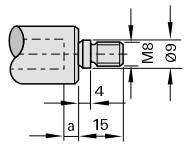
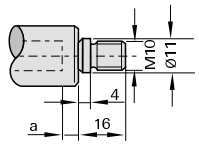
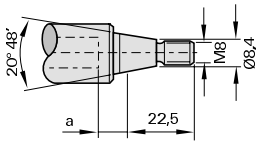
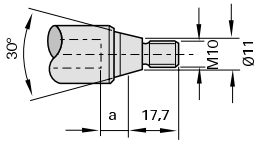
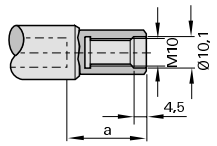
- Twist drill: 0.5 – 4.0 m/min
- Through hole bit HW: 0.5 – 2.5 m/min
- Through hole bit with VHW shank: 0.8 – 3.0 m/min
- Through hole bit DP: 0.5 – 2.0 m/min
- Dowel bit: 1.0 – 4.0 m/min
- Dowel bit with VHW shank: 1.0 – 6.0 m/min
- Hardware hinge drill bit HW: 1.0 – 3.0 m/min
- Hardware hinge drill bit DP: 0.5 – 2.5 m/min

— Feed V_f for veneered and paper-laminated particle board, MDF and solid wood

- Twist drill: 0.4 – 3.0 m/min
- Through hole bit HW: 0.4 – 1.9 m/min
- Through hole bit with VHW shank: 0.6 – 2.3 m/min
- Through hole bit DP: 0.4 – 1.5 m/min
- Dowel bit: 0.8 – 3.2 m/min
- Dowel bit with VHW shank: 0.8 – 4.5 m/min
- Hardware hinge drill bit HW: 0.8 – 2.3 m/min
- Hardware hinge drill bit DP: 0.4 – 1.9 m/min

Connection dimensions for Boring Bit Collet Chucks

Threaded shank design for Kombi and Klack systems with appropriate machines

Type		Machine assignment
A		Nottmeyer, Lehbrink, Pankoke + Kochsiek, Prieß + Horstmann
B		Ayen, Holzma, Knoevenagel, Mayer, Brandt, Reichenbacher, Torwegge, Zubiola
C		Nottmeyer
D		Böttchner + Gessner, Biesse, Busellato, Dingenotto, Hüllhorst, Holz-Her, Homag, Koch, Morbidelli, Reimall, Torwegge, Weeke, Reich
E		Bilek Type KÜN, Knoevenagel
F		Alberti, Balestrini, Bilek (05 R), Busellato, Dubus, Goma, Grotefeld, Omeg, Reimall, Schleicher, SCM, Tanzani, Viciani, Vitap, Weingärtner
G		Scheer

12 CUTTING EDGES / HW / DP / DM GRADES:

— **Small wedge angles and large hook angles mean sharp cutting edges, but also quick wear.**

— **The harder the cutting material, the larger the wedge angle must be (to avoid tooth breakage) and this means a blunt hook angle. Thus, edge life is increased at the expense of sharpness.**

— **Workpiece materials requiring sharp cutting edges (such as solid wood, plywood, ...) can be machined with DP tools only if these have very large shear angles.**

— **CUTTING MATERIAL:**
The following cutting materials are used for Stehle turnover knives and exchangeable knives:

- Cutting materials for wood-based panels and universal application:
  - TC02
  - TC03
  - TC05
  - TC06

- Cutting material for solid wood:
  - TCw15
  - TCw25
  - TCw30
  - TCw40

sales regulations

— REWORK AND ALTERATIONS

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

— ORDER INFORMATION

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

— QUANTITIES

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

— TERMS OF DELIVERY

- For deliveries abroad generally conditions ex factory apply.
- Additional costs for express shipping such as express, airfreight etc. will be invoiced at our cost price.

— ORDER PROCESSING

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

— ORDER PROCESSING VIA STEHLE ONLINE SHOP

Take advantage of our online shop and order 7/24. You always have the latest data and products available online.
https: //shop.stehle-int.com

— ORDER PROCESSING VIA NEXMART

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

— GENERAL TERMS AND CONDITIONS

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

Diameter Index Circular Saw Blades

Ø D [mm]	Ø d [mm]	Z	Tooth geom-etry	Order-No.		Program	Page
70	20	2x8	F	50445100	HW	RS2	1–30
80	20	2x10	F	58802435	HW	RS2	1–30
90	30	20	WS	192471	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
100	12	30	WS	50110001	HW	HKS - Board	1–8
100	20	20	KO-F	58807950	HW	RSK - nn-System	1–28
100	20	2x10	F	58110190	HW	RS2	1–30
100	22	12	WS	192472	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
100	22	20	WS	192475	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
100	22	20	WS	58808802	HW	KKO	1–60
100	22	2x10	F	58110188	HW	RS2	1–30
100	22	30	WS	50110003	HW	HKS - Board	1–8
100	30	12	F	50750144	DP	RNK DP	2–6
100	32	30	WS	192476	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
100	32	30	ES	192509	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
100	32	30	ES	192510	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
100	32	30	ES	192511	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
100	32	30	ES	192512	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
100	32	30	ES	192513	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
105	20	2x10	F	58110171	HW	RS2	1–30
105	22	30	WS	50110006	HW	HKS - Board	1–8
110	22	20	WS	192477	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
110	32	20	WS	192478	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
110	40	20	WS	192479	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
110	40	20	WS	192480	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
120	20	6	F-FA	58457378	DP	HKS - L	1–10
120	20	24	WS	192448	DP	Scoring Saw Blades DP "WS" - nn-System DP flex	1–37
120	20	24	WS	50104061	HW	HKS - solid	1–7
120	20	24	KO-F	58807951	HW	RSK - nn-System	1–28
120	20	2x12	F	58110186	HW	RS2	1–30
120	20	40	TR-F	58104063	HW	TRF	1–25
120	22	16	KO-F	58750101	DP	RSK	1–29
120	22	24	WS	192447	DP	Scoring Saw Blades DP "WS" - nn-System DP flex	1–37
120	22	24	WS	58806209	HW	RSK	1–27
120	22	24	KO-F	58807952	HW	RSK - nn-System	1–28
120	22	2x12	WS	50750102	DP	RSVS	1–29
120	22	2x12	WS	50807854	HW	RSVS	1–31
120	22	2x12	F	58110187	HW	RS2	1–30
120	32	20	WS	192483	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
120	40	24	WS	189751	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
120	40	36	WS	192484	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
120	50	12+12	WS	192452	DP	Scoring Saw Blades DP "WS" - adjustable, nn-System DP flex	1–38
120	50	2x12	WS	50750105	DP	RSVS	1–29
120	50	2x12	WS	50807902	HW	RSVS	1–31
125	20	20	WS	50110011	HW	HKS - solid	1–7
125	20	24	WS	192449	DP	Scoring Saw Blades DP "WS" - nn-System DP flex	1–37
125	20	24	KO-F	58807953	HW	RSK - nn-System	1–28
125	20	2x12	F	58110206	HW	RS2	1–30
125	20	36	WS	50110012	HW	HKS - Board	1–8
125	22	24	WS	50806200	HW	RSK	1–27
125	22	24	KO-F	58807954	HW	RSK - nn-System	1–45
125	22	2x12	F	58110204	HW	RS2	1–30
125	30	12	F	50750145	DP	RNK DP	2–6
125	30	36	WS	192487	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
125	32	24	WS	192900	HW	Clipping Saw Blades HW for edge trimming "WS" - without countersink	1–60
130	20	20	WS	50110017	HW	HKS - solid	1–7
130	20	36	WS	50110018	HW	HKS - Board	1–8
130	20	36	TR-F	58115027	HW	Parat - negative (HKS)	1–14
136	20	4	F	58460500	DP	HKS - L - Thin-kerf Saw blades	1–2
136	20	18	F-WS	58110400	HW		1–1
136	20	24	F-WS	58110401	HW	HKS - solid - thin-kerf saw blades	1–1
136	20	36	TR-F	58116400	HW	HKS - Unisteel - Thin-kerf Saw blades	1–4
136	20	36	TR-F-FA	58808600	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–6
140	16	36	WS	192489	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
140	20	20	WS	50110028	HW	HKS - solid	1–7
140	20	36	WS	50110029	HW	HKS - Board	1–8
140	22	36	WS	192488	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
140	30	36	WS	192490	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
140	30	36	WS	192491	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
140	36	2x12	WS	193258	HW	Scoring Saw Blades HW - adjustable "WS"	1–31
150	20	12	WS	50110243	HW	HKS - solid	1–7
150	20	24	WS	50110039	HW	HKS - solid	1–7
150	20	30	TR-F	58116502	HW	Unisteel (HKS)	1–13
150	20	32	TR-F	58458810	HT	HKS - Mega-Steel - Thin-kerf Saw blades	1–5
150	20	36	WS	50110040	HW	HKS - Board	1–8
150	20	42	TR-F	58115002	HW	Parat - negative (HKS)	1–14
150	20	48	WS	50110041	HW	HKS - Board	1–8
150	22	48	WS	192493	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
150	30	24	WS	58100096	HW	ZQW	1–21
150	30	36	WS	58100099	HW	ZWS	1–22
150	30	44	ES	192523	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
150	30	44	ES	192524	HW	Clipping Saw Blades HW for edge trimming "ES" - nn-System, without countersink	1–62
150	30	48	WS	192494	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
150	30	48	WS	58100101	HW	ZWS	1–22
160	16	24	WS	50110051	HW	HKS - solid	1–7
160	16	48	WS	50110053	HW	HKS - Board	1–8
160	20	4	F-FA	58457997	DP	HKS - LR	1–9
160	20	4	F-FA	58458790	DP	HKS - L2	1–11
160	20	6	F	58460479	DP	HKS - L - Thin-kerf Saw blades	1–2
160	20	8	F-FA	58457379	DP	HKS - L	1–10
160	20	12	WS	50110244	HW	HKS - solid	1–7
160	20	18	F-WS	58110413	HW	HKS - solid - thin-kerf saw blades	1–1
160	20	20	HR	58459771	DP	HKS - nn-System DP flex	1–12
160	20	24	WS	50110054	HW	HKS - solid	1–7
160	20	24	F-WS	58110423	HW	HKS - solid - thin-kerf saw blades	1–1
160	20	30	F-WS	58110424	HW	HKS - solid - thin-kerf saw blades	1–1
160	20	30	TR-F	58116504	HW	Unisteel (HKS)	1–13
160	20	30	F-FA	58458171	DP	HKS - L	1–10
160	20	30	HR	58459767	DP	HKS - nn-System DP flex	1–12
160	20	36	WS	50110055	HW	HKS - Board	1–8
160	20	40	TR-F	58116402	HW	HKS - Unisteel - Thin-kerf Saw blades	1–4
160	20	40	TR-F	58458784	HT	HKS - Mega-Steel - Thin-kerf Saw blades	1–5
160	20	42	TR-F	58115004	HW	Parat - negative (HKS)	1–14

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Ø D [mm]	Ø d [mm]	Z	Tooth geom-etry	Order-No.		Program	Page
160	20	48	WS	192497	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
160	20	48	WS	50110056	HW	HKS - Board	1–8
160	20	48	TR-F	58110161	HW	TRF	1–25
160	20	48	F-WS	58110419	HW	HKS - solid - thin-kerf saw blades	1–1
160	20	48	WS-FA	58116000	HW	KKS - plastic	1–57
160	20	48	TR-F-FA	58808605	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–6
160	20	48 Vario	WS	58110356	HW	HKS - Board	1–8
160	20	52	TR-F	58115607	HW	Parat - negative (HKS)	1–3
160	20	52	TR-TR	58808607	HW	KKS - hard plastic negative	1–59
160	20	56	TR-F	58110142	HW	TRF	1–25
160	20	56	TR-F	58115042	HW	Parat - negative (HKS)	1–14
160	22	36	WS	188662	HW	Clipping Saw Blades HW for edge trimming "WS" - without countersink	1–60
160	22	36	WS	192456	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
160	22	48	WS	192498	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
160	30	8	F	50750148	DP	RNK DP	2–6
160	30	8	F	50750149	DP	RNK DP	2–6
160	30	8	F-FA	58457377	DP	HKS - L	1–10
160	30	24	WS	192495	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
160	30	24	WS	50110057	HW	HKS - solid	1–7
160	30	36	WS	50110058	HW	HKS - Board	1–8
160	30	42	TR-F	58115026	HW	Parat - negative (HKS)	1–14
160	30	48	WS	50110059	HW	HKS - Board	1–8
160	40	30	WS	192496	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
160	45	30	KO-F	50750121	DP	RSK DP	1–46
160	55	36	KO-F	58803072	HW	RSK - nn-System	1–45
165	15,88	24	F-WS	58110421	HW	HKS - solid - thin-kerf saw blades	1–1
165	15,88	40	F-WS	58110405	HW	HKS - solid - thin-kerf saw blades	1–1
165	20	6	F	58460480	DP	HKS - L - Thin-kerf Saw blades	1–2
165	20	18	F-WS	58110402	HW	HKS - solid - thin-kerf saw blades	1–1
165	20	24	WS	50110060	HW	HKS - solid	1–7
165	20	24	F-WS	58110403	HW	HKS - solid - thin-kerf saw blades	1–1
165	20	36	WS	50110061	HW	HKS - Board	1–8
165	20	36	F-WS	58110404	HW	HKS - solid - thin-kerf saw blades	1–1
165	20	40	TR-F	58116401	HW	HKS - Unisteel - Thin-kerf Saw blades	1–4
165	20	48	WS	50110062	HW	HKS - Board	1–8
165	20	48	F-WS	58110420	HW	HKS - solid - thin-kerf saw blades	1–1
165	20	48	TR-F	58115044	HW	Parat - negative (HKS)	1–14
165	20	48	TR-F-FA	58808606	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–6
165	20	52	TR-F	58115608	HW	Parat - negative (HKS)	1–3
165	20	52	TR-TR	58808608	HW	KKS - hard plastic negative	1–59
165	30	24	WS	50110130	HW	HKS - solid	1–7
168	20	6	F	50460481	DP	HKS - L - Thin-kerf Saw blades	1–2
168	20	18	F-WS	58110427	HW	HKS - solid - thin-kerf saw blades	1–1
168	20	30	F-WS	58110428	HW	HKS - solid - thin-kerf saw blades	1–1
168	20	48	F-WS	58110429	HW	HKS - solid - thin-kerf saw blades	1–1
168	20	48	TR-F-FA	58808603	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–6
168	20	52	TR-F	58115609	HW	Parat - negative (HKS)	1–3
170	30	24	WS	50110069	HW	HKS - solid	1–7
170	30	36	WS	193354	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
170	30	36	WS	50110070	HW	HKS - Board	1–8
170	30	48	WS	50110071	HW	HKS - Board	1–8
180	16	24	WS	50110081	HW	HKS - solid	1–7
180	16	48	WS	50110183	HW	HKS - Board	1–8
180	20	24	WS	50110075	HW	HKS - solid	1–7
180	20	36	TR-F	58116507	HW	Unisteel (HKS)	1–13
180	20	40	WS	50110076	HW	HKS - Board	1–8
180	20	48	TR-F	58115007	HW	Parat - negative (HKS)	1–14
180	22	36	WS	192964	DP	Scoring Saw Blades DP "WS" - nn-System DP flex	1–37
180	22	36	F	58806210	HW	RSK	1–27
180	30	4	F-FA	58458799	DP	HKS - L2	1–11
180	30	14	WS	50110248	HW	HKS - solid	1–7
180	30	24	WS	50110078	HW	HKS - solid	1–7
180	30	30	KO-F	50750122	DP	RSK DP	1–46
180	30	30	WS	58100016	HW	ZQW	1–21
180	30	30	KO-F	58807858	HW	RSK - nn-System	1–45
180	30	30	KO-WS	58807970		RSK-WS	1–47
180	30	36	TR-F	58116508	HW	Unisteel (HKS)	1–13
180	30	40	WS	50110079	HW	HKS - Board	1–8
180	30	48	TR-F	58115008	HW	Parat - negative (HKS)	1–14
180	30	54	WS	192500	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System, with countersink	1–61
180	30	54	WS	50110080	HW	HKS - Board	1–8
180	30	54	WS	58100015	HW	ZWS	1–22
180	30	60	F-WS-WS	58808701	HW	Matador 5	1–24
180	45	30	KO-F	50750123	DP	RSK DP	1–46
180	45	30	KO-F	50750124	DP	RSK DP	1–46
180	45	36	KO-F	58803104	HW	RSK - nn-System	1–45
180	45	36	KO-F	58807862	HW	RSK - nn-System	1–45
184	16	54	F-WS	58110406	HW	HKS - solid - thin-kerf saw blades	1–1
184	20	24	WS	50110082	HW	HKS - solid	1–7
184	20	24	F-WS	58110416	HW	HKS - solid - thin-kerf saw blades	1–1
190	16	24	WS	50110153	HW	HKS - solid	1–7
190	16	30	WS	50110083	HW	HKS - Board	1–8
190	16	42	WS	50110084	HW	HKS - Board	1–8
190	20	4	F-FA	58458800	DP	HKS - L2	1–11
190	20	16	WS	50110250	HW	HKS - solid	1–7
190	20	24	WS	50110154	HW	HKS - solid	1–7
190	20	30	WS	50110086	HW	HKS - Board	1–8
190	20	38	TR-F	58116509	HW	Unisteel (HKS)	1–13
190	20	48	WS	50110087	HW	HKS - Board	1–8
190	20	48	F-WS	58110407	HW	HKS - solid - thin-kerf saw blades	1–1
190	20	54	TR-F	58115009	HW	Parat - negative (HKS)	1–14
190	20FX	32	WS	50110266	HW	HKS - Board	1–8
190	20FX	48	WS	50110267	HW	HKS - Board	1–8
190	20FX	54	TR-F	58110229	HW	TRF	1–25
190	20FX	54	TR-TR	58808604	HW	KKS - hard plastic negative	1–59
190	20FX	58	TR-F	58115033	HW	Parat - negative (HKS)	1–14
190	20FX	60	WS	50110268	HW	HKS - Board	1–8
190	30	4	F-FA	58457994	DP	HKS - LR	1–9
190	30	4	F-FA	58458791	DP	HKS - L2	1–11
190	30	8	F-FA	58457357	DP	HKS - L	1–10
190	30	14	F-FA	58112011	HW	BKS (nail proof)	1–16
190	30	16	WS	50110251	HW	HKS - solid	1–7
190	30	24	WS	50110155	HW	HKS - solid	1–7
190	30	24	F-WS	58110417	HW	HKS - solid - thin-kerf saw blades	1–1
190	30	24	WS	58114105	HW	HKS - solid	1–7
190	30	30	WS	50110089	HW	HKS - Board	1–8
190	30	30	F-FA	58457546	DP	HKS - L	1–10
190	30	36	HR	58459768	DP	HKS - nn-System DP flex	1–12
190	30	38	TR-F	58116510	HW	Unisteel (HKS)	1–13
190	30	48	WS	50110090	HW	HKS - Board	1–8
190	30	48	F-WS	58110418	HW	HKS - solid - thin-kerf saw blades	1–1
190	30	48	TR-F	58458785	HT	HKS - Mega-Steel - Thin-kerf Saw blades	1–5
190	30	54	TR-F	58115010	HW	Parat - negative (HKS)	1–14
190	30	54	WS-FA	58116001	HW	KKS - plastic	1–57
190	30	54	TR-TR	58808609	HW	KKS - hard plastic negative	1–59
190	30	56	TR-F	58458779	HW	TRF	1–25
190	30	60	WS	50110091	HW	HKS - Board	1–8
200	20	30	KO-F	50750125	DP	RSK DP	1–46
200	20	36	KO-F	50750147	DP	RSK DP	1–46
200	20	36	KO-F	58803073	HW	RSK - nn-System	1–45
200	30	18	WS	50110252	HW	HKS - solid	1–7
200	30	30	WS	50110095	HW	HKS - solid	1–7
200	30	34	WS	58100017	HW	ZQW	1–21
200	30	48	WS	50110096	HW	HKS - Board	1–8
200	30	48	WS	58100091	HW	ZWS	1–22

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200	30	54	TR-F	58115011	HW	Parat - negative (HKS)	1–14
200	30	64	WS	192501	HW	Clipping Saw Blades HW for edge trimming "WS" - nn-System without countersink	1–60
200	30	64	WS	58100025	HW	ZWS	1–22
200	30	65	F-WS-WS	58808702	HW	Matador 5	1–24
200	45	30	KO-F	50750127	DP	RSK DP	1–46
200	45	36	KO-F	58803074	HW	RSK - nn-System	1–45
200	45	36	KO-F	58806134	HW	RSK - nn-System	1–45
200	65	30	KO-F	50750126	DP	RSK DP	1–46
200	65	36	KO-F	58806130	HW	RSK - nn-System	1–45
205	18	30	WS	50110286	HW	HKS - solid	1–7
210	30	12	F-FA	58457358	DP	HKS - L	1–10
210	30	14	F-FA	50112013	HW	BKS (nail proof)	1–16
210	30	18	WS	50110253	HW	HKS - solid	1–7
210	30	30	WS	50110104	HW	HKS - solid	1–7
210	30	40	TR-F	58116512	HW	Unisteel (HKS)	1–13
210	30	48	WS	50110105	HW	HKS - Board	1–8
210	30	48	WS	58110194	HW	K + G - negative	1–15
210	30	54	TR-F	58115012	HW	Parat - negative (HKS)	1–14
210	30	54	TR-TR	58808610	HW	KKS - hard plastic negative	1–59
210	30	60	WS	50110106	HW	HKS - Board	1–8
210	30	60	F-WS	58110408	HW	HKS - solid - thin-kerf saw blades	1–2
216	30	4	F-FA	58458792	DP	HKS - L2	1–11
216	30	12	F-FA	58458137	DP	HKS - L	1–10
216	30	24	WS	58110180	HW	K + G - negative	1–15
216	30	24	F-WS	58110409	HW	HKS - solid - thin-kerf saw blades	1–2
216	30	30	WS	50110107	HW	HKS - solid	1–7
216	30	36	F-WS	58110410	HW	HKS - solid - thin-kerf saw blades	1–2
216	30	40	TR-F	58116520	HW	Unisteel (HKS)	1–13
216	30	40	HR	58459769	DP	HKS - nn-System DP flex	1–12
216	30	48	WS	50110108	HW	HKS - Board	1–8
216	30	48	WS	58110181	HW	K + G - negative	1–15
216	30	48	F-WS	58110425	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–3
216	30	56	TR-F	58458786	HT	HKS - Mega-Steel - Thin-kerf Saw blades	1–5
216	30	60	WS	50110109	HW	HKS - Board	1–8
216	30	60	WS	58110192	HW	K + G - negative	1–15
216	30	60	F-WS	58110411	HW	HKS - solid - thin-kerf saw blades	1–2
216	30	60	TR-F	58115024	HW	Parat - negative (HKS)	1–14
216	30	60	WS-FA	58116002	HW	KKS - plastic	1–57
216	30	60	TR-F	58458780	HW	TRF	1–25
216	30	60	TR-TR	58808611	HW	KKS - hard plastic negative	1–59
216	30	60	F-WS-WS	58808714	HW	Matador 5	1–24
216	30	80	TR-F	58115034	HW	Parat - negative (HKS)	1–14
220	30	24	WS	50110164	HW	HKS - solid	1–7
220	30	36	WS	50110110	HW	HKS - solid	1–7
220	30	42	DA-F DU	58804281	HW	KDF - Industry	1–33
220	30	48	WS	50110111	HW	HKS - Board	1–8
220	30	54	TR-F	58115021	HW	Parat - negative (HKS)	1–14
220	30	64	WS	50110112	HW	HKS - Board	1–8
220	30	64	TR-F	58100399	HW	TRF	1–25
220	30	70	F-WS-WS	58808712	HW	Matador 5	1–24
220	40	70	F-WS-WS	58808703	HW	Matador 5	1–24
225	30	24	WS	50110165	HW	HKS - solid	1–7
225	30	34	WS	50110228	HW	HKS - solid	1–7
225	30	48	WS	50110237	HW	HKS - Board	1–9
225	30	60	TR-F	58115039	HW	Parat - negative (HKS)	1–14
225	30	64	WS	50687902	HW	HKS - Board	1–9
230	30	4	F-FA	58457992	DP	HKS - LR	1–9
230	30	6	F-FA	58458793	DP	HKS - L2	1–11
230	30	15	F-FA	58457359	DP	HKS - L	1–10
230	30	18	WS	50110255	HW	HKS - solid	1–7
230	30	24	WS	50110168	HW	HKS - solid	1–7
230	30	36	WS	50110113	HW	HKS - solid	1–7
230	30	44	TR-F	58116514	HW	Unisteel (HKS)	1–13
230	30	44	HR	58459770	DP	HKS - nn-System DP flex	1–12
230	30	48	WS	50110114	HW	HKS - Board	1–9
230	30	60	TR-F	58805879	HT	HKS - Mega-Steel - Thin-kerf Saw blades	1–5
230	30	64	WS	50110115	HW	HKS - Board	1–9
230	30	64	TR-F	58115014	HW	Parat - negative (HKS)	1–14
232	30	64	TR-F	58458781	HW	TRF	1–25
232	30	64	TR-TR	58808616	HW	KKS - hard plastic negative	1–59
235	30	16	F-FA	58112015	HW	BKS (nail proof)	1–16
235	30	18	WS	50110256	HW	ZQW	1–21
235	30	24	WS	50110170	HW	ZQW	1–21
235	30	24	WS	58100191	HW	ZQW	1–21
235	30	34	WS	50100193	HW	ZWS	1–22
235	30	36	WS	50110117	HW	ZWS	1–22
235	30	44	TR-F	58116521	HW	Unisteel (HKS)	1–13
235	30	48	WS	58110121	HW	ZWS	1–22
235	30	64	WS	58110118	HW	ZWS	1–22
235	30	64	TR-F	58115018	HW	NF - negative	1–51
240	30	24	WS	50110174	HW	ZQW	1–21
240	30	36	WS	50110123	HW	ZWS	1–22
240	30	44	TR-F	58116515	HW	Unisteel (HKS)	1–13
240	30	48	WS	50110124	HW	ZWS	1–22
240	30	75	G5	192791	HW	Sizing Saw Blades HW "G5"	1–24
250	30	6	F-FA	58458794	DP	HKS - L2	1–11
250	30	16	F-FA	58120220	HW	BKS (nail proof)	1–16
250	30	16	F-FA	58457360	DP	HKS - L	1–10
250	30	18	F	58104050	HW	ZFL	1–18
250	30	24	WS	58102001	HW	ZW	1–20
250	30	24	F-WS	58110412	HW	HKS - solid - thin-kerf saw blades	1–2
250	30	24	WS	58120060	HW	ZQW	1–21
250	30	30	ES-F + F + ES-F	50459024	HW	NK3VS	2–6
250	30	30	WS	58120061	HW	ZQW	1–21
250	30	40	WS	58100018	HW	ZWS	1–22
250	30	40	WS	58120020	HW	ZQW	1–21
250	30	40	F-FA	58458000	DP	HKS - L	1–10
250	30	48	WS	58100026	HW	ZWS	1–22
250	30	48	DA-F DU	58804351	HW	KDF - Industry	1–33
250	30	48	DA-F DU	58804352	HW	KDF - Industry - negative	1–32
250	30	50	HR	58459455	DP	HRP - nn-System DP flex	1–36
250	30	60	WS	58100031	HW	ZWS	1–22
250	30	60	TR-F	58100385	HW	TRF	1–25
250	30	60	WS	58100701	HW	ZWS-1	1–23
250	30	60	TR-F	58808201	HW	NF - negative	1–51
250	30	80	WS-FA	50808500	HW	KKS - plastic	1–57
250	30	80	WS	58100038	HW	ZWS	1–22
250	30	80	TR-F	58100386	HW	TRF	1–25
250	30	80	TR-F	58808102	HW	NF - positive	1–50
250	30	80	TR-F	58808200	HW	NF - negative	1–51
250	30	80	TR-F	58808203	HW	NF - negative	1–51
250	30	80	TR-F-FA	58808620	HW	KKS - hard plastic positive	1–58
250	30	80	F-WS-WS	58808706	HW	Matador 5	1–24
250	30	84	G7	192965	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
250	32	80	TR-F	58808204	HW	NF - negative	1–51
250	40	80	TR-F	58808205	HW	NF - negative	1–51
250	70	20	F	50457841	HW	LWR	1–49
254	20/30	40	WS	58114108	HW	ZWS	1–22
254	25,4	72	F-WFA	58805870	HT	Mega-Steel	1–56
254	30	24	WS	58118119	HW	K + G - negative	1–15
254	30	24	WS	58120071	HW	ZQW	1–21
254	30	40	WS	58100218	HW	K + G - negative	1–15
254	30	40	WS	58120067	HW	ZWS	1–22
254	30	40	WS	58120072	HW	ZQW	1–21
254	30	48	F-WFA	58165001	HW	Unisteel	1–54
254	30	60	WS	58100231	HW	K + G - negative	1–15
254	30	60	WS	58120068	HW	ZWS	1–22
254	30	60	WS	58120073	HW	ZWS	1–22
254	30	60	F-WFA	58805861	HW	Steel	1–55
254	30	60	TR-F	58808240	HW	NF - negative	1–51
254	30	72	F-WFA	58805871	HT	Mega-Steel	1–56
254	30	80	TR-F	58100402	HW	TRF	1–25
254	30	80	WS	58110139	HW	K + G - negative	1–15
254	30	80	TR-F	58808246	HW	NF - negative	1–51
254	30	80	TR-TR	58808612	HW	KKS - hard plastic negative	1–59
254	30	80	TR-TR	58808617	HW	KKS - hard plastic negative	1–59
260	30	8	F-FA	58458797	DP	HKS - L2	1–11
260	30	32	WS	58110185	HW	ZQW	1–21
260	30	40	WS	58110175	HW	ZWS	1–22

Diameter Index Circular Saw Blades

Ø D [mm]	Ø d [mm]	Z	Tooth geom-etry	Order-No.		Program	Page
260	30	60	WS	58100233	HW	K + G - negative	1–15
260	30	60	WS	58100254	HW	ZWS	1–22
260	30	60	F-WFA	58165010	HW	Unisteel	1–54
260	30	72	TR-F	58808206	HW	NF - negative	1–51
260	30	80	WS	58100234	HW	K + G - negative	1–15
260	30	80	TR-F	58808260	HW	NF - negative	1–51
260	30	80	TR-TR	58808613	HW	KKS - hard plastic negative	1–59
270	30	18	F	58114170	HW	BKS (gasbeton)	1–17
270	30	24	WS	58110176	HW	ZQW	1–21
270	30	54	F-WFA	58116517	HW	Unisteel	1–54
270	30	60	WS	58110182	HW	ZWS	1–22
280	30	48	WS	58110136	HW	ZWS	1–22
280	30	64	TR-F	58808261	HW	NF - negative	1–51
280	30	85	F-WS-WS	58808705	HW	Matador 5	1–24
300	30	14	F	58104006	HW	ZFL	1–18
300	30	20	F-FA	58120041	HW	BKS (nail proof)	1–16
300	30	24	WS	58120002	HW	ZQW	1–21
300	30	28	WS	58102002	HW	ZW	1–20
300	30	36	WS	58120013	HW	ZQW	1–21
300	30	36	F-FA	58457557	DP	HKS - L	1–10
300	30	48	KO-WS	192751		Scoring Saw Blades HW "KO-WS"	1–47
300	30	48	WS	58100250	HW	ZWS	1–22
300	30	48	WS	58100702	HW	ZWS-1	1–23
300	30	60	WS	58100027	HW	ZWS	1–22
300	30	60	TR-F	58806053	HW	TFP	1–43
300	30	72	WS	58100032	HW	ZWS	1–22
300	30	72	TR-F	58100387	HW	TRF	1–25, 1–27
300	30	72	TR-F	58808104	HW	NF - positive	1–50
300	30	72	TR-F	58808209	HW	NF - negative	1–51
300	30	96	WS-FA	50808501	HW	KKS - plastic	1–57
300	30	96	WS	58100251	HW	ZWS	1–22
300	30	96	TR-F	58100388	HW	TRF	1–25
300	30	96	WS	58100703	HW	ZWS-1	1–23
300	30	96	TR-F	58458788	HW	TRF - 1	1–26
300	30	96	TR-F	58808107	HW	NF - positive	1–50
300	30	96	TR-F	58808213	HW	NF - negative	1–51
300	30	96	TR-F	58808214	HW	NF - negative	1–51
300	30	96	TR-F-FA	58808621	HW	KKS - hard plastic positive	1–58
300	30	98	G7	192568	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
300	30	98	G7	192663	HW	NF-Chop Saw Blades HW - profiles "G7"	1–52
300	30	100	F-WS-WS	58808708	HW	Matador 5	1–24
300	30	100	F-WS-WS	58808713	HW	Matador 5	1–24
300	32	96	TR-F	58808125	HW	NF - positive	1–50
300	32	96	TR-F	58808215	HW	NF - negative	1–51
300	40	72	WS	58100237	HW	K + G - negative	1–15
300	40	96	TR-F	58808216	HW	NF - negative	1–51
300	70	22	F	50100525	HW	LWR	1–49
303	30	60	HR	58459439	DP	HRP - nn-System DP flex	1–36
303	30	60	DA-F DU	58804279	HW	KDF - Industry - negative	1–32
303	30	60	TR-F-F DU	58804282	HW	KDF - Industry Professionell	1–35
303	30	60	DA-F-FA DU	58804301	HW	KDF - Industry Plus	1–34
303	30	60	DA-F DU	58804353	HW	KDF - Industry	1–33
303	30	100	F-WS-WS	58808707	HW	Matador 5	1–24
305	25,4	60	F-WFA	50805872	HT	Mega-Steel	1–56
305	25,4	60	F-WFA	58805862	HW	Steel	1–55
305	25,4	80	F-WFA	50805873	HT	Mega-Steel	1–56
305	25,4	80	F-WFA	58805863	HW	Steel	1–55
305	30	8	F-FA	58458795	DP	HKS - L2	1–11
305	30	32	WS	58110270	HW	K + G - negative	1–15
305	30	48	WS	58120065	HW	ZWS	1–22
305	30	60	WS	58110281	HW	K + G - negative	1–15
305	30	60	WS	58120066	HW	ZWS	1–22
305	30	60	F-WFA	58165002	HW	Unisteel	1–54
305	30	60	TR-F	58808241	HW	NF - negative	1–51
305	30	72	F-WS	58110426	HW	HKS - KKS - hard plastic negative - Thin-kerf Saw blades	1–3
305	30	80	F-WFA	50805874	HT	Mega-Steel	1–56
305	30	80	F-WFA	58805864	HW	Steel	1–55
305	30	96	WS	58110272	HW	K + G - negative	1–15
305	30	96	TR-F	58808245	HW	NF - negative	1–51
305	30	96	TR-TR	58808614	HW	KKS - hard plastic negative	1–59
315	30	10	F-FA	58458801	DP	HKS - L2	1–11
315	30	14	F	58104055	HW	ZFL	1–18
315	30	20	F-FA	58120046	HW	BKS (nail proof)	1–16
315	30	28	WS	58102003	HW	ZW	1–20
315	30	28	WS	58120062	HW	ZQW	1–21
315	30	36	WS	58100255	HW	ZQW	1–21
315	30	48	WS	58100252	HW	ZWS	1–22
315	30	60	WS	58100253	HW	ZWS	1–22
315	30	84	WS	58110274	HW	K + G - negative	1–15
315	30	96	TR-F	58803823	HW	TRF - 1	1–26
315	30	96	TR-F	58808315	HW	NF - negative	1–51
320	25,4	84	F-WFA	58805859	HW	Steel	1–55
320	65	60	TR-F-FA	50750120	DP	TFP DP	1–44
320	65	72	TR-F	58807818	HW	TFP	1–43
330	30	24	WS	58120018	HW	ZQW	1–21
330	30	54	F-WFA	58165005	HW	Unisteel	1–54
330	30	90	F-WFA	58805865	HW	Steel	1–55
330	30	96	TR-F	58808217	HW	NF - negative	1–51
330	32	96	TR-F	58808218	HW	NF - negative	1–51
335	30	36	WS	58120063	HW	ZQW	1–21
350	30	12	F-FA	58458802	DP	HKS - L2	1–11
350	30	16	F	58104015	HW	ZFL	1–18
350	30	24	WS	50804422	HW	Planet	1–48
350	30	24	F	58104041	HW	ZFL	1–18
350	30	24	WS	58120005	HW	ZQW	1–21
350	30	24	F-FA	58120042	HW	BKS (nail proof)	1–16
350	30	32	WS	58100011	HW	ZQW	1–21
350	30	32	WS	58101004	HW	ZW	1–20
350	30	36	WS	58120014	HW	ZQW	1–21
350	30	42	WS	58120015	HW	ZQW	1–21
350	30	54	WS	58100021	HW	ZWS	1–22
350	30	54	WS	58100704	HW	ZWS-1	1–23
350	30	72	TR-F-FA	50750128	DP	TFP DP	1–44
350	30	72	WS	58100028	HW	ZWS	1–22
350	30	72	TR-F	58100300	HW	TRF	1–25
350	30	72	HR	58459446	DP	HRP - nn-System DP flex	1–36
350	30	72	DA-F DU	58804280	HW	KDF - Industry	1–33
350	30	72	TR-F	58807803	HW	TFP	1–43
350	30	72	TR-F	58807830	HW	TRF - 1	1–26, 1–27
350	30	84	WS	58100033	HW	ZWS	1–22
350	30	90	TR-F	58808222	HW	NF - negative	1–51
350	30	98	G7	192274	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
350	30	98	G7	192662	HW	NF-Chop Saw Blades HW - profiles "G7"	1–52
350	30	100	WS-FA	50808502	HW	KKS - plastic	1–57
350	30	100	F-WS-WS	58808709	HW	Matador 5	1–24
350	30	108	WS	58100040	HW	ZWS	1–22
350	30	108	TR-F	58100389	HW	TRF	1–25
350	30	108	TR-F	58807831	HW	TRF - 1	1–26
350	30	108	TR-F	58808111	HW	NF - positive	1–50
350	30	108	TR-F	58808225	HW	NF - negative	1–51
350	30	108	TR-F-FA	58808622	HW	KKS - hard plastic positive	1–58
350	30	112	G7	58192275	HW	NF-Chop - Negative - Profiles "G7"	1–53
350	32	108	TR-F	58808226	HW	NF - negative	1–51
350	40	72	WS	58110273	HW	K + G - negative	1–15
350	40	84	G7	192273	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
350	40	108	TR-F	58808227	HW	NF - negative	1–51
350	60	72	TR-F-FA	50750129	DP	TFP DP	1–44
350	60	72	TR-F	58807955	HW	TFP	1–43
350	70	20	F	50100528	HW	LWR	1–49
350	70	28	F	50457843	HW	LWR	1–49
355	25,4	80	F-WFA	50805876	HT	Mega-Steel	1–56
355	25,4	80	F-WFA	58805866	HW	Steel	1–55
355	25,4	90	F-WFA	50805878	HT	Mega-Steel	1–56
355	25,4	90	F-WFA	58805868	HW	Steel	1–55
355	30	80	F-WFA	58165003	HW	Unisteel	1–54
355	30	90	F-WFA	50805877	HT	Mega-Steel	1–56

Diameter Index Circular Saw Blades

Ø D [mm]	Ø d [mm]	Z	Tooth geom-etry	Order-No.		Program	Page
355	30	90	F-WFA	58805867	HW	Steel	1–55
355	30	96	WS	58110143	HW	K + G - negative	1–15
355	75	72	TR-F	58807888	HW	TFP	1–43
380	32	110	TR-F	58808243	HW	NF - negative	1–51
380	32	112	G7	192567	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
380	60	72	TR-F-FA	50750130	DP	TFP DP	1–44
380	60	72	TR-F-FA	50750131	DP	TFP DP	1–44
380	60	72	TR-F	58806065	HW	TFP	1–43
380	60	72	TR-F	58807819	HW	TFP	1–43
400	30	15	F-FA	58458798	DP	HKS - L2	1–11
400	30	18	F	58104021	HW	ZFL	1–18
400	30	28	WS	50804423	HW	Planet	1–48
400	30	28	WS	58100005	HW	ZQW	1–21
400	30	28	WS	58100183	HW	ZWZ	1–19
400	30	28	F-FA	58120043	HW	BKS (nail proof)	1–16
400	30	32	WS	58120008	HW	ZQW	1–21
400	30	36	WS	58100012	HW	ZQW	1–21
400	30	36	WS	58101005	HW	ZW	1–20
400	30	48	WS	58120017	HW	ZQW	1–21
400	30	60	WS	58100022	HW	ZWS	1–22
400	30	72	TR-F-FA	50750132	DP	TFP DP	1–44
400	30	72	TR-F	58806069	HW	TFP	1–43
400	30	84	WS	58100029	HW	ZWS	1–22
400	30	84	F-WFA	58165004	HW	Unisteel	1–54
400	30	96	WS	58100034	HW	ZWS	1–22
400	30	96	TR-F	58808113	HW	NF - positive	1–50
400	30	96	TR-F	58808232	HW	NF - negative	1–51
400	30	98	G7	192659	HW	NF-Chop Saw Blades HW - profiles "G7"	1–52
400	30	98	G7	58192276	HW	NF-Chop - Negative - Profiles "G7"	1–53
400	30	108	TR-F-FA	58808623	HW	KKS - hard plastic positive	1–58
400	30	120	WSA	189833	HW	Clipping Saw Blades HW for wood optimization "WSA"	1–48
400	30	120	WS	58100041	HW	ZWS	1–22
400	30	120	WSA	58807839	HW	Clipping Saw Blades HW for wood optimization "WSA"	1–48
400	75	72	TR-F-FA	50750133	DP	TFP DP	1–44
400	75	72	TR-F	58806071	HW	TFP	1–43
400	80	72	TR-F-FA	50750134	DP	TFP DP	1–44
400	80	72	TR-F	58807809	HW	TFP	1–43
420	30	96	TR-F	58808115	HW	NF - positive	1–50
420	30	96	TR-F	58808234	HW	NF - negative	1–51
420	30	98	G7	192277	HW	NF-Chop Saw Blades HW - profiles "G7"	1–53
420	30	98	G7	192660	HW	NF-Chop Saw Blades HW - profiles "G7"	1–52
420	40	100	TR-F	58808236	HW	NF - negative	1–52
420	40	54	WS	58110145	HW	K + G - negative	1–15
420	40	84	WS	58110144	HW	K + G - negative	1–15
420	60	60	TR-F-FA	50750135	DP	TFP DP	1–44
420	60	72	TR-F	58807956	HW	TFP	1–43
430	80	72	TR-F	58806479	HW	TFP	1–43
450	30	20	WS	58101020	HW	ZW	1–20
450	30	30	F-FA	58120044	HW	BKS (nail proof)	1–16
450	30	32	F	58104051	HW	ZFL	1–18
450	30	36	WS	50804425	HW	Planet	1–48
450	30	40	WS	58100013	HW	ZQW	1–21
450	30	40	WS	58101006	HW	ZW	1–20
450	30	66	WS	58100023	HW	ZWS	1–23
450	30	72	TR-F-FA	50750138	DP	TFP DP	1–44
450	30	72	TR-F	58458789	HW	TFP	1–43
450	30	90	F-WFA	58165006	HW	Unisteel	1–54
450	30	96	TR-F	58808235	HW	NF - negative	1–52
450	30	108	WS	58100060	HW	ZWS	1–23
450	30	112	G7	58192278	HW	NF-Chop - Negative - Profiles "G7"	1–53
450	30	132	WSA	189834	HW	Clipping Saw Blades HW for wood optimization "WSA"	1–48
450	50	24	F	189273	HW	Gang-Rip Saw Blades HW with HW-rakers - solid "F"	1–49
450	60	72	TR-F-FA	50750136	DP	TFP DP	1–44
450	60	72	TR-F	58807817	HW	TFP	1–43
450	80	72	TR-F-FA	50750137	DP	TFP DP	1–44
460	30	72	TR-F-FA	50750146	DP	TFP DP	1–44
480	30	72	TR-F-FA	50750139	DP	TFP DP	1–44
480	60	72	TR-F-FA	50750140	DP	TFP DP	1–44
500	30	34	F-FA	58120045	HW	BKS (nail proof)	1–16
500	30	36	F	58104052	HW	ZFL	1–18
500	30	44	WS	58100014	HW	ZQW	1–21
500	30	44	WS	58102007	HW	ZW	1–20
500	30	72	WS	58100024	HW	ZWS	1–23
500	30	120	TR-F	58808118	HW	NF - positive	1–50
500	30	120	TR-F	58808239	HW	NF - negative	1–52
500	30	126	G7	192661	HW	NF-Chop Saw Blades HW - profiles "G7"	1–52
500	30	126	G7	58192279	HW	NF-Chop - Negative - Profiles "G7"	1–53
500	30	144	WSA	58807842	HW	Clipping Saw Blades HW for wood optimization "WSA"	1–48
500	30	145	F-WS-WS	58808710	HW	Matador 5	1–24
550	30	32	F	58104054	HW	ZFL	1–18
550	30	64	WS	58120070	HW	ZWS	1–23
550	30	133	G7	58192392	HW	NF-Chop - Negative - Profiles "G7"	1–53
550	30	160	F-WS-WS	58808711	HW	Matador 5	1–24
600	30	36	F-FA	58120227	HW	BKS (nail proof)	1–16
600	30	40	F	58104048	HW	ZFL	1–18
600	30	54	WS	58101018	HW	ZW	1–20
700	30	42	F	58104053	HW	ZFL	1–18
700	30	42	F-FA	58120228	HW	BKS (nail proof)	1–16
700	30	46	F	58104049	HW	ZFL	1–18
700	30	60	WS	58101019	HW	ZW	1–20

Diameter Index Cutters with Bore

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57	16		2	182142	DP	DIAMAX Edge Rounding Cutters DP - HOLZ-HER	2–16
58.7	16		3	187135	DP	DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1832 / FF301	2–17
58.7	16		3	187140	DP	DIAMAX Edge Rounding Cutters CM DP - HOLZ-HER 1832 / FF301	2–17
60	25	64,5	2+2	186381	DP	DIAMAX airFace Jointing Cutters DP	2–10
60	25	64,5	2+2	186382	DP	DIAMAX airFace Jointing Cutters DP	2–10
69	16		4	185679	DP	DIAMAX Edge Rounding Cutters CM DP - Ott	2–16
69	16		4	185680	DP	DIAMAX Edge Rounding Cutters CM DP - Ott	2–16
70	25	43	2+2	186037	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
70	25	43	2+2	186038	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
70	30	48	2+2	185800	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
70	30	48	2+2	185801	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
70	30	64	2+2	185802	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
70	30	64	2+2	185803	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
70	30	64	2+2	187025	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
70	30	64	2+2	187026	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
80	30	43	2+2	186031	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
85	30	43,2	3+3	186408	DP	DIAMAX airFace Jointing Cutters DP	2–10
85	30	43,2	3+3	186409	DP	DIAMAX airFace Jointing Cutters DP	2–10
85	30	48	3+3	186057		DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–12
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100	22	3,97	12	50110178	HW	1103L Grooving Cutters - for Lamello®	2–1
100	22	3,97	4 V4	69470022	HW	1568 Grooving Cutterheads - Silverline - for Lamello®	2–2
100	22	4,0	6	50660300	HW	1103L Grooving Cutters - for Lamello®	2–1
100	22	7,0	6	50660303	HW	NKP	2–4
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100	25	43	2+2	186071	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	25	43	2+2	186072	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	4,0	35	50806250	HW	RNK-Matador 5	2–5
100	30	5,0	35	50806252	HW	RNK-Matador 5	2–5
100	30	43	3+3	186063	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	43	3+3	186064	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	43	3+3	186065	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	43	3+3	186066	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
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100	30	43,2	3+3	186373	DP	DIAMAX airFace Jointing Cutters DP	2–10
100	30	43,2	3+3	186374	DP	DIAMAX airFace Jointing Cutters DP	2–10
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100	30	63	3+3	186936	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
100	30	63	3+3	186937	DP	DIAMAX Jointing Cutters DP - HOLZ-HER - AirStream-System	2–11
100	30	64	3+3	186061	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	64	3+3	186062	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	64	3+3	186073	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	64	3+3	186074	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
100	30	64,5	2+2	186387	DP	DIAMAX airFace Jointing Cutters DP	2–10
100	30	64,5	2+2	186388	DP	DIAMAX airFace Jointing Cutters DP	2–10
100	30	64,5	3+3	186371	DP	DIAMAX airFace Jointing Cutters DP	2–10
100	30	64,5	3+3	186372	DP	DIAMAX airFace Jointing Cutters DP	2–10
100.4	22	7,0	3	50660347	DP	3104L Grooving Cutters DP - for Lamello Clamex P®	2–1
100.4	30	7,0	3	50660346	DP	3104L Grooving Cutters DP - for Lamello Clamex P®	2–1
102	22	3,85	12	50660301	HW	1103L Grooving Cutters - for Lamello®	2–1
102	35	50	2	50389261	HS	464 Multi Dowel Cutterheads	2–35
102	35	50	4	50389269	HS	464 Multi Dowel Cutterheads	2–35
102	35	75	2	50389262	HS	464 Multi Dowel Cutterheads	2–35
102	35	75	4	50389270	HS	464 Multi Dowel Cutterheads	2–35
102	35	100	2	50389263	HS	464 Multi Dowel Cutterheads	2–35
102	35	100	4	50389271	HS	464 Multi Dowel Cutterheads	2–35
102	40	100	2	50389266	HS	464 Multi Dowel Cutterheads	2–35
102	40	100	4	50389274	HS	464 Multi Dowel Cutterheads	2–35
102	40	125	2	50389267	HS	464 Multi Dowel Cutterheads	2–35
102	40	125	4	50389275	HS	464 Multi Dowel Cutterheads	2–35
102	40	150	2	50389268	HS	464 Multi Dowel Cutterheads	2–35
102	40	150	4	50389276	HS	464 Multi Dowel Cutterheads	2–35
102	40	50	2	50389264	HS	464 Multi Dowel Cutterheads	2–35
102	40	50	4	50389272	HS	464 Multi Dowel Cutterheads	2–35
102	40	75	2	50389265	HS	464 Multi Dowel Cutterheads	2–35
102	40	75	4	50389273	HS	464 Multi Dowel Cutterheads	2–35
116	30	40/50	2	69563160		1547 Universal Cutterheads Euro - Silverline	2–20
116	40	40/50	2+2	69563163		1547 Universal Cutterheads Euro - Silverline	2–20
116	50	40/50	2	69563161		1547 Universal Cutterheads Euro - Silverline	2–20
120	20	3,2	35	58806260	HW	RNK-Matador 5	2–5
120	20	4,0	35	191948	HW	Grooving Cutters HW "G5"	2–5
120	20	4,0	35	50806254	HW	RNK-Matador 5	2–5
120	20	5,0	35	191949	HW	Grooving Cutters HW "G5"	2–5
120	20	5,0	35	50806255	HW	RNK-Matador 5	2–5
120	35	4,0	35	191952	HW	Grooving Cutters HW "G5"	2–5
120	35	5,0	35	191953	HW	Grooving Cutters HW "G5"	2–5
122	40	100	4	50822783		525 Profile Cutterheads	2–30
122	40	130	4	50822784		525 Profile Cutterheads	2–30
122	40	150	4	50822785		525 Profile Cutterheads	2–30
122	40	180	4	50822786		525 Profile Cutterheads	2–30
122	40	230	4	50822787		525 Profile Cutterheads	2–30
122	40	40	4	50822780		525 Profile Cutterheads	2–30
122	40	60	4	50822781		525 Profile Cutterheads	2–30
122	40	80	4	50822782		525 Profile Cutterheads	2–30
125	30	1,5	12	188359	HW	Grooving Cutters HW - MAN	2–3
125	30	1,8	12	188360	HW	Grooving Cutters HW - MAN	2–3
125	30	2,0	12	188361	HW	Grooving Cutters HW - MAN	2–3
125	30	2,2	12	188362	HW	Grooving Cutters HW - MAN	2–3
125	30	2,5	12	188363	HW	Grooving Cutters HW - MAN	2–3
125	30	3,0	12	188364	HW	Grooving Cutters HW - MAN	2–3
125	30	3,5	12	188365	HW	Grooving Cutters HW - MAN	2–3
125	30	4,0	12	50188366	HW	1101 Grooving Cutters	2–3
125	30	4,0	35	50806251	HW	RNK-Matador 5	2–5
125	30	4,5	12	188367	HW	Grooving Cutters HW - MAN	2–3
125	30	5,0	12	188368	HW	Grooving Cutters HW - MAN	2–3
125	30	5,0	35	50806253	HW	RNK-Matador 5	2–5
125	30	6,0	12	188369	HW	Grooving Cutters HW - MAN	2–3
125	30	7,0	12	188370	HW	Grooving Cutters HW - MAN	2–3
125	30	8,0	12	50188371	HW	1101 Grooving Cutters	2–3
125	30	10	12	188372	HW	Grooving Cutters HW - MAN	2–3
125	30	29	3+3	186401	DP	DIAMAX airFace Jointing Cutters DP	2–10
125	30	30	4 V4	68010013	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
125	30	32,5	3+3	186306	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	32,5	3+3	186307	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13

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125	30	43,2	3+3	185970	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	43,2	3+3	185971	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	43,2	3+3	186051	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	43,2	3+3	186052	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	43,2	3+3	58186399	DP	3585 Jointing Cutters DP airFace	2–10
125	30	50	4 V4	68010023	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
125	30	63	3+3	186055	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	63	3+3	186056	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	64	3+3	186048	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	64	3+3	186986	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP - MAN	2–14
125	30	64	3+3	58186400	DP	3585 Jointing Cutters DP airFace	2–10
125	30	64,4	3+3	185972	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	64,4	3+3	185973	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	64,4	3+3	186049	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	30	64,4	3+3	186050	DP	DIAMAX SmartJointer airFace Jointing Cutterheads DP	2–13
125	40	30	4 V4	68010014	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
125	40	50	4 V4	68010024	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
125	40	80	4	50561046	HS	556-1 Planing Cutterheads	2–26
125	40	100	2+2	50665050	HW	5570 Spiral Cutterheads	2–25
125	40	100	4	50561038	HS	556-1 Planing Cutterheads	2–26
125	40	130	2+2	50665101	HW	5570 Spiral Cutterheads	2–25
125	40	130	4	50561035	HS	556-1 Planing Cutterheads	2–26
125	40	150	4	50561036	HS	556-1 Planing Cutterheads	2–26
125	40	170	2+2	50665102	HW	5570 Spiral Cutterheads	2–25
125	40	180	4	50561037	HS	556-1 Planing Cutterheads	2–26
125	40	230	2+2	50665103	HW	5570 Spiral Cutterheads	2–25
125	40	240	2+2	50665104	HW	5570 Spiral Cutterheads	2–25
125	40	240	4	50561054	HS	556-1 Planing Cutterheads	2–26
125	50	30	4 V4	68010015	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
125	50	50	4 V4	68010025	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
130	30	40	2	50664637	HW	5567 Counter Profile Cutterheads	2–21
137	40	60	4	58562920		521-1 Hydro Profile Cutterheads	2–32
137	40	100	4	58562921		521-1 Hydro Profile Cutterheads	2–32
137	40	130	4	58562922		521-1 Hydro Profile Cutterheads	2–32
137	40	150	4	58562923		521-1 Hydro Profile Cutterheads	2–32
137	40	180	4	58562924		521-1 Hydro Profile Cutterheads	2–32
137	40	230	4	58562925		521-1 Hydro Profile Cutterheads	2–32
137	50	100	4	50822792		525 Profile Cutterheads	2–30
137	50	130	4	50822793		525 Profile Cutterheads	2–30
137	50	150	4	50822794		525 Profile Cutterheads	2–30
137	50	180	4	50822795		525 Profile Cutterheads	2–30
137	50	230	4	50822798		525 Profile Cutterheads	2–30
137	50	60	4	50822790		525 Profile Cutterheads	2–30
137	50	80	4	50822791		525 Profile Cutterheads	2–30
140	30	50	4 V4	68010043	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
140	40	50	4 V4	68010044	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
140	50	50	4 V4	68010045	HW	1586 Jointing and Rabbeting Cutterheads - Silverline	2–9
143	40	60	4	58562686	HS	520-1 Hydro Planing Cutterheads	2–27
143	40	130	4	58562689	HS	520-1 Hydro Planing Cutterheads	2–27
143	40	230	4	58562990	HS	520-1 Hydro Planing Cutterheads	2–27
150	30	1,5	12	188373	HW	Grooving Cutters HW - MAN	2–3
150	30	2,0	12	188375	HW	Grooving Cutters HW - MAN	2–3
150	30	2,2	12	188376	HW	Grooving Cutters HW - MAN	2–3
150	30	2,5	12	188377	HW	Grooving Cutters HW - MAN	2–3
150	30	3,0	12	50188378	HW	1101 Grooving Cutters	2–3
150	30	3,5	12	188379	HW	Grooving Cutters HW - MAN	2–3
150	30	4,0	12	50188380	HW	1101 Grooving Cutters	2–3
150	30	4,5	12	188381	HW	Grooving Cutters HW - MAN	2–3
150	30	5,0	12	50188382	HW	1101 Grooving Cutters	2–3
150	30	6,0	12	50188383	HW	1101 Grooving Cutters	2–3
150	30	7,0	12	50188384	HW	1101 Grooving Cutters	2–3
150	30	8,0	12	50188385	HW	1101 Grooving Cutters	2–3
150	30	9,0	12	188386	HW	Grooving Cutters HW - MAN	2–3
150	30	10	12	188387	HW	Grooving Cutters HW - MAN	2–3
150	50	60	4	58562926		521-1 Hydro Profile Cutterheads	2–32
150	50	60	6	58562934		521-1 Hydro Profile Cutterheads	2–32
150	50	100	4	58562927		521-1 Hydro Profile Cutterheads	2–32
150	50	100	6	58562935		521-1 Hydro Profile Cutterheads	2–32
150	50	130	4	58562928		521-1 Hydro Profile Cutterheads	2–32
150	50	130	6	58562936		521-1 Hydro Profile Cutterheads	2–32
150	50	150	4	58562929		521-1 Hydro Profile Cutterheads	2–32
150	50	150	6	58562937		521-1 Hydro Profile Cutterheads	2–32
150	50	180	4	58562930		521-1 Hydro Profile Cutterheads	2–32
150	50	180	6	58562938		521-1 Hydro Profile Cutterheads	2–32
150	50	230	4	58562931		521-1 Hydro Profile Cutterheads	2–32
150	50	230	6	58562939		521-1 Hydro Profile Cutterheads	2–32
150	50	260	4	58562932		521-1 Hydro Profile Cutterheads	2–32
150	50	260	6	58562940		521-1 Hydro Profile Cutterheads	2–32
150	50	310	4	58562933		521-1 Hydro Profile Cutterheads	2–32
150	50	310	6	58562941		521-1 Hydro Profile Cutterheads	2–32
160	20	6,0	12	50660304	HW	NKP	2–4
160	30	12,5-24,0	4 V4	68390023	HW	5562 Grooving Cutterheads - Silverline	2–8
160	30	15,0-30,0	4 V4	68400063	HW	5562 Grooving Cutterheads - Silverline	2–8
160	30	37-48	2	50664655	HW	5554 Counter Profile Set	2–22
160	30	4,0-7,5	8 V8	68370033	HW	5561 Grooving Cutterheads - Silverline	2–7
160	30	7,6	2	68370083	HW	5561 Grooving Cutterheads - Silverline	2–7
160	30	8,0-15,5	4 V4	68380023	HW	5562 Grooving Cutterheads - Silverline	2–8
160	40	12,5-24,0	4 V4	68390024	HW	5562 Grooving Cutterheads - Silverline	2–8
160	40	15,0-30,0	4 V4	68400064	HW	5562 Grooving Cutterheads - Silverline	2–8
160	40	4,0-7,5	8 V8	68370034	HW	5561 Grooving Cutterheads - Silverline	2–7
160	40	7,6	2	68370084	HW	5561 Grooving Cutterheads - Silverline	2–7
160	40	8,0-15,5	4 V4	68380024	HW	5562 Grooving Cutterheads - Silverline	2–8
163	50	60	4	58562687	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	60	6	58562688	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	60	8	58562738	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	60	8	58562942		521-1 Hydro Profile Cutterheads	2–32
163	50	100	4	58562691	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	100	6	58562692	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	100	8	58562740	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	100	8	58562943		521-1 Hydro Profile Cutterheads	2–32
163	50	130	4	58562693	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	130	4	58562741	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	130	6	58562742	HS	520-1 Hydro Planing Cutterheads	2–27

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163	50	130	8	58562944		521-1 Hydro Profile Cutterheads	2–32
163	50	150	6	58562694	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	150	8	58562743	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	150	8	58562945		521-1 Hydro Profile Cutterheads	2–32
163	50	180	4	58562700	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	180	6	58562702	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	180	8	58562750	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	180	8	58562946		521-1 Hydro Profile Cutterheads	2–32
163	50	230	4	58562695	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	230	6	58562696	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	230	8	58562744	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	230	8	58562947		521-1 Hydro Profile Cutterheads	2–32
163	50	260	4	58562697	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	260	6	58562698	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	260	8	58562745	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	260	8	58562948		521-1 Hydro Profile Cutterheads	2–32
163	50	310	4	58562701	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	310	6	58562703	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	310	8	58562751	HS	520-1 Hydro Planing Cutterheads	2–27
163	50	310	8	58562949		521-1 Hydro Profile Cutterheads	2–32
167	30	50	2	50663009	HW	1580 Pivoting Cutterheads	2–15
174	30	26	2+2	176097	HW	Miter Glue Joint Profile Cutterheads HW	2–24
180	30	4,0	18	169685	HW	Grooving Cutters HW	2–4
180	30	5,0	18	169684	HW	Grooving Cutters HW	2–4
180	30	8,0	18	169683	HW	Grooving Cutters HW	2–4
180	30	10	18	169682	HW	Grooving Cutters HW	2–4
180	40	35	6	58532354	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6	58532358	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6	58532382	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6	58532384	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6	58532387	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6+3	58532361	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6+3	58532390	HS	4000 Tongue and Groove Tools	2–38
180	40	35	6+3	58532391	HS	4000 Tongue and Groove Tools	2–38
200	30		2+2	68255130	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	30		2+2	68255230	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	30	12,0	2	68390073	HW	5562 Grooving Cutterheads - Silverline	2–8
200	30	12,5-24,0	4 V4	68390033	HW	5562 Grooving Cutterheads - Silverline	2–8
200	30	15,0	2	68380083	HW	5562 Grooving Cutterheads - Silverline	2–8
200	30	15,0-30,0	4 V4	68400033	HW	5562 Grooving Cutterheads - Silverline	2–8
200	30	4,0-7,5	8 V8	68370053	HW	5561 Grooving Cutterheads - Silverline	2–7
200	30	7,6	2	68370103	HW	5561 Grooving Cutterheads - Silverline	2–7
200	30	8,0-15,5	4 V4	68380033	HW	5562 Grooving Cutterheads - Silverline	2–8
200	40		2+2	68255140	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	40		2+2	68255240	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	40	12,0	2	68390074	HW	5562 Grooving Cutterheads - Silverline	2–8
200	40	12,5-24,0	4 V4	68390034	HW	5562 Grooving Cutterheads - Silverline	2–8
200	40	15,0	2	68380084	HW	5562 Grooving Cutterheads - Silverline	2–8
200	40	15,0-30,0	4 V4	68400034	HW	5562 Grooving Cutterheads - Silverline	2–8
200	40	4,0-7,5	8 V8	68370054	HW	5561 Grooving Cutterheads - Silverline	2–7
200	40	7,6	2	68370104	HW	5561 Grooving Cutterheads - Silverline	2–7
200	40	8,0-15,5	4 V4	68380034	HW	5562 Grooving Cutterheads - Silverline	2–8
200	50		2+2	68255150	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	50		2+2	68255250	HW	5540 Panel Raising Cutterheads - Silverline	2–18
200	50	12,0	2	68390075	HW	5562 Grooving Cutterheads - Silverline	2–8
200	50	12,5-24,0	4 V4	68390035	HW	5562 Grooving Cutterheads - Silverline	2–8
200	50	15,0	2	68380085	HW	5562 Grooving Cutterheads - Silverline	2–8
200	50	15,0-30,0	4 V4	68400035	HW	5562 Grooving Cutterheads - Silverline	2–8
200	50	4,0-7,5	8 V8	68370055	HW	5561 Grooving Cutterheads - Silverline	2–7
200	50	7,6	2	68370105	HW	5561 Grooving Cutterheads - Silverline	2–7
200	50	8,0-15,5	4 V4	68380035	HW	5562 Grooving Cutterheads - Silverline	2–8
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203	50	150	12	58562753	HS	520-1 Hydro Planing Cutterheads	2–27
203	50	230	12	58562754	HS	520-1 Hydro Planing Cutterheads	2–27
203	50	260	12	58562755	HS	520-1 Hydro Planing Cutterheads	2–27
203	50	310	12	58562756	HS	520-1 Hydro Planing Cutterheads	2–27
203	50	330	12	58562757	HS	520-1 Hydro Planing Cutterheads	2–27
250	30	8,0-15,0	8 V8	68380043	HW	5562 Grooving Cutterheads - Silverline	2–8
250	40	8,0-15,0	8 V8	68380044	HW	5562 Grooving Cutterheads - Silverline	2–8
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4	8	15	2	58502111	HW	2210 Router Bits	3–39
5	8	19	2	58502112	HW	2210 Router Bits	3–39
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6.0	6,0	15	2	50811419	VHW	2257-1 Finishing Cutters	3–9
6	8	25	2	58502113	HW	2210 Router Bits	3–39
6.0	12	12	1	183567	DP	DIAMAX Shank-Type Cutters DP	3–14
8	8	20	2	58502009	HW	2210 Router Bits	3–39
8	8	30	2	58502116	HW	2210 Router Bits	3–39
8.0	8,0	30	2	50811034	VHW	2257-1 Finishing Cutters	3–9
8.0	8,0	30	2	50811421	VHW	2257 Finishing Cutters	3–8
8.0	8,0	32	2+2	50811564	VHW	2257-2 Finishing Cutters	3–10
8.0	12	12	1	178659	DP	DIAMAX Shank-Type Cutters DP	3–14
8.0	12	20	1	175669	HW	Shank-Type Cutters with HW Turnover Knives - Z=1, MAN	3–1
8	12	22	1+1	58186994	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
8.0	12	22	2	187724	DP	DIAMAX Shank-Type Cutters DP	3–14
8.5	12	15	1+1	58187249	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
9.8	12	23	2	186879	VHW	Profile Grooving Shank-Type Cutters VHW - for Lamello Clamex P®	3–37
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10	8	32	2+1	58502119	HW	2210 Router Bits	3–39
10	10	20	1	185368	HW	Profile Grooving Shank-Type Cutters HW - for Lamello Clamex P®	3–37
10	10	25	1	175678	HW	Shank-Type Cutters with HW Turnover Knives - Z=1, MAN	3–1
10	10	30	2	178301	VHW	Roughing Cutters VHW - positive spiral	3–7
10	10	30	2	178332	VHW	Finishing Cutters VHW - negative spiral	3–8
10	10	30	2	50811036	VHW	2257-1 Finishing Cutters	3–9
10	10	32	2+2	50811565	VHW	2257-2 Finishing Cutters	3–10
10	12	20	1	185703	DP	Profile Grooving Shank-Type Cutters DP - for Lamello Clamex P®	3–38
10	12	22	1+1	186789	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
10	12	22	2	186784	DP	DIAMAX Shank-Type Cutters DP	3–14
10	12	22	2	186785	DP	DIAMAX Shank-Type Cutters DP	3–14
10	12	25	1	175670	HW	Shank-Type Cutters with HW Turnover Knives - Z=1, MAN	3–1
12	8	20	2	58502288	HW	2210 Router Bits	3–40
12	8	25	2+1	58502121	HW	2210 Router Bits	3–39
12	8	38	2+1	58502122	HW	2210 Router Bits	3–39
12	12	20	2+2	58187301	VHW	Roughing / Finishing Cutter VHW for lightweight panels	3–13
12	12	22	1+1	186790	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
12	12	25.4	1	181102	DP	DIAMAX Shank-Type Cutters DP	3–14
12	12	28	1+1	186792	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
12	12	28	1+1	186793	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
12	12	30	1	175664	HW	Shank-Type Cutters with HW Turnover Knives - Z=1, MAN	3–1
12	12	40	2+2	58187302	VHW	Roughing / Finishing Cutter VHW for lightweight panels	3–13
12	12	42	2	178335	VHW	Finishing Cutters VHW - negative spiral	3–8
12	12	42	2	50811037	VHW	2257-1 Finishing Cutters	3–9
12	12	42	2+2	50811566	VHW	2257-2 Finishing Cutters	3–10
12	12	42	3	178304	VHW	Roughing Cutters VHW - negative spiral	3–6
12	12	42	3	178336	VHW	Finishing Cutters VHW - negative spiral	3–8
12	12	42	3	50811424	VHW	2257-1 Finishing Cutters	3–9
12	12	45	2	178302	VHW	Roughing Cutters VHW - positive spiral	3–7
12	12	45	3	50811025	VHW	2265-1 Roughing Cutters	3–7
12	12	47	2	185826	VHW	Finishing Plunge Cutters VHW - door manufacturing	3–11
12	12	70	2	185828	VHW	Finishing Plunge Cutters VHW - door manufacturing	3–11
12	16	21	3	181935	DP	High-Performance Shank-Type Cutters with solid carbide body DP - Z=3	3–19
12	16	22	2+2	187075	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=2+2	3–21
12	16	22	2+2	187076	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=2+2	3–21
12	16	22	3+3	58186571	DP	3506 High-Performance Shank-Type Cutters CM	3–22
12	16	23	3+3	187281	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3	3–22
12	16	28	3	181936	DP	High-Performance Shank-Type Cutters with solid carbide body DP - Z=3	3–19
12	16	28	3+3	186572	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3	3–22
12	16	30	3	181937	DP	High-Performance Shank-Type Cutters with solid carbide body DP - Z=3	3–19
12.7	8	25	2	58512018	HW	2210 Router Bits	3–41
12.7	8	25	3	58512334	HW	2210 Router Bits	3–42
14	12	12,5	3	50811813	HW	1593 V Groove Letter Cutters	3–34
14	12	16,5	3	50811812	HW	1593 V Groove Letter Cutters	3–34
14	14	35	3	178305	VHW	Roughing Cutters VHW - positive spiral	3–7
14	14	35	3	178337	VHW	Finishing Cutters VHW - positive spiral	3–9
14	14	47	2	185829	VHW	Finishing Plunge Cutters VHW - door manufacturing	3–11
14	14	55	3	178307	VHW	Roughing Cutters VHW - positive spiral	3–7
14	14	55	3	178339	VHW	Finishing Cutters VHW - positive spiral	3–9
14	14	95	2	185833	VHW	Lock-Case Finishing Cutters VHW - door manufacturing	3–12
14	16	20	2+1	186579	DP	High-Performance Roughing Shank-Type Cutters DP - for the machining of solid core panels	3–16
14	16	33	3+3	187282	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3	3–22
14.7	8	8	2	58512087	HW	2210 Router Bits	3–40
15.7	8	8	2	58512088	HW	2210 Router Bits	3–40
15.8	8	16	2	58502269	HW	2210 Router Bits	3–41
16	16	22	1+1	186794	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
16	16	22	3+3	186573	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3	3–22
16	16	25.4	1	181104	DP	DIAMAX Shank-Type Cutters DP	3–14
16	16	28	1+1	186795	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
16	16	28	2+2	186147	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
16	16	28	2+2	187077	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=2+2	3–21
16	16	28	3+3	186574	DP	High-Performance Shank-Type Cutters CM DP Nesting - Z=3+3	3–22
16	16	28	3+3	50811803	DP	3506 High-Performance Shank-Type Cutters CM	3–22
16	16	30	1+1	168682	HW	Shank-Type Cutters with HW Turnover Knives - Z=1+1, MEC	3–3
16	16	32	4 (2+2)	185498	DP	Shank-Type Roughing-Finishing Cutters DP - Z=4 (2+2)	3–17
16	16	35	1	181106	DP	DIAMAX Shank-Type Cutters DP	3–14
16	16	35	1+1	186796	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
16	16	35	1+1	186797	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
16	16	35	2	178309	VHW	Roughing Cutters VHW - positive spiral	3–7
16	16	35	2	178340	VHW	Finishing Cutters VHW - positive spiral	3–9
16	16	35	2	178342	VHW	Finishing Cutters VHW - negative spiral	3–8
16	16	35	3	178310	VHW	Roughing Cutters VHW - positive spiral	3–7
16	16	35	3	178311	VHW	Roughing Cutters VHW - negative spiral	3–6
16	16	35	3	178341	VHW	Finishing Cutters VHW - positive spiral	3–9

Diameter Index Shank-Type Cutters

Ø D [mm]	Ø d [mm]	L2 [mm]	Z	Order-No.		Program	Page
16	16	35	3	178343	VHW	Finishing Cutters VHW - negative spiral	3–8
16	16	38	2+2	186148	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
16	16	38	2+2	186149	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
16	16	50	1+1	175714	HW	Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives	3–4
16	16	52	2	185830	VHW	Finishing Plunge Cutters VHW - door manufacturing	3–11
16	16	55	2	178313	VHW	Roughing Cutters VHW - positive spiral	3–7
16	16	55	2	178344	VHW	Finishing Cutters VHW - positive spiral	3–9
16	16	55	2+2	50811567	VHW	2257-2 Finishing Cutters	3–10
16	16	55	3	178312	VHW	Roughing Cutters VHW - negative spiral	3–6
16	16	55	3	178345	VHW	Finishing Cutters VHW - positive spiral	3–9
16	16	55	3	178347	VHW	Finishing Cutters VHW - negative spiral	3–8
16	16	55	3	178348	VHW	Finishing Cutters VHW - positive spiral	3–9
16	16	55	3	50811408	VHW	2265-1 Roughing Cutters	3–7
16	16	55	3	50811432	VHW	2257-1 Finishing Cutters	3–9
16	16	75	2	185831	VHW	Roughing Plunge Cutters VHW - door manufacturing	3–11
16	16	115	2	185834	VHW	Lock-Case Finishing Cutters VHW - door manufacturing	3–12
16	16	115	3	185836	VHW	Lock-Case Roughing Cutters VHW - door manufacturing	3–12
16	25	50	1+1	175715	HW	Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives	3–4
16.7	6	19	2	58512078	HW	2210 Router Bits	3–40
16.7	8	9	2	58512089	HW	2210 Router Bits	3–40
17	10	8,3	1	186880	HW	Ornamental Groove Cutters with HW turnover knives	3–31
18	16	28	1+1	186798	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	16	35	1+1	186801	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	16	35	1+1	186802	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	16	43	1+1	186805	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	16	43	1+1	186806	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	18	55	3	178316	VHW	Roughing Cutters VHW - positive spiral	3–7
18	18	55	3	178351	VHW	Finishing Cutters VHW - positive spiral	3–9
18	20	28	1+1	186799	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	20	28	1+1	186800	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	20	35	1+1	186803	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	20	35	1+1	186804	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	20	43	1+1	58186807	DP	3502 Shank-Type Cutters	3–15
18	20	43	1+1	58186808	DP	3502 Shank-Type Cutters	3–15
18	20	115	3	185837	VHW	Lock-Case Roughing Cutters VHW - door manufacturing	3–12
18	25	28	3+3	186118	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
18	25	28	3+3	186665	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–20
18	25	43	1+1	186912	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	25	43	1+1	186913	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
18	25	50	1+1	175716	HW	Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives	3–4
18	25	50	1+1	175717	HW	Shank-Type Cutters with HW Turnover Knives - Z=1+1 with mini turnover knives	3–4
18	25	55	2	177156	HW	Shank-Type Cutters with HW Turnover Knives - Z=2	3–5
18	25	55	2	180906	HW	Shank-Type Cutters with HW Turnover Knives - Z=2	3–5
18.7	6	10	2	58512090	HW	2210 Router Bits	3–40
18.7	8	10	2	58512096	HW	2210 Router Bits	3–40
19	8	16	2	58502261	HW	2210 Router Bits	3–39
19	12	14,5	2	50811815	HW	1520 Cutters for recessed grips	3–34
20	20	28	2+2	186150	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	20	35	1+1	186809	DP	DIAMAX Shank-Type Cutters DP - Z=1+1	3–15
20	20	38	2+2	186153	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	20	38	3+3	186119	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
20	20	38	3+3	186666	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
20	20	48	2+2	186156	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	20	50	2+2	185027	DP	Shank-Type Roughing Cutters DP	3–16
20	20	55	2	178318	VHW	Roughing Cutters VHW - positive spiral	3–7
20	20	55	3	178320	VHW	Roughing Cutters VHW - negative spiral	3–6
20	20	55	3	178353	VHW	Finishing Cutters VHW - positive spiral	3–9
20	20	55	3	178354	VHW	Finishing Cutters VHW - negative spiral	3–8
20	20	55	3	50811031	VHW	2265-1 Roughing Cutters	3–7
20	20	75	3	178355	VHW	Finishing Cutters VHW - positive spiral	3–9
20	20	75	3	178356	VHW	Finishing Cutters VHW - negative spiral	3–8
20	20	75	3	50811032	VHW	2265-1 Roughing Cutters	3–7
20	25	28	2+2	186151	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	28	2+2	186152	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	29,5	1+1	50184380	DP	3600 p-System High-Performance Shank-Type Cutters	3–24
20	25	38	2+2	186154	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	38	2+2	186155	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	48	2+2	186157	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	48	2+2	186158	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
20	25	52	1+1	58186810	DP	3502 Shank-Type Cutters	3–15
20	25	52	1+1	58186811	DP	3502 Shank-Type Cutters	3–15
20	25	53	2+2	184254	HW	Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle	3–2
20	25	53	2+2	184256	HW	Shank-Type Cutters with HW Turnover Knives - Z=2+2 with alternating shear angle	3–2
20	25	55	2	177157	HW	Shank-Type Cutters with HW Turnover Knives - Z=2	3–5
20.7	8	11	2	58512097	HW	2210 Router Bits	3–40
22.7	8	12	2	58512098	HW	2210 Router Bits	3–40
24.7	8	13	2	58512099	HW	2210 Router Bits	3–40
25	25	28	3+3	186120	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	28	3+3	186121	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	38	3+3	186122	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	38	3+3	186123	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	48	2+2	50184384	DP	3600 p-System High-Performance Shank-Type Cutters	3–24
25	25	48	3+3	186124	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	48	3+3	186125	DP	High-Performance Shank-Type Cutters DP - Z=3+3	3–20
25	25	65	2+2	186159	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
25	25	65	2+2	186160	DP	DIAREX High-Performance Shank-Type Cutters DP - Z=2+2	3–18
28	12	26	2	50811817	HW	1521 Dovetail Cutterheads	3–33
28.7	8	16	2	58512100	HW	2210 Router Bits	3–40
32.7	8	17	2	58512101	HW	2210 Router Bits	3–40

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Ø D [mm]	Ø d [mm]	L2 [mm]	Z	Order-No.		Program	Page
38	12	18	2	50811816	HW	1520 Cutters for recessed grips	3–34
40	16	6	2	50811820	HW	1523 Rounding Chamfering Cutterheads Set Z=2	3–35
41.5	25	41,3	1	185138		Folding Chamfering Cutterheads HW - Z=1	3–32
48	25	22	4+2+4	186139	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	22	4+2+4	186140	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	28	4+2+4	186141	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	28	4+2+4	186142	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	35	4+2+4	186143	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	35	4+2+4	186144	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	48	4+2+4	186145	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
48	25	48	4+2+4	186145	DP	High-Performance Trimming Router Bits DP - Z=4+2+4	3–23
52	12	7	6	50811814	HW	1594 Plaining Cutters	3–26
54	25	63	2+2	58187299	HW	Shank-Type Cutters with HW Turnover Knives - t3-System	3–30
54	25	78	2+2	58187300	HW	Shank-Type Cutters with HW Turnover Knives - t3-System	3–30
54	25	106,5	2+2	58187113	HW	Shank-Type Cutters with HW Turnover Knives - t3-System	3–30
60	20	9	2	50811821	HW	1523 Rounding Chamfering Cutterheads Set Z=2	3–35
60	25	38	3+3	50184083	DP	3610 p-System High-Performance Jointing Shank-Type Cutters	3–25
74	25	28	2	50811819	HW	1522 Chamfering Cutterheads	3–33
80			2+2+v2	58665105	HW	5575 Spiral Cutterheads	3–28
80			2+2+v2	58665106	HW	5575 Spiral Cutterheads	3–28
90	20	76	2+2	50811832	HW	1524 Handrail cutterheads	3–36
90	20	76	2+2	50811833	HW	1524 Handrail cutterheads	3–36
90	20	76	2+2	50811834	HW	1524 Handrail cutterheads	3–36
100	25	5,6	8	50811708	DP	3508 Planing and Rabbeting Shank-Type Cutters	3–26
100	25	14	4	182620	HW	Planing Shank-Type Cutterheads HW	3–27
125			2+2 V2+2	58665107		5576 Jointing and rabbeting cutterheads	3–29
125			2+2 V2+2	58665108		5576 Jointing and Rabbeting Cutterheads	3–29

Diameter Index Drill Bits

Ø D [mm]	Ø d [mm]	L2 [mm]	L1 [mm]	Order-No.		Program	Page
2.0	2,0	25	50	182625	VHW	Twist Drills with solid carbide body	4–1
2.0	2,0	25	50	182626	VHW	Twist Drills with solid carbide body	4–1
2.5	2,5	27	55	182627	VHW	Twist Drills with solid carbide body	4–1
2.5	2,5	27	55	50600742	VHW	2010 Twist Drills	4–1
3.0	3,0	27	55	182629	VHW	Twist Drills with solid carbide body	4–1
3.0	3,0	27	55	182630	VHW	Twist Drills with solid carbide body	4–1
3.0	10	18	57.5	50600261	VHW	2041 Dowel Bits	4–9
3.0	10	18	57.5	50600262	VHW	2041 Dowel Bits	4–9
3.0	10	18	70	50600267	VHW	2041 Dowel Bits	4–9
3.0	10	18	70	50600268	VHW	2041 Dowel Bits	4–9
3.0	10	27	70	50600376	VHW	2022 Through-Hole Bits	4–4
3.0	10	27	70	50600588	VHW	2022 Through-Hole Bits	4–4
3.5	3,5	27	52	182631	VHW	Twist Drills with solid carbide body	4–1
3.5	3,5	27	52	182632	VHW	Twist Drills with solid carbide body	4–1
4.0	4,0	27	55	182633	VHW	Twist Drills with solid carbide body	4–1
4.0	4,0	27	55	182634	VHW	Twist Drills with solid carbide body	4–1
4.0	10	20	57.5	182382	VHW	Mosquito Dowel Bits with solid carbide body	4–9
4.0	10	20	57.5	182383	VHW	Mosquito Dowel Bits with solid carbide body	4–9
4.0	10	27	57.5	50600100	HW	2032 Dowel Bits	4–6
4.0	10	27	57.5	50600101	HW	2032 Dowel Bits	4–6
4.0	10	27	70	50600455	VHW	2041 Dowel Bits	4–9
4.0	10	27	70	50600456	VHW	2041 Dowel Bits	4–9
4.0	10	35	70	173174	HW	Dowel Bits HW - without back-guide	4–6
4.0	10	35	70	173175	HW	Dowel Bits HW - without back-guide	4–6
4.0	10	35	70	50600450	VHW	2022 Through-Hole Bits	4–4
4.0	10	35	70	50600451	VHW	2022 Through-Hole Bits	4–4
5.0	5,0	28	60	182635	VHW	Twist Drills with solid carbide body	4–1
5.0	5,0	28	60	182636	VHW	Twist Drills with solid carbide body	4–1
5.0	10	22	57.5	50600263	VHW	2041 Dowel Bits	4–9
5.0	10	22	57.5	50600264	VHW	2041 Dowel Bits	4–9
5.0	10	25	57.5	50600132	HW	2020 Through-Hole Bits	4–2
5.0	10	25	57.5	50600133	HW	2020 Through-Hole Bits	4–2
5.0	10	25	57.5	50600640	HW	2040 Dowel Bits	4–8
5.0	10	25	57.5	50600641	HW	2040 Dowel Bits	4–8
5.0	10	27	57.5	182458	HW	Mosquito Through-Hole Bits HW	4–3
5.0	10	27	57.5	182459	HW	Mosquito Through-Hole Bits HW	4–3
5.0	10	27	57.5	50600102	HW	2032 Dowel Bits	4–6
5.0	10	27	57.5	50600103	HW	2032 Dowel Bits	4–6
5.0	10	30	57.5	50600174	HW	2031 Dowel Bits	4–5
5.0	10	30	57.5	50600175	HW	2031 Dowel Bits	4–5
5.0	10	30	70	50600269	VHW	2041 Dowel Bits	4–9
5.0	10	30	70	50600270	VHW	2041 Dowel Bits	4–9
5.0	10	35	70	183152	VHW	Mosquito Through-Hole Bits with solid carbide body	4–4
5.0	10	35	70	183152	VHW	Mosquito Through-Hole Bits with solid carbide body	4–4
5.0	10	35	70	50600116	HW	2032 Dowel Bits	4–6
5.0	10	35	70	50600117	HW	2032 Dowel Bits	4–6
5.0	10	35	70	50600136	HW	2020 Through-Hole Bits	4–2
5.0	10	35	70	50600137	HW	2020 Through-Hole Bits	4–2
5.0	10	35	70	50600372	HW	2021 Through-Hole Bits	4–3
5.0	10	35	70	50600373	HW	2021 Through-Hole Bits	4–3
5.0	10	35	70	50600648	HW	2040 Dowel Bits	4–8
5.0	10	35	70	50600649	HW	2040 Dowel Bits	4–8
5.0	10	36	70	50600690	VHW	2042 High-Performance Dowel Bits	4–10
5.0	10	36	70	50600691	VHW	2042 High-Performance Dowel Bits	4–10
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5.0	10	45	77	50600324	HW	Through-Hole Bits HW - without back-guide	4–2
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5.0	10	50	85	177194	HW	Dowel Bits HW - with back-guide, long version	4–7
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6.0	10	25	57.5	50600144	HW	2020 Through-Hole Bits	4–2
6.0	10	25	57.5	50600642	HW	2040 Dowel Bits	4–8
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6.0	10	30	57.5	167175	HW	Dowel Bits HW - with back-guide	4–5
6.0	10	30	57.5	167185	HW	Dowel Bits HW - with back-guide	4–5
6.0	10	30	70	183148	VHW	Mosquito Dowel Bits with solid carbide body	4–9
6.0	10	30	70	183149	VHW	Mosquito Dowel Bits with solid carbide body	4–9
6.0	10	35	70	176259	HW	Through-Hole Bits HW - without back-guide	4–2
6.0	10	35	70	50600118	HW	2032 Dowel Bits	4–6
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6.0	10	36	70	185773	VHW	High-Performance Dowel Bits with solid carbide body	4–10
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8.0	10	25	57.5	50600645	HW	2040 Dowel Bits	4–8
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Ledermann GmbH & Co. KG, Willi-Ledermann-Straße 1, 72160 Horb am Neckar, Germany
T +49 (0) 7451/93-222, F +49 (0) 7451/93-444
info@stehle-int.com, www.stehle-int.com

Machines

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

Application

Abrasive	Abrasive – excellently suited	Abrasive – well suited
Construction	Construction – excellently suited	Construction – well suited
Wood	Wood – excellently suited	Wood – well suited
Wood-based materials	Wood-based materials – excellently suited	Wood-based materials – well suited
Aluminium	Aluminium – excellently suited	Aluminium – well suited
Steel	Steel – excellently suited	Steel – well suited
Plastic	Plastic – excellently suited	Plastic – well suited

Design / Features

ALU Aluminium body	For cross cuts	VHW Solid tungsten carbide	max. 20.000 U/min Maximum RPM	MEC Mechanical feed
STEEL Steel body	For profile trimming	SK SK adapters	MC For Micro chips	
VHW Solid tungsten carbide body	HW TC02 Tungsten carbide quality	BT BT adapters	R/L Right hand / Left hand	
coated saw blade body	HS High speed steel	HSK HSK adapters	Hard wood	
LOW NOISE Low noise level	DP Polycrystalline diamond	1 No. of ground cutting edges	Soft woods	
x mm Resharpening area in mm	DM Monocrystalline diamond	v_f 60 m/min Recommended feed	MAN Manual feed	

Tooth Configurations

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

Delivery code

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o	available on short notice	#	Discontiuned, subject to availability		

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