

Panel processing

Leitz Lexicon Edition 7

Version 3

01/2026



Explanation of abbreviations

A	= dimension A	LH	= left hand rotation
a_e	= cutting thickness (radial)	M	= metric thread
a_p	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	min^{-1}	= revolutions per minute (RPM)
AL	= working length	MK	= morse taper
AM	= number of knives	m min^{-1}	= metres per minute
AS	= anti sound (low noise design)	m s^{-1}	= metres per second
b	= overhang	n	= RPM
B	= width	n_{max}	= maximum permissible RPM
BDD	= thickness of shoulder	NAL	= position of hub
BEM	= note	ND	= thickness of hub
BEZ	= description	NH	= zero height
BH	= tipping height	NL	= cutting length
BO	= bore diameter	NLA	= pinhole dimensions
CNC	= Computerized Numerical Control	NT	= grooving depth
d	= diameter	P	= profile
D	= cutting circle diameter	POS	= cutter position
D0	= zero diameter	PT	= profile depth
DA	= outside Diameter	PG	= profile group
DB	= diameter of shoulder	QAL	= cutting material quality
DFC	= Dust Flow Control (optimised chip clearance)	R	= radius
DGL	= number of links	RD	= right hand twist
DIK	= thickness	RH	= right hand rotation
DKN	= double keyway	RP	= radius of cutter
DP	= polycrystalline diamond	S	= shank dimension
DRI	= rotation	SB	= cutting width
FAB	= width of rebate	SET	= set
FAT	= depth of rebate	SLB	= slotting width
FAW	= bevel angle	SLL	= slotting length
FLD	= flange diameter	SLT	= slotting depth
f_z	= tooth feed	SP	= tool steel
$f_{z \text{ eff}}$	= effective tooth feed	ST	= Cobalt-basis cast alloys, e.g. Stellite®
GEW	= thread	STO	= shank tolerance
GL	= total length	SW	= cutting angle
GS	= Plunging edge	TD	= diameter of tool body
H	= height	TDI	= thickness of tool
HC	= tungsten carbide, coated	TG	= pitch
HD	= wood thickness (thickness of workpiece)	TK	= reference diameter
HL	= high-alloyed tool steel	UT	= cutting edges with irregular pitch
HS	= high-speed steel (HSS)	V	= number of spurs
HW	= tungsten carbide (TCT)	v_c	= cutting speed
ID	= ident number	v_f	= feed speed
IV	= insulation glazing	VE	= packing unit
KBZ	= abbreviation	VSB	= adjustment range
KLH	= clamping height	WSS	= workpiece material
KM	= edge breaker	Z	= number of teeth
KN	= single keyway	ZA	= number of fingers
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60	ZF	= tooth shape (cutting edge shape)
L	= length	ZL	= finger length
I	= clamping length		
LD	= left hand twist		
LEN	= Leitz standard profiles		

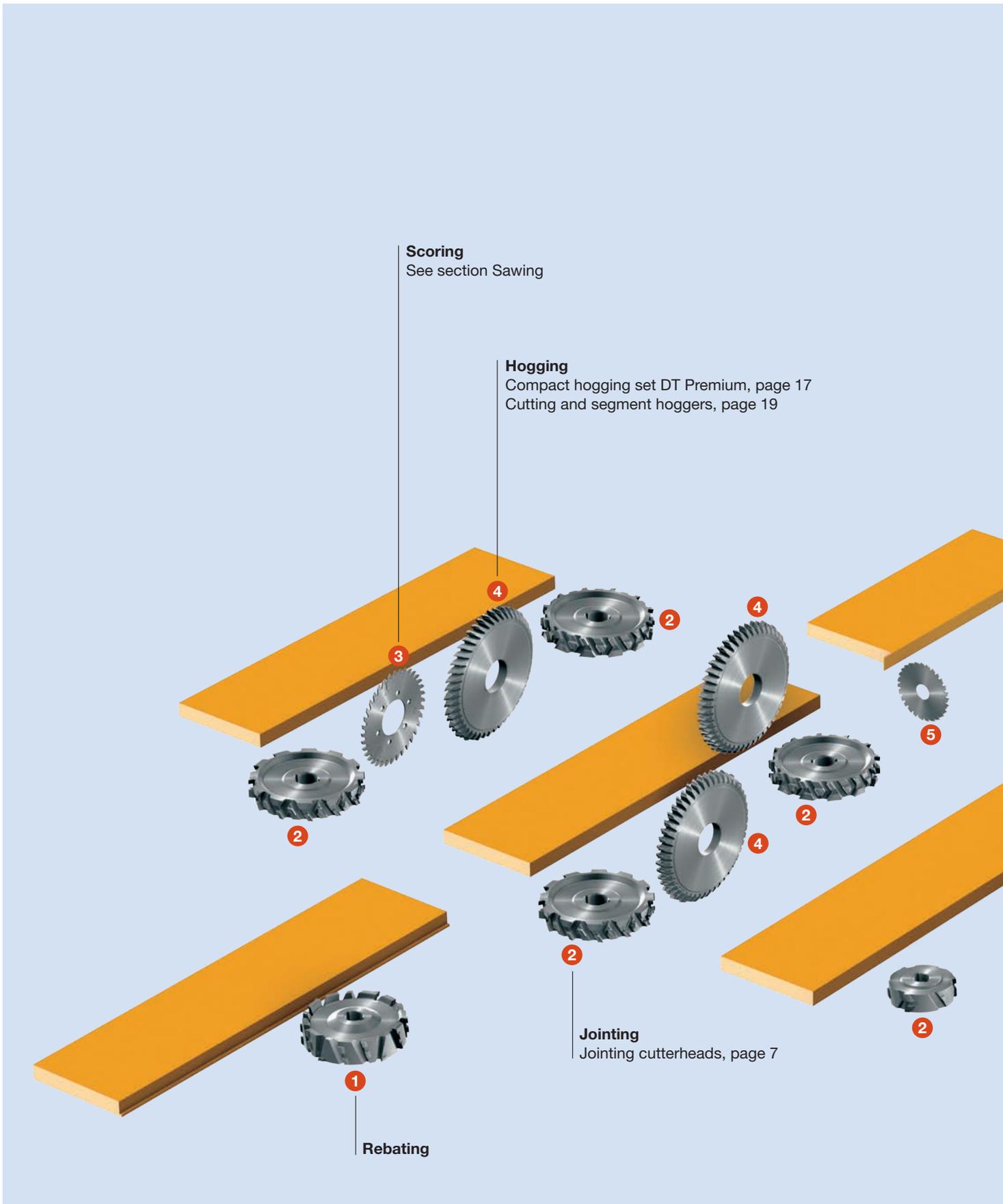
Notes to the Lexicon concerning the diagrams and tables

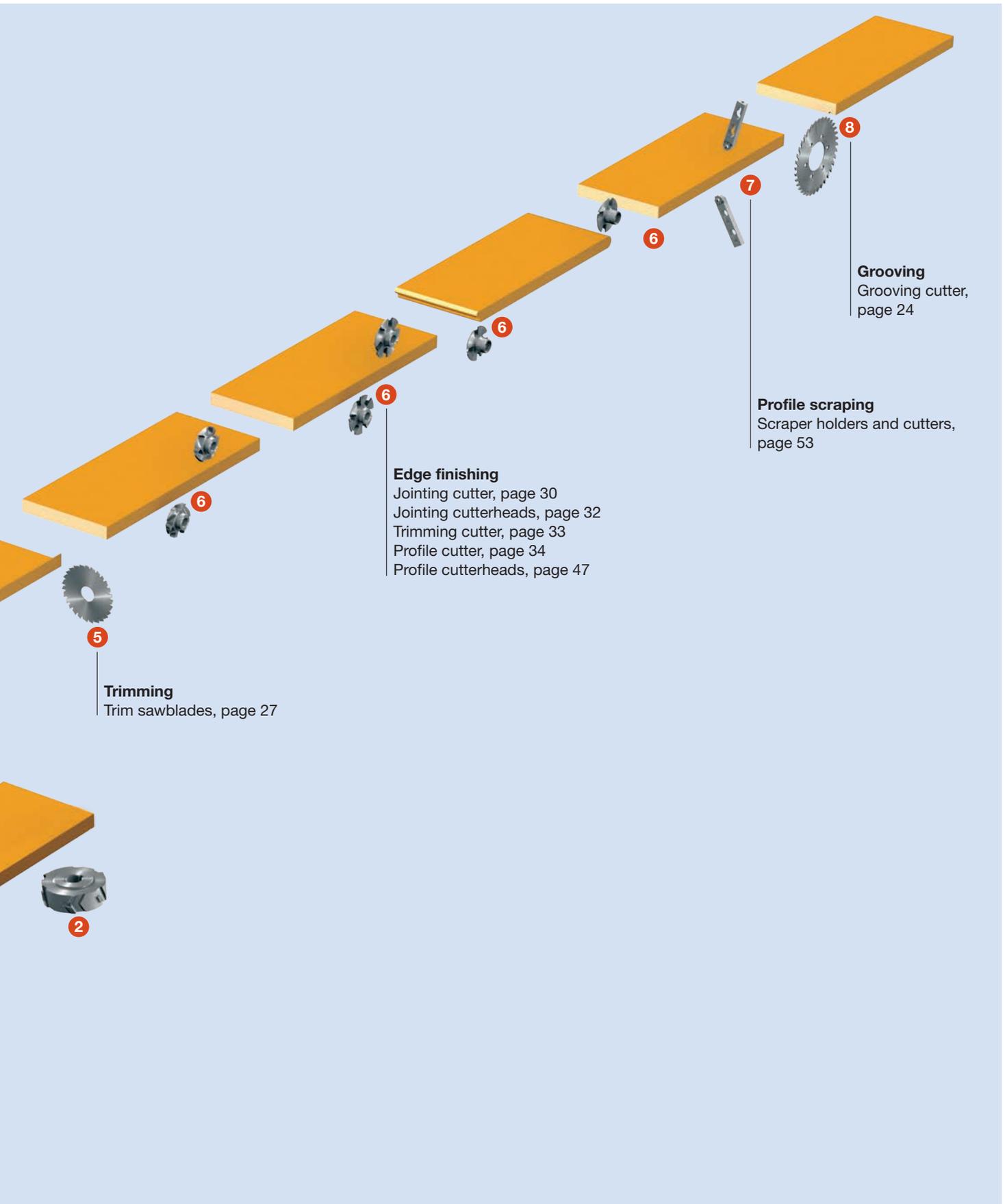
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



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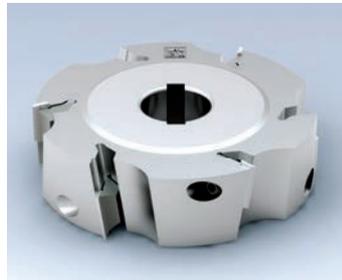
2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters

Type of operation	Cutting of the finished size with pre-sized, panel shaped working pieces. Therefore the jointing tools only are peripheral cutting and not with side relief!
Workpiece material	Softwood and hardwood, glulam, chipboard and fibre material, uncoated and veneered, plastic and paper coated.
Machines	Spindle moulders, edgebanding machines with sizing part, double end tenoners. Counter milling or jump cutting: Depending on the processing quantity and material, diamond tools or cutterheads with tungsten carbide turnblades are used.
Application	Jointing against feed: For all panel working materials with or without coating. Jointing with feed: For machining solid wood with heavily irregular course of fibres and risk of tear outs. Only allowed for machines with mechanical feed. Note: Chips are very difficult to remove. Jump cutting: Jointing with and against feed when cutting across, to prevent tear outs on the front and backside of the workpiece when these are already glued.

Tool Designs



Turnblade cutterhead with alternate shear angle: Suitable for all coated and uncoated panel shaped working materials. Turnblade tools with shear angle produce a curved surface on the workpiece. For exactly straight jointing edges we recommend ProfilCut profile cutterheads with profiled edges (special production) or diamond jointing cutters.

Diamond jointing cutter with alternate shear angle:

S = with symmetrical edge arrangement: Produce a slight hollow section on the milled jointing edge. This has the advantage that the edgebanding on the outside edge close tightly. The tool always must be adjusted symmetrically to the workpiece thickness.

The tool can be used in RH and LH rotation.

AS = Asymmetrical edge arrangement: One cutting edge cuts from bottom to top, the top cutting edges all are directed downward which is advantageous for frequently changing material thicknesses.



2-part tools on synchronically adjustable sleeve:

These tools with alternate shear angles are advantageous for high quantities and nearly constant workpiece thicknesses as with increasing tool blunting the jointing edges on the coating do not remain tear-free. The stepless and synchronic adjustment allows the use of multiple performance times and thus an increase of the tool lifetime.

Diamaster WhisperCut



Diamaster WhisperCut – The lightweight and efficient jointing cutterhead for low noise sizing of panel material.

Advantages at a glance:

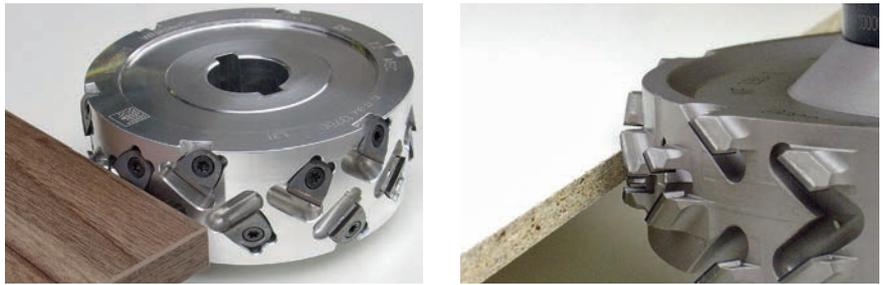
- Significant noise reduction of up to 5 dB(A) through optimized tool body shape and weight halving
- Trouble free chip ejection and excellent chip collection through DFC technology
- Individual use as per customer requirement: resharpenable or as changing knife system

2. Panel processing

2.1 Edge processing

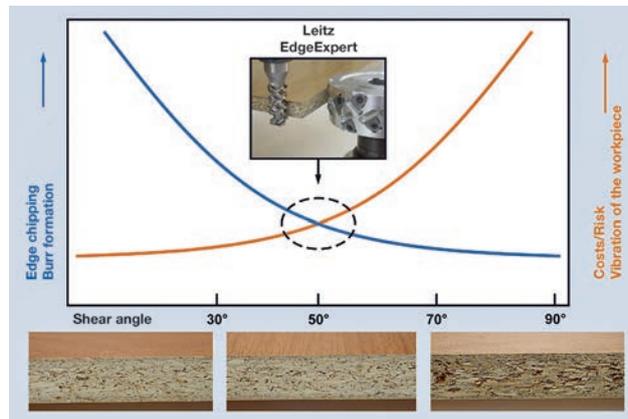
2.1.2 Jointing cutters

Diamaster EdgeExpert



Diamaster EdgeExpert – The expert for top edge performance especially in case of demanding decors.

In interior design and furniture manufacture, the use of processed material surfaces is increasing in both use and importance. This requires new tool concepts such as the Diamaster EdgeExpert program from Leitz. Whether very thin paper decors, veneers or foil- and high-gloss coating, the Diamaster EdgeExpert enables tear-free edges and even middle layer on continuous machines and CNC machining centres. Especially suitable for zero-joint edging technology with laser, plasma or hot air.

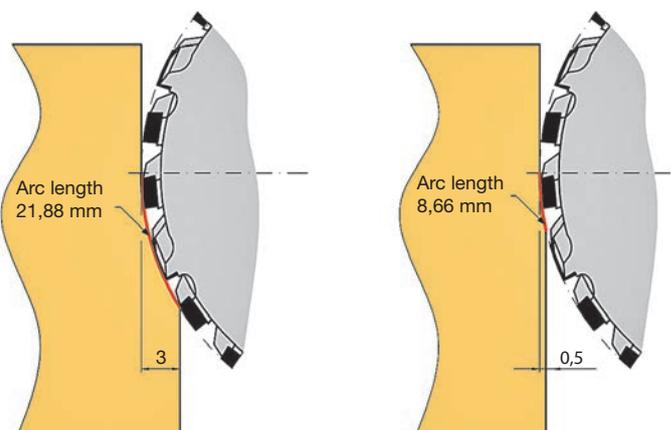


Dust collection

The tool characteristics of the joint cutter Diamaster PRO low noise model range have DFC gullet for delayed chip ejection and are suitable for i-system.

Chip removal

The chip removal has an important influence on the machining quality and on the tool life. Through a reduction of the chip removal, the arched length of the tool positioned in the interference is decreased, causing the tool to cut less material and to increase the tool life.



2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters

Noise emission

For noise reduction, LowNoise tools Diamaster PRO with its low knife protrusion, staggered edge and shear can be used. See section Edge Processing - Jointing Cutters.

Service

The Diamaster WhisperCut knives either can be serviced by Leitz Service or by the user on site.

Resharpener Diamaster WhisperCut



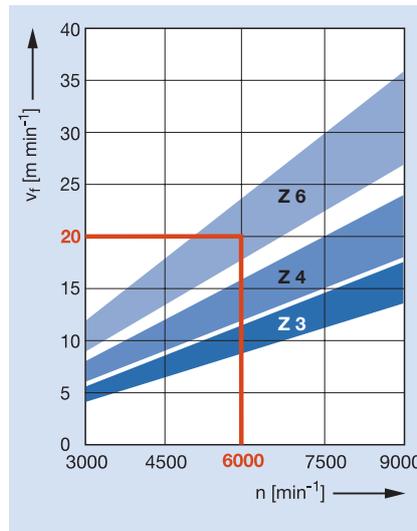
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

Diamaster WhisperCut – The jointing cutterhead with exchan- geable knives

- constant diameter
- quick and easy knife change by the user on site
- no costly adjustment at the machine
- no interchangeable tool required
- optimal knife utilization with small material thicknesses

Feed speed related to RPM and number of teeth Z

Material: Chipboard with melamine
resin coating



2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters



WhisperCut jointing / milling cutter - cutterhead design

Application:

For tear-free and low noise jointing of workpiece edges side with and against feed (jump cutting).

Machine:

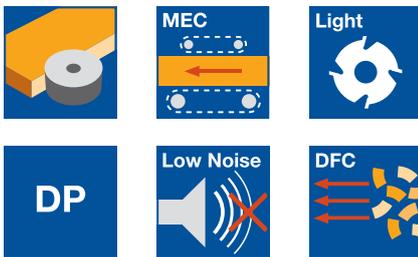
Edgebanding machines, copy shaping machines, double-end tenoners etc.

Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

Technical information:

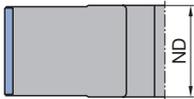
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surfaces. Tool with knife arrangement S can be used left and right and produces hollow cut for tightly closing edgebanding. Low noise design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) by DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.



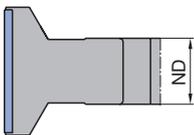
Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body

WF 230 2 DP, WM 230 2 01

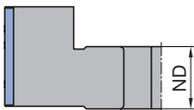
Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Ayza Mizrak	70	54	30	20	DKN	2	2x5	10xD	AS	192320 ● 192321 ●
Ayza Mizrak	125	54	40	30	DKN	3	3x5	15xE	AS	192326 192327
Biesse	80	45	53	30	DKN	1	2x4	8xB	S	192127 ● 192127 ●
Biesse	80	65	53	30	DKN	2	2x6	12xB	S	192128 ● 192128 ●
Biesse	100	43	75	30	DKN	1	3x4	12xA	S	192088 192088
Biesse	100	65	75	30	DKN	1	3x6	18xA	S	192089 192089
Biesse	125	43	40	30	DKN	2	3x4	12xE	S	075627 ● 075627 ●
Biesse	125	43	51	30	DKN	2	3x5	12xE	AS°	192379 192380
Biesse	125	61	51	30	DKN	2	3x6	15xE	AS°	192381 192382
Biesse	125	63	40	30	DKN	2	3x6	18xE	S	075626 ● 075626 ●
Brandt	100	43,6	40,6	25	DKN	3	2x4	8xA	AS	192211 ● 192212 ●
Brandt	100	62,5	40,6	25	DKN	3	2x6	12xA	AS	192345 192346
Brandt	100	43,6	40,6	30	DKN	3	3x4	12xA	AS	090885 ● 090886 ●
Brandt	100	65,2	40,6	30	DKN	3	3x6	18xA	AS	090887 ● 090888 ●
Brandt	100	105	85	30	DKN	3	3x10	30xA	AS	090891 090892
Cehisa	100	54	25	20	DKN	2	2x5	10xA	AS	192078 192079
EBM	70	43	61	25	DKN	1	2x4	8xB	AS	192237 ● 192238 ●
EBM	70	63	81	25	DKN	1	2X6	12xB	AS	192239 ● 192240 ●
EBM	100	43	61	30	DKN	1	2x4	8xB	AS	192233 ● 192234 ●
EBM	100	63	81	30	DKN	1	2x6	12xB	AS	192235 ● 192236 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192278 ●
Felder	60	63	63.5	25	DKN	3	2x7	2xC2		
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192277 ●
Felder	80	48,5	64	25	DKN	1	3x6	12xF	AS°	192281 ● 192282 ●
Felder	80	64	64	25	DKN	3	2x7	3xB1		
Felder	80	64	64	25	DKN	3	2x7	12xF	AS°	192300
Felder	80	64	64	25	DKN	3	2x7	2xB2		
Felder	80	64	64	25	DKN	3	2x7	12xF	AS°	192299
Felder	80	64	64	25	DKN	3	3x7	2xB1		
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192279 ●
Felder	80	64	64	25	DKN	3	3x7	3xB1		
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192280 ●
Felder	100	45	68	30	DKN	1	3x4	12xA	S	192400 192400
Felder	100	64	68	30	DKN	2	3x6	18xB	S	192399 192399
Fravol	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192247 ●
								2xC1		



Position of boss (NAL) 1



Position of boss (NAL) 2

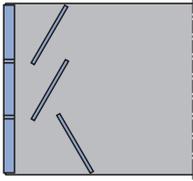


Position of boss (NAL) 3

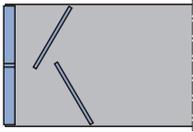
2. Panel processing

2.1 Edge processing

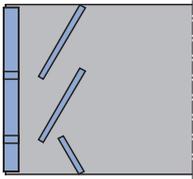
2.1.2 Jointing cutters



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



Type AS° = asymmetric tip arrangement with a narrow row of teeth below

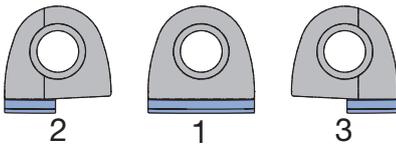
Machine	D mm	SB mm	ND mm	BO mm		NAL	Z	Knife Type	Type	ID LH	ID RH
Fravol	60	63	63.5	25	DKN	3	2x7	12xC	AS°		192248 ●
								2xC2			
Fravol	100	65	56.5	30	DKN	3	2x6	12xA	AS	192243	192244
Fravol	100	84	56.5	30	DKN	3	2x8	14xA	AS°	192285 ●	
								14xA1			
Fravol	100	84	56.5	30	DKN	3	2x8	14xA	AS°		192286 ●
								14xA2			
Fravol	100	124	96	30	DKN	2	2x11	22xA	AS	192245	192246
Hebrock	70	43	61	25	DKN	1	2x4	8xB	AS	192237 ●	192238 ●
Hebrock	70	63	81	25	DKN	1	2X6	12xB	AS	192239 ●	192240 ●
Hebrock	100	43	61	30	DKN	1	2x4	8xB	AS	192233 ●	192234 ●
Hebrock	100	63	81	30	DKN	1	2x6	12xB	AS	192235 ●	192236 ●
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°		192221 ●
								2xD2			
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°	192222 ●	
								2xD1			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°		192223 ●
								2xD2			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°	192224 ●	
								2xD1			
Holz-Her	100	63	39,5	30	DKN	2	3x6	18xB	S	192147	192148
								1804			
Holz-Her	100	43	25	30	DKN	2	2x4	8xA	AS	192082 ●	192083 ●
								1891			
Holz-Her	100	65	25	30	DKN	2	2x6	12xA	AS	192084	192085
								1891			
Holz-Her	100	63	39,5	HSK 32	R 2		3x6	18xB	S	192307	192308
								FG701			
Homag	100	43,6	40,6	25	DKN	3	2x4	8xA	AS	192211 ●	192212 ●
Homag	100	62,5	40,6	25	DKN	3	2x6	12xA	AS	192345	192346
Homag	100	43,6	40,6	30	DKN	3	3x4	12xA	AS	090885 ●	090886 ●
Homag	100	65,2	40,6	30	DKN	3	3x6	18xA	AS	090887 ●	090888 ●
Homag	100	105	85	30	DKN	3	3x10	30xA	AS	090891	090892
Homag	125	42,6	54	30	DKN	3	3x4	12xA	AS	192287 ●	192288 ●
Homag	125	43	40	30	DKN	2	3x4	12xE	S	075627 ●	075627 ●
Homag	125	63	40	30	DKN	2	3x6	18xE	S	075626 ●	075626 ●
Homag	125	63	54	30	DKN	3	3x6	18xA	AS	192289	192290
IMA	125	32	34	30	DKN	2	3x4	12xD	AS	192092	192093
IMA	125	43	42	30	DKN	2	3x5	15xD	AS	192094 ●	192095 ●
IMA	125	63	42	30	DKN	3	3x7	21xD	AS	192096 ●	192097 ●
IMA	125	43	57	30	DKN	1	3x5	15xD	AS	192098 ●	192099 ●
Advantage											
IMA	125	65	57	30	DKN	1	3x7	21xD	AS	192100 ●	192101 ●
Advantage											
Lange	60	65	62	20	DKN	2	2x7	12xC	AS°	192397	
								2xC1			
Lange	60	65	62	20	DKN	2	2x7	12xC	AS°		192398
								2xC2			
Mizrak	70	54	30	20	DKN	2	2x5	10xD	AS	192320 ●	192321 ●
Makine											
Nanxing	125	35	32	30	DKN	2	3x4	12xE	S	192419	192419
Nanxing	125	43	40	30	DKN	2	3x4	12xE	AS	192418	192417
Nanxing	125	55	40	30	DKN	1	4x5	20xE	AS	192421 ●	192420
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	192209 ●	
								3xB1			
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°		192210 ●
								3xB2			
Ott	85	65	45	30	DKN	2	3x6	18xB	AS	192227 ●	192228 ●
Ott	85	85	50	30	DKN	3	3x8	24xB	AS	192229	192230
Ott	100	43,6	40,6	30	DKN	3	3x4	12xA	AS	192413 ●	192414 ●
Ott	100	65,2	40,6	30	DKN	3	3x6	18xA	AS	192415 ●	192416 ●
SCM	80	56	58	30	DKN	2	2x6	10xC	AS°	192318	
								2xC1			
SCM	80	56	58	30	DKN	2	2x6	10xC	AS°		192319
								2xC2			
SCM	100	51	60	30	DKN	3	2x6	8xB	AS°	192215 ●	192216 ●
								2xB1			
								2xB2			

Machine	D	SB	ND	BO	NAL	Z	Knife Type	Type	ID LH	ID RH
	mm	mm	mm	mm						
SCM	100	51	60	30 DKN	3	3x6	12xB 3xB1 3xB2	AS°	192217 ●	192218 ●
SCM	100	66	60	30 DKN	3	2x7	12xB 2xB1 2xB2	AS°	192213 ●	
SCM	100	66	60	30 DKN	3	2x7	12xB 2xB2	AS°		192214 ●
SCM	100	66	60	30 DKN	3	3x7	18xB 3xB1	AS°	192219 ●	
SCM	100	66	60	30 DKN	3	3x7	18xB 3xB2	AS°		192220 ●
SCM	125	51		HSK 32 R 2		3x6	12xA 3xA1 3xA2	AS°	192337	192338
SCM	125	51		HSK 32 R 2		4x6	16xA 4xA1 4xA2	AS°	192341	192342
SCM	125	66		HSK 32 R 2		3x7	18xA 3xA1	AS°	192339	
SCM	125	66		HSK 32 R 2		3x7	18xA 3xA2	AS°		192340
SCM	125	66		HSK 32 R 2		4x7	24xA 4xA1	AS°	192343	
SCM	125	66		HSK 32 R 2		4x7	24xA 4xA2	AS°		192344
Stefani	100	51	60	30 DKN	3	2x6	8xB 2xB1 2xB2	AS°	192215 ●	192216 ●
Stefani	100	51	60	30 DKN	3	3x6	12xB 3xB1 3xB2	AS°	192217 ●	192218 ●
Stefani	100	66	60	30 DKN	3	2x7	12xB 2xB1	AS°	192213 ●	
Stefani	100	66	60	30 DKN	3	2x7	12xB 2xB2	AS°		192214 ●
Stefani	100	66	60	30 DKN	3	3x7	18xB 3xB1	AS°	192219 ●	
Stefani	100	66	60	30 DKN	3	3x7	18xB 3xB2	AS°		192220 ●
Turanlar Makine	70	54	30	20 DKN	2	2x5	10xD	AS	192320 ●	192321 ●
Turanlar Makine	70	54	30	20 DKN	2	3x5	15xD	AS	192324	192325
Turanlar Makine	125	54	30	30 DKN	3	3x5	15xE	AS	192322	192323
Törk Makine	100	65,2	40,6	30 DKN	3	3x6	18xA	AS	192415 ●	192416 ●

2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters



Shape of WhisperCut spare knives
SB 6.7 / 14 mm

Spare knives:

BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	A	1	091052 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A1	3	091082 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A2	2	091081 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	091066 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	3	091067 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B2	2	091068 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	C	1	091077 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C1	3	091079 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C2	2	091078 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	D	1	091071 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D1	3	091073 ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D2	2	091072 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	E	1	091074 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	F	1	091084 ●

Eroded spare knives for quick and easy knife change.

Spare parts:

BEZ	ABM mm	Machine	ID
Securing part set	40/30x8 M12	Holz-Her 1801/1802	116011 ●
Spindle nut	38x28 M25x1,5	Felder, Fraval	066566
Countersink screw, Torx® 20/59°	M5x11.5		007899 ●
Spanner wrench	50x5	Holz-Her up to YOM 2016	117538 ●
Torx® key	Torx® 20		117503 ●



WhisperCut EdgeExpert jointing / milling cutter - cutterhead design

Application:

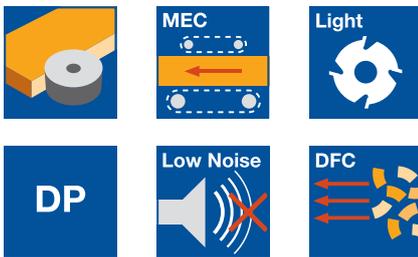
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

Machine:

Edgebanding machines, copy shaping machines, double-end tenoners etc.

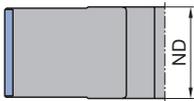
Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

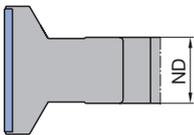


Technical information:

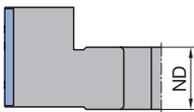
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.



Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3

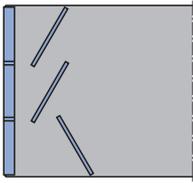
Diamaster WhisperCut EdgeExpert - DFC, LowNoise, aluminium alloy tool body WM 230 2 01

Machine	D	SB	ND	BO	NAL	Z	Knife	Type	ID	ID
	mm	mm	mm	mm					LH	RH
Biesse	80	33	53	30 DKN	1	3x4	12xG	S	192375	192375
Biesse	80	43	53	30 DKN	1	3x6	18xG	S	192356	192356
Biesse	100	33	75	30 DKN	1	3x4	12xH	S	192376	192376
Biesse	100	43	75	30 DKN	1	3x6	18xH	S	192357	192357
Biesse	125	33	40	30 DKN	2	3x4	12xl	S	192373	192373
Biesse	125	33	40	30 DKN	2	4x4	16xl	S	192374	192374
Biesse	125	43	40	30 DKN	2	3x6	18xl	S	192249 ●	192249 ●
Biesse	125	43	48	30 DKN	2	3x6	15xl	AS°	192383	
Biesse	125	43	48	30 DKN	2	3x6	15xl	AS°		192384
Biesse	125	43	40	30 DKN	2	4x6	24xl	S	192358	192358
Biesse	125	63	40	30 DKN	2	3x8	24xJ	S	192250	192250
Biesse	125	63	48	30 DKN	2	3x9	24xl	AS°	192392	
Biesse	125	63	48	30 DKN	2	3x9	24xl	AS°		192393
Homag	100	33	40.6	30 DKN	3	3x4	12xH	AS	192371	192372
Homag	100	43	40.6	25 DKN	3	3x5	15xl	AS	192361	192362
Homag	100	43	40.6	30 DKN	3	3x5	15xl	AS	192359 ●	192360 ●
Homag	125	33	40	30 DKN	2	3x4	12xl	S	192373	192373
Homag	125	33	40	30 DKN	2	4x4	16xl	S	192374	192374
Homag	125	43	40	30 DKN	2	3x6	18xl	S	192249 ●	192249 ●
Homag	125	43	54	30 DKN	3	3x5	15xJ	AS	192389	192390
Homag	125	43	40	30 DKN	2	4x6	24xl	S	192358	192358
IMA	125	43	40	30 DKN	2	3x6	18xl	AS	192251	192252
IMA	125	43	42	30 DKN	2	4x5	20xJ	AS	192367	192368
IMA	125	43	57	30 DKN	1	4x5	20xJ	AS	192369	192370
IMA	125	63	40	30 DKN	3	3x8	24xJ	AS	192301	192302
SCM	100	43	60	30 DKN	1	3x6	15xH	AS°	192363	
SCM	100	43	60	30 DKN	1	3x6	15xH	AS°		192364
SCM	125	43		HSK	2	4x6	20xl	AS°	192365	
SCM	125	43		32 R			4xJ1			
SCM	125	43		HSK	2	4x6	20xl	AS°		192366
				32 R			4xJ2			

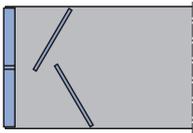
2. Panel processing

2.1 Edge processing

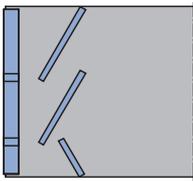
2.1.2 Jointing cutters



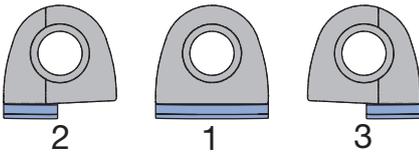
Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



Type AS° = asymmetric tip arrangement with a narrow row of teeth below



Shape of WhisperCut spare knives
SB 6.7 / 14 mm

Spare knives:

BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	G	1	091085 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	H	1	091086 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	I	1	091087 ●
WhisperCut-knife SB6,7	6.7x14.2x4.3	DP	I2	2	091093 ●
WhisperCut-knife SB6,7	6.7x14.2x4.3	DP	I1	3	091094 ●
WhisperCut-knife SB14	14x14.2x4.3	DP	J	1	091088 ●
WhisperCut-knife SB6,7	6.7x14.2x4.3	DP	J2	2	091095 ●
WhisperCut-knife SB6,7	6.7x14.2x4.3	DP	J1	3	091096 ●

Spare parts:

BEZ	ABM mm	ID
Countersink screw, Torx® 20/59°	M5x11.5	007899 ●
Torx® key	Torx® 20	117503 ●



WhisperCut PLUS jointing / milling cutter - cutterhead design

Application:

For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting).

Machine:

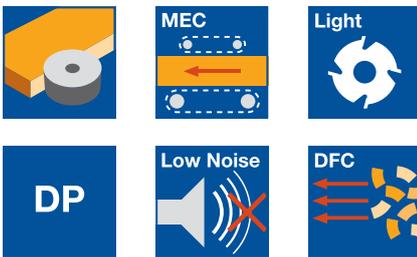
Edgebanding machines, copy shaping machines, double-end tenoners etc.

Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

Technical information:

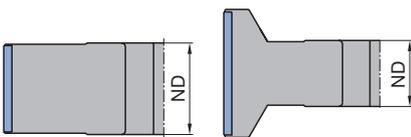
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. Resharpenable up to 12 times.



Diamaster WhisperCut PLUS - DFC, LowNoise, aluminium alloy tool body

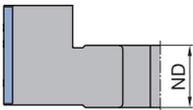
WM 230 2 02

Machine	D mm	SB mm	ND mm	BO mm	NAL	n_{max} min ⁻¹	Z	Type	ID	
									LH	RH
Biesse	84	45	53	30 DKN	1	16600	2x4	S	192401	192401
Biesse	84	43	53	30 DKN	1	16600	3x4	S	192402	192402
Biesse	100	43	75	30 DKN	1	15300	3x4	S	192403	192403
Biesse	125	43	40	30 DKN	2	13700	3x4	S	192404	192404
Homag	125	43	40	30 DKN	2	13700	3x4	S	192404	192404
Homag	125	42,6	54	30 DKN	3	13700	3x4	AS	192405	192406

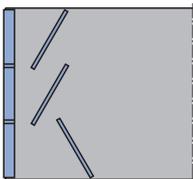


Position of boss (NAL) 1

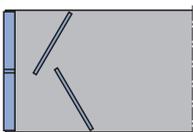
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement

Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

Technical information:

Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers.

Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body

WM 230 2 02

Machine	D mm	SB mm	ND mm	BO mm	NAL	n_{max} min ⁻¹	Z	Type	ID	
									LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192394	192394
Homag	125	43	40	30 DKN	2	13700	3x6	S	192394	192394
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192395	192396



Jointing / milling cutter on hydro sleeve

Application:

For tear-free and low noise jointing of workpiece edges side with and against feed (jump cutting).

Machine:

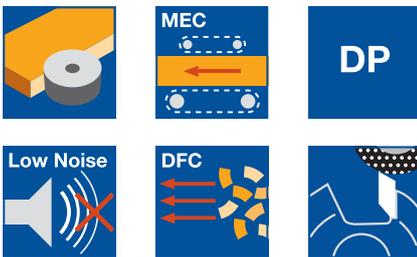
Edgebanding machines with zero joint technology.

Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

Technical information:

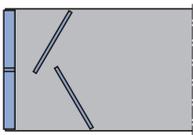
Increase of the processing quality through zero clearance hydro adaptor. Tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces hollow cut for tightly closing edgebanding.



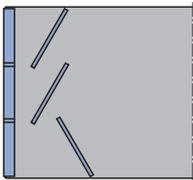
Diamaster PRO mounted on hydro sleeve

HF 230 2, HF 230 2 DP

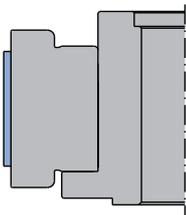
Machine	D mm	SB mm	BO mm	n_{max} min ⁻¹	NAL	Z	Type	ID	
								LH	RH
Homag	125	43	30	13600	1	5x4	S	192133	192134
Homag	125	63	30	13600	1	5x6	S	192135	192136
Homag	150	43	30	13600	1	5x4	S	192205 □	192206 □
Homag	150	63	30	13600	1	5x6	S	192207 □	192208 □



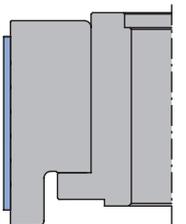
Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement



Position of boss (NAL) 1



Position of boss (NAL) 2

Diamaster WhisperCut EdgeExpert mounted on hydro sleeve

HM 230 2 01

Machine	D mm	SB mm	BO mm	n_{max} min ⁻¹	NAL	Z	Type	ID	
								LH	RH
IMA	125	43	30	13700	1	4x6	AS	192259	192258
IMA	125	63	30	13700	1	4x8	AS	192261	192260
IMA	150	43	30	13700	1	4x6	AS	192263	192262
IMA	150	63	30	13700	1	4x8	AS	192265	192264

Diamaster PRO mounted on hydro sleeve, IMA aggregate 08.379

WM 230 2 01

Machine	D mm	SB mm	BO mm	n_{max} min ⁻¹	NAL	Z	ID	
							LH	RH
IMA	125	65	30	13700	2	4x7	192313	192312
IMA	125	43,5	30	13700	2	4x5	192315	192314

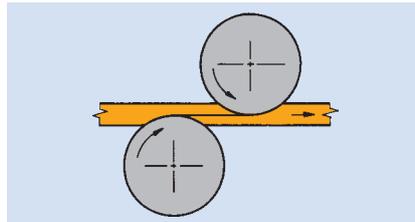
Spare parts:

BEZ	ABM mm	ID
Securing part	for HF-spindle HF 30	066563 ●
Allen key	SW 5, L 150	005501 ●

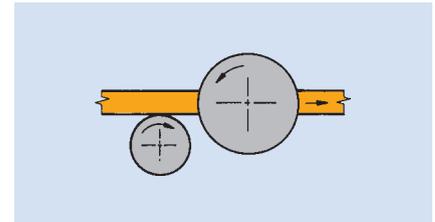
2. Panel processing

2.1 Edge processing 2.1.3 Compact hoggers - DP

Process	Hogging along and across the grain, sizing.
Workpiece materials	Chipboard and fibre materials (MDF) uncoated, with plastic or veneer coating.
Machines	Single sided, double-sided machines and double-end tenoners.
Application	Both sizing processes “double hogging” and “scoring/hogging” require two basic hogging types with different cutting geometries: Diamaster DT Premium – Double hogging with feed and negative rake angle and Diamaster DT Premium Score – Scoring/cutting with against feed with positive cutting angle.

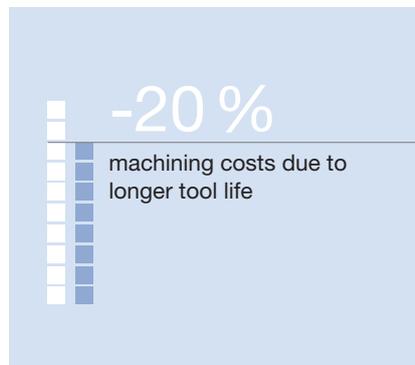


Double hogging: Both hogs cut with feed.



Scoring/hogging: Scoring saw cuts with feed, hogger against feed.

Compact hogger DT Premium	Manufacturers are facing major challenges due to their customers demanding changing quantities as well as requesting a wide variety of carrier and decorative materials to be used in panel production. The new DT Premium compact hogger is the solution for increasing productivity thanks to its long tool life – with perfect quality on the edge and cutting surface.
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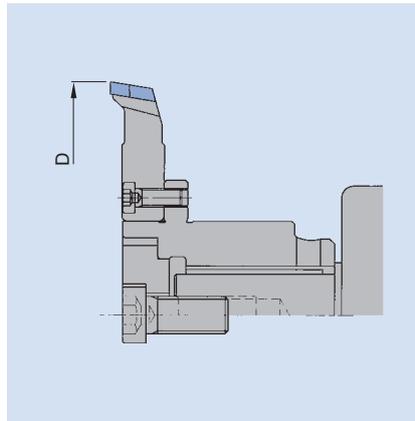


Productivity & efficiency	<p>Maximum economic efficiency through long tool life</p> <ul style="list-style-type: none"> – Long tool life even under difficult operating conditions thanks to new tooth shape – Reduction of set-up costs due to long tool life – Efficient chip removal due to innovative gullet geometry and integrated chipbreaker – Cost efficient processing of various materials – Ideal also for batch size 1 due to adapted cutting geometries – Resharpenable up to 15 times through larger resharpening area
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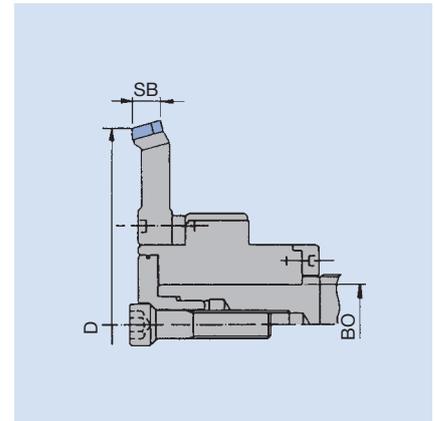
Quality	<p>Perfect edges and cutting surfaces</p> <ul style="list-style-type: none"> – Excellent edge quality and smooth cutting surfaces through adapted cutting geometries – Clean workpiece finishes due to efficient chip removal with DFC®-Technology – Constant cutting width over the entire life cycle
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Sustainability	<p>Longer tool life time, less dust and noise</p> <ul style="list-style-type: none"> – Reduced noise due to special tool design – Reduction of noise and vibration through damping elements – Longer tool life time through larger resharpening area
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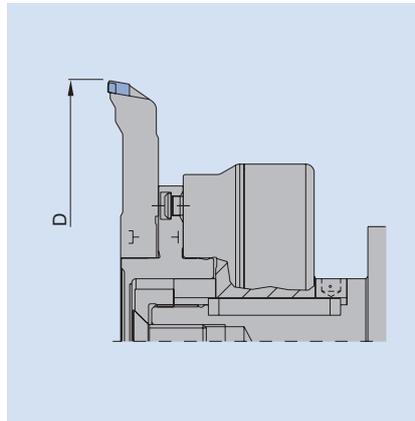
Designs



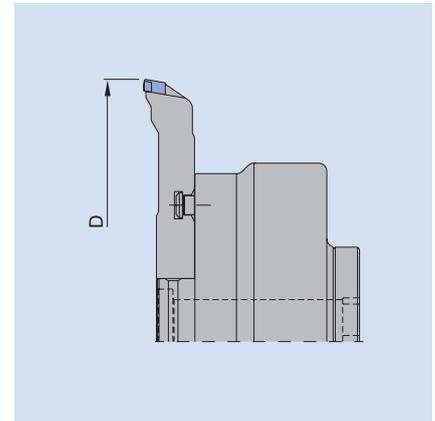
Tooth shape: top bevel decreasing.
Hogger on standard flange.



Tooth shape: top bevel increasing.
Hogger on HF hydro sleeve.



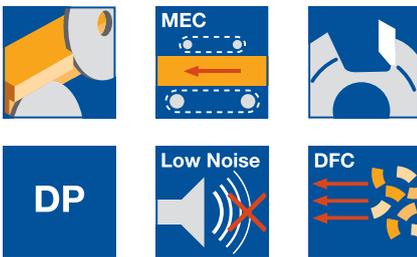
Tooth shape: top bevel decreasing.
Hogger on quick change sleeve.



Tooth shape: top bevel decreasing.
Hogger on hydro quick change sleeve.

2. Panel processing

2.1 Edge processing 2.1.3 Compact hoggers - DP



Order example:

Hogging set D-250 mm, Z 36, right
Hogging set consisting of:
DT Premium hogger D-250 ID **190393**
Hydro clamping sleeve ID **061702**

Special information:

Including assembly, machine model

Tooth shape 1 (ZF 1):

For processing different materials (batch size 1), coated wood materials such as HPL, melamine, high gloss.

Tooth shape 2 (ZF 2):

For processing veneers, paper, honey-comb panels.

Diamaster DT Premium

Application:

For hogging along and across grain - sizing - especially for **hogging / hogging**.

Machine:

Double-end tenoners, edgebanding machines etc.

Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, light construction panels (honeycomb).

Technical information:

Maximum economic efficiency through long tool life even in different materials (batch size 1). Up to 15 times resharpenable and constant cutting width over the entire life cycle. Perfect edge quality and smooth cutting surfaces through adapted cutting geometries. Clean workpiece finishes due to efficient chip removal with DFC-technology. Hogger as standard with 4 pinholes reference diameter 100 and quick clamping system 160 (BO 60) and 192 (BO 80).

Diamaster DT Premium

HZ 210 2

D	SB	BO	ZF	Z	v_f^*	ID	ID
mm	mm	mm			m min ⁻¹	LH	RH
250	10	60	1	24	30	190382 □	190383 □
250	10	60	1	36	40	190390 □	190391 □
250	10	60	1	48	50	190398 ●	190399 ●
250	10	60	1	60	80	190406 □	190407 □
250	10	60	2	24	30	190384 □	190385 □
250	10	60	2	36	40	190392 □	190393 □
250	10	60	2	48	50	190400 □	190401 □
250	10	80	1	24	30	190410 □	190411 □
250	10	80	1	36	40	190418 □	190419 □
250	10	80	1	48	50	190426 □	190427 □
250	10	80	2	24	30	190412 □	190413 □
250	10	80	2	36	40	190420 □	190421 □
250	10	80	2	48	50	190428 □	190429 □

Further dimensions on request.

Standard flanged sleeves, hydro clamping elements, quick clamping and hydro quick clamping sleeves, see section Clamping Systems.

* Recommended feed rate.



Compact hogger

Application:

For hogging along and across grain - for sizing applications in double hogging process (**hogging / hogging**).

Machine:

Double-end tenoners, edgebanding machines etc.

Workpiece material:

Particle and fibre materials (MDF etc.) uncoated, veneered, plastic and paper coated, lightweight panels (honeycomb).

Technical information:

Resharpenable 10 times. Hogger as standard with 4 pinholes reference diameter 100 and quick clamping system 160 (BO 60) and 192 (BO 80).

Compact hogger

HZ 210 2

D	SB	BO	Z	v_f^*	ID	ID
mm	mm	mm		m min ⁻¹	LH	RH
250	6,5	60	35	35	190478 ●	190479 ●
250	6,5	60	45	45	190480 ●	190481 ●
250	6,5	60	55	55	190482	190483
250	6,5	80	35	35	190484	190485
250	6,5	80	45	45	190486	190487
250	6,5	80	55	55	190488	190489

Standard flanged sleeves, hydro clamping, quick clamping and hydro quick clamping sleeves, see Lexicon section Clamping Systems.

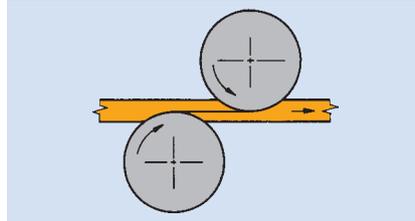
* Recommended feed rate for coated chipboard materials and fibre materials.

2. Panel processing

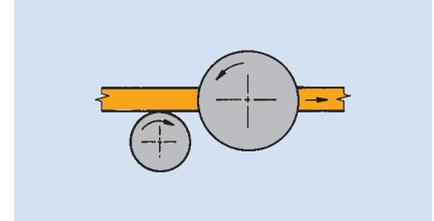
2.1 Edge processing 2.1.4 Cutting and segment hoggers

Process	Hogging along and across grain with/without scoring sawblades.
Workpiece materials	Solid wood, wood derived materials and composite materials.
Machines	Multi-rip saws, double-end tenoners, window making machines, edgebanding machines.

Application



Double hogging:
Both hogs cut with feed.



Scoring/hogging:
Scoring saw cuts with feed, hogger against feed.

Recommended tooth shape hogger sawblades

Workpiece material		FZ	ES	WZ
Softwood and hardwood	along grain	●		□
	across grain		●	●
Laminated wood	along grain	□	●	
	across grain		●	●
Chip/fibre materials	without coating	●	□	
	plastic coated	●	□	
	veneered		●	●
	paper coated		●	□
Composite material	HPL-coated	●	□	
	HDF, MDF veneered		●	□

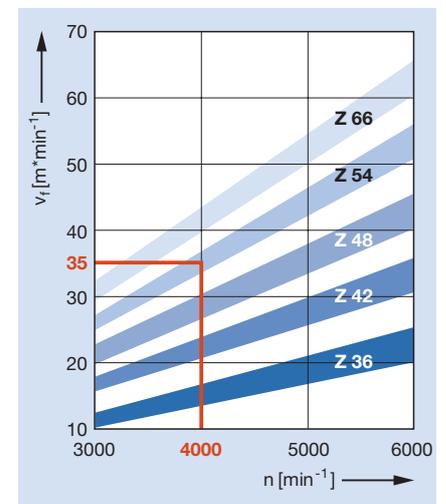
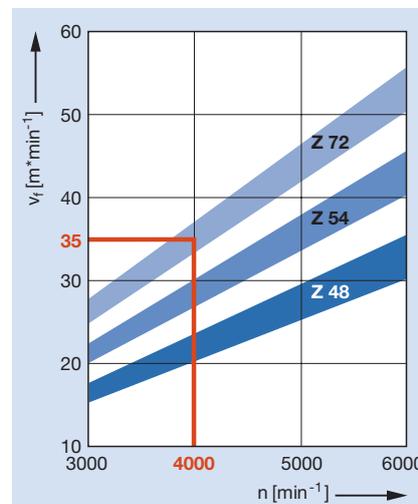
- suitable
- partly suitable

Cutting width and RPM

Tool*	D/mm	SB/mm	RPM max.
Segment hogger	250	25 – 50	7200 m/min ⁻¹
	300	30 – 60	6000 m/min ⁻¹
	350	35 – 70	5100 m/min ⁻¹

* A larger sawblade diameter is recommended for veneered chipboard, fibre materials and laminated wood (e.g. hogger D 250 mm → recommended sawblade D 260 mm).

Segment hogger



Feed speed v_f in relation to the number of teeth Z and RPM n .

2. Panel processing

2.1 Edge processing

2.1.4 Cutting and segment hoggers

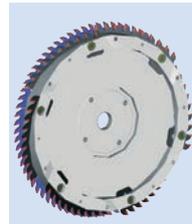
Segment hogger

Segment hoggers are a modular design. Segment hoggers are used, depending on the diameter, for hogging widths from 25 to 70 mm. Hoggers or segment hoggers combined with different circular sawblades are suitable for cutting the following materials along and across the grain:

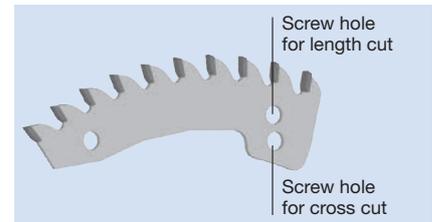
- Solid wood
- Wood derived materials without coating
- Wood derived materials with coating, with veneer, with paper etc.
- Composite materials



Cross cut



Length cut



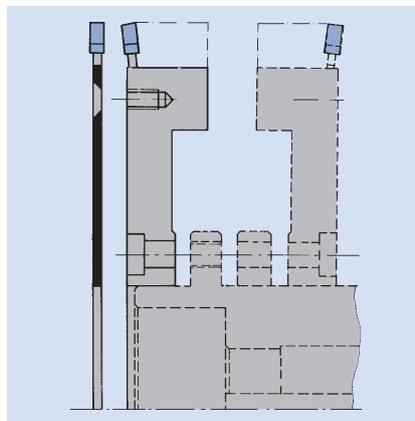
The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.

Segment hoggers with up to 12 segments are used for edging and sizing on wood-derived material production lines (e.g. Siempelkamp, Kontra etc.). A special segment hogger design has been developed for the finish cut on wood derived material production lines.

Saw hogger

Saw hoggers, single tools or assemblies with cutting widths of 6.35 - 12.00 mm are used for hogging along and across the grain and to size solid wood on finger jointing machines.

Assembly design/examples



Segment hogger with extension hogger.



Hoggers

Application:

For tear-free sizing along and across grain. Machining against feed only combined with scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

Machine:

Double-end tenoner, finger joint machine with trimming aggregate.

Workpiece material:

Solid wood and wood derived materials.

Technical information:

Steel tool body with HW circular sawblade and hogger elements mounted on flanged sleeve. Can be extended for larger hogger widths. Single sided bevel tooth shape reduces tear outs.



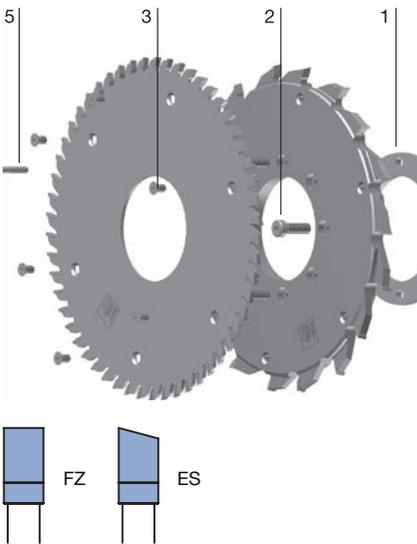
Basic hogger - steel tool body without flanged sleeve

WZ 210 2 01, WZ 210 2 02

BEZ	D	SB	BO	QAL	Z	ID	ID
	mm	mm	mm			LH	RH
Basic hogger	251	12	80	HW	18	062602 ●	062603 ●
Basic hogger	301	12	80	HW	24	062604	062605
Extension cutter	251	12	80	HW	18	062652	062653

Spare parts:

Part- no.	BEZ	ABM	BEM	ID
		mm		
1	Spacer	115x5x80		028046 ●
2	Cylindrical screw with ISK	M8x20		005946 ●
3	Countersink screw, Torx® 20	M6x10	Torx® 20	006083 ●
4	Screw with ISK	M8x17	for D = 250, 350, 305, 355	006237 ●
5	Allen key	SW 6		005447 ●
6	Torx® key	Torx® 20		117503 ●



Circular sawblade

WK 800 2 09, WK 800 2 38, WK 801 2, WK 801 2 05

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	4,4	80	54	FZ	HW	061825 ●	061826 ●
250	4,4	80	54	ES	HW	061837 ●	061838 ●
250	4,4	80	72	FZ	HW	061945 ●	061946 ●
260	4,4	80	72	ES	HW	061860 □	061861 □
260	4,4	80	72	FZ	HW	061947 ●	061948 ●
300	4,4	80	48	FZ	HW	061827 ●	061828 ●



Segment hoggers

Application:

For tear-free sizing along and across grain. Machining against feed only combined with scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

Machine:

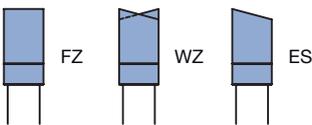
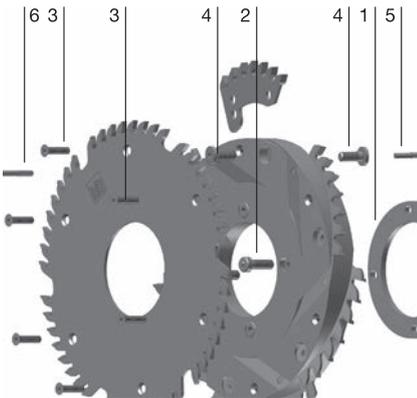
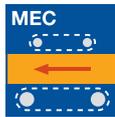
Double-end tenoners, finger joint machine with trimming aggregate, plug cutter.

Workpiece material:

All types of solid wood, chip and fibre boards (MDF ect.) uncoated, veneered, plastic and paper coated.

Technical information:

Steel tool body with HW circular sawblade and segment hogging elements. Staggered cut through six hogger segments. Mounted on flanged sleeve. Can be extended for larger hogging width. Single sided bevel tooth shape to improve the cutting quality and to reduce tear outs.



Steel basic and extension hoggers without flanged sleeve

WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	26,0	80	6x7	FZ	HW	064410 ●	064411 ●
300	31,5	30	6x9	FZ	HW	064412	064413
350	36,5	30	6x10	FZ	HW	064414	064415

Spare parts:

Part- no.	BEZ	ABM	SB	QAL	ZF	Z	BEM	ID
		mm	mm					
	Hogging segment	D 250	5,7	HW	FZ	7		064958 ●
	Hogging segment	D 250	5,7	HW	FZ	7		064959 ●
	Hogging segment	D 300	5,7	HW	FZ	9		064960 ●
	Hogging segment	D 300	5,7	HW	FZ	9		064961 ●
	Hogging segment	D 350	5,7	HW	FZ	10		064962 ●
	Hogging segment	D 350	5,7	HW	FZ	10		064963 ●
1	Spacer	115x5x80						028046 ●
2	Cylindrical screw with ISK	M8x20						005946 ●
3	Countersink screw, Torx® 20	M6x10					Torx® 20	006083 ●
4	Screw with ISK	M8x17					for D = 250, 350, 305, 355	006237 ●
5	Allen key	SW 6						005447 ●
6	Torx® key	Torx® 20						117503 ●

Spare circular sawblade for segment hogging set

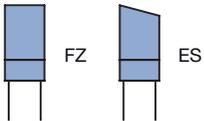
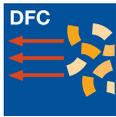
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	4,4	80	48	FZ	HW	061831 ●	061832 ●
250	4,4	80	48	ES	HW	061878	061879
250	4,4	80	66	FZ	HW	061953 ●	061954 ●
260	4,4	80	48	ES	HW	061963 ●	061964 ●
260	4,4	80	66	ES	HW	061965 ●	061966 ●
300	4,4	30	42	FZ	HW	061833	061834
300	4,4	30	66	FZ	HW	061055 ●	061056 ●
350	3,2	30	66	WZ	HW	058223 ●	058224 ●

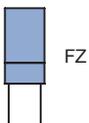
2. Panel processing

2.1 Edge processing

2.1.4 Cutting and segment hoggers



DFC segment hogger available on special request.



Spare circular sawblade for DFC segment hogger

WK 801 2, WK 801 2 05

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	4,4	80	54	ES	HW	061837 ●	061838 ●
260	4,4	80	72	ES	HW	061860 □	061861 □

Circular sawblades:

Tooth shape **ES** is optimised to cut across grain on softwood, hardwood, wood derived materials, veneered and paper coated and veneered composite materials.

Segments for DFC hogger (6 pieces / hogger)

TM 170 0

D	Z	ZF	QAL	ID	ID
mm				LH	RH
246	5	FZ	HW	064974 ●	064975 ●

DFC segment hogger available on special request.

Circular sawblade for non-Leitz segment hoggers

WK 800 2 46

Typ	D	SB	BO	Z	ZF	QAL	ID	ID
	mm	mm	mm				LH	RH
1	250	4	80	48	FZ	HW	061870 ●	061871 ●
1	250	4	100	48	FZ	HW	061872 □	061873 □

Type 1 for Leuco.

Segments for non-Leitz segment hogger

TM 170 0

Typ	für D	SB	Z	ZF	QAL	ID	ID
	mm	mm				LH	RH
1	200/250	4	4	FZ	HW	064976 ●	064976 ●

Type 1 for Leuco.

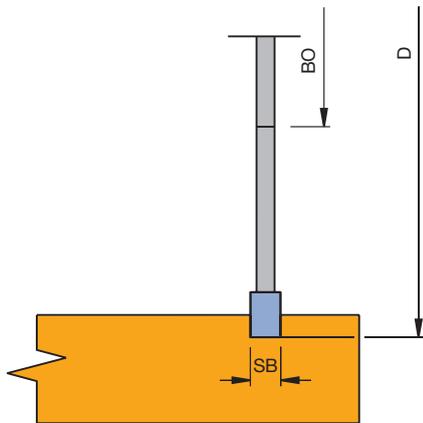
2. Panel processing

2.1 Edge processing

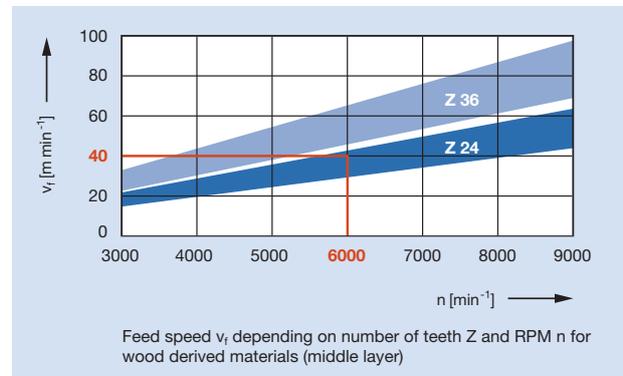
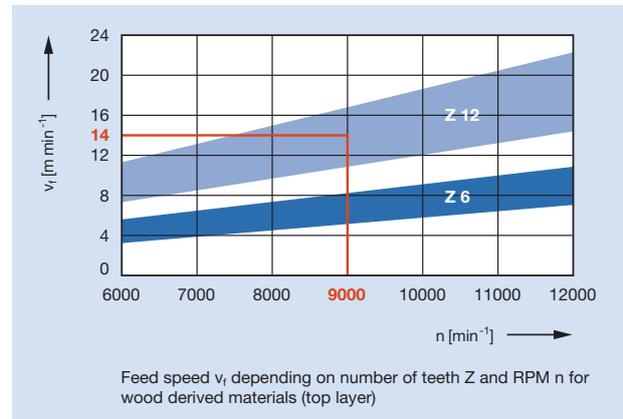
2.1.5 Grooving cutters

Grooving with feed

Straight cut composite tool for grooving with feed (MEC).



Cutting rear panel grooves

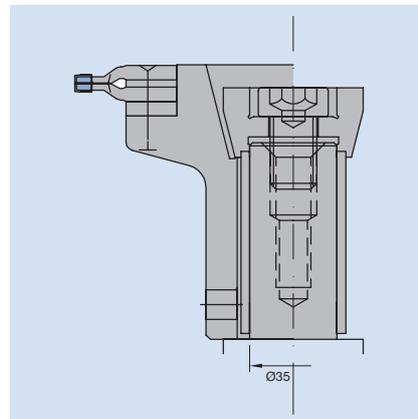


Grooving against feed

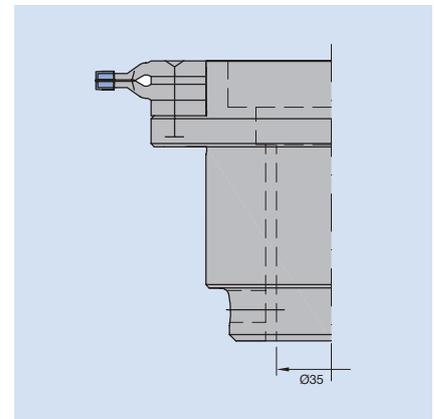
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

Adjustment of the cutting width with spacers (adjustment steps 0.1 mm). High chip collection by working against feed. Feed speed up to 40 m min^{-1} . Constant grooving width and distances to the machine chain also after regrinding. Special cutting geometry for tear-free cuts. Suitable to mount on sleeves with bore 30, 35 and 40 mm. Tipping height 6.0 mm.

Tools for grooving against feed available on request.



Assembly example:
Spindle 30 KN or DKN



Assembly example:
Spindle 35 KN or DKN



Grooving cutter for mechanical feed

Application:

Grooving with feed (climb cut).

Machine:

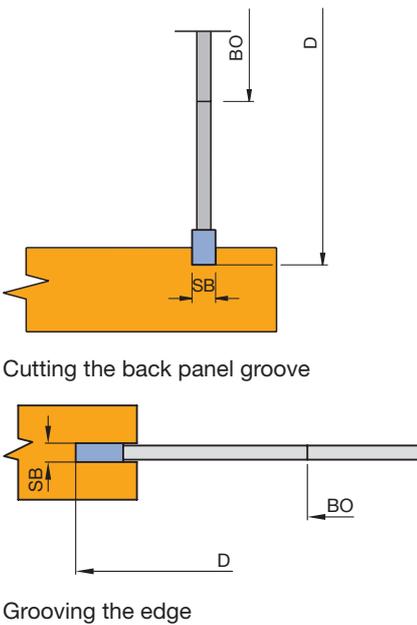
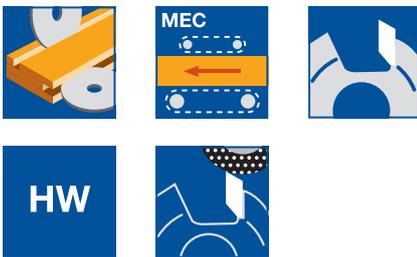
Moulders and double-end tenoners.

Workpiece material:

Solid wood, uncoated, coated and veneered wood derived materials.

HW tipped

WF 100 2, WF 100 2 02, WF 100 2 03



D	SB	TDI	BO	BO _{max}	Z	n _{max}	ID
mm	mm	mm	mm	mm		min ⁻¹	
80	4,0		16 DKN		3	12000	182000
125	1,5	0,8	30	50	12	13700	020145 ●
125	2,0	1,2	30	50	12	13700	020147 ●
125	2,5	1,4	30	50	12	13700	020149 ●
125	3,0	2,0	30	50	12	13700	020150 ●
125	3,5	2,2	30	50	12	13700	020151 ●
125	4,0	2,5	30	50	12	13700	020152 ●
125	4,5	3,0	30	50	12	13700	020153 ●
125	5,0	3,5	30	50	12	13700	020191 ●
125	6,0	4,5	30	50	12	13700	020192 ●
125	7,0	5,0	30	50	12	13700	020193 ●
125	8,0	6,0	30	50	12	13700	020194 ●
125	10,0	7,0	30	50	12	13700	020196 ●
150	1,5	0,8	30	60	18	11400	020164 ●
150	2,0	1,2	30	60	18	11400	020166 ●
150	2,5	1,4	30	60	18	11400	020168 ●
150	3,0	2,0	30	60	12	11400	020154 ●
150	3,0	2,0	30	60	18	11400	020169 ●
150	3,5	2,2	30	60	12	11400	020155 ●
150	4,0	2,5	30	60	12	11400	020156 ●
150	4,0	2,5	30	60	18	11400	020170 ●
150	4,5	3,0	30	60	12	11400	020157 ●
150	5,0	3,5	30	60	12	11400	020158 ●
150	5,0	3,5	30	60	18	11400	020171 ●
150	6,0	4,5	30	60	12	11400	020159 ●
150	6,0	4,5	30	60	18	11400	020172 ●
150	7,0	5,0	30	60	12	11400	020160 ●
150	8,0	6,0	30	60	12	11400	020161 ●
150	8,0	6,0	30	60	18	11400	020173 ●
150	8,5	7,0	30	60	18	11400	020319 ●
150	10,0	7,0	30	60	12	11400	020163 ●
150	10,0	7,0	30	60	18	11400	020174 ●
180	2,0	1,2	30	70	18	9500	020202 ●
180	2,5	1,4	30	70	18	9500	020203 ●
180	3,0	2,0	30	70	18	9500	020204 ●
180	3,5	2,2	30	70	18	9500	020205 ●
180	4,0	2,5	30	60	18	9500	020197 ●
180	5,0	3,5	30	60	18	9500	020198 ●
180	6,0	4,5	30	60	18	9500	020199 ●
180	8,0	6,0	30	60	18	9500	020200 ●
180	8,5	6,0	30	60	18	9500	020320 ●
180	10,0	7,0	30	60	18	9500	020201 ●
200	2,0	1,2	35	80	18	8500	020299 ●
200	3,0	2,0	35	80	18	8500	020302 ●
200	4,0	2,5	35	80	18	8500	020303 ●
200	5,0	3,5	35	80	18	8500	020304 ●
200	6,0	4,5	35	80	18	8500	020305 ●
200	8,0	6,0	35	80	18	8500	020306 ●
200	8,5	6,0	30	80	18	8500	020321 ●
200	10,0	7,0	35	80	18	8500	020307 ●


DP tipped

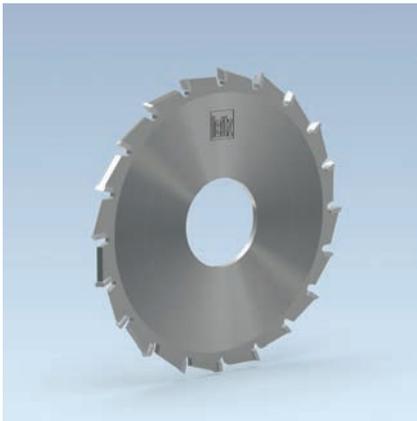
WF 100 2, WF 100 2 DP

D	SB	TDI	BO	BO _{max}	NLA	Z	ZF	QAL	n _{max}	ID
mm	mm	mm	mm	mm	mm				min ⁻¹	
80	4,0		16			3	FZ	DP		192334
150	4,0	2,5	30	60		18	FZ	DP	15200	192304
180	4,0	2,5	30	60		24	FZ	DP	12700	192305
180	8,5	6,5/8,5	80		4/9/100	35	WZ/WZ/	DP	9500	190755
					4/9/100		FZ			
200	4,0	2,5	30	80		24	FZ	DP	11400	192306

DP tipped, mounted on flanged sleeve ID 61681

SF 500 2

D	SB	BO	DKN	Z	ZF	QAL	n _{max}	ID
mm	mm	mm	mm				min ⁻¹	
180	8,5	35	10x43	35	WZ/WZ/FZ	DP	9500	190756 □



Circular sawblade for end trim on edgeworking machines

Application:

For low noise edgeworking trim cuts.

Machine:

Single or double-sided edgeworking machines and double-end tenoners.

Workpiece material:

Veneered, melamine and plastic edging.

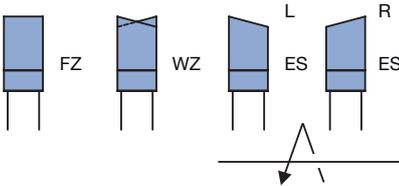
Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

Veneered and plastic edging:

Edging thickness ≥ 2.0 mm - crosscut saw ES pos.

Edging thickness < 2.0 mm - crosscut saw ES neg.



Circular sawblade - LowNoise, ES

SK 499 2, WK 101 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 372 2

Machine	D mm	SB mm	BO mm	NLA mm	Z	ZF	ID	
							LH	RH
Biesse	115	3,2	52	3/7,1/64	30	ES pos.	166420	166421
Biesse	130	3,6	30	4/7,4/46	24	ES pos.	166424 ●	166425 ●
Biesse	140	3,2	30	3/8/56	36	ES pos.	166427 ●	166426 ●
Biesse	150	3,5	30	3/8/56	36	ES neg.	166484 ●	166485 ●
Brandt	100	2,6	32		30	ES neg.	166400 ●	166401 ●
Brandt	100	2,6	32		30	ES pos.	166429 ●	166430 ●
Brandt	125	2,6	32		30	ES neg.	166403 ●	166404 ●
Cehisa	100	3,0	32		30	ES pos.	166436	166437
Fraval	100	3,2	22		24	ES pos.	166407 ●	166406 ●
Fraval	100	2,6	30		30	ES pos.	166476 ●	166477 ●
Fraval	125	3,2	22		30	ES pos.	166411 ●	166410 ●
Holz-Her	110	3,6	22		16	ES pos.	166439 ●	166440 ●
Homag	80	3,2	34	8/4,2/44	30	ES pos.	166443 ●	166444 ●
* Homag	100	3,0	32		20	ES pos.	166445 ●	166446 ●
Homag	100	3,2	32		20	ES neg.	166449	166450 ●
Homag	100	2,6	32		30	ES neg.	166400 ●	166401 ●
Homag	100	2,6	32		30	ES pos.	166429 ●	166430 ●
Homag	110	1,7	40	4/5,5/52	30	FZ/TR pos.	166453	166453
* Homag	120	3,2	40		30	ES pos.	166454	166455
Homag	125	2,6	32		30	ES neg.	166403 ●	166404 ●
SCM	150	3,8	35	4/6,5/50	30	ES pos.	166468 ●	166469 ●
Wiltsmeyer	100	3,2	32		20	ES neg.	166449	166450 ●

* = For 2 part set SK 499 2 use mounting flange ID **066750**.

Workpiece material:

Softwood, hardwood edging.

Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

Solid wood edging and multi-purpose application:

Edging thickness ≥ 2.0 mm - crosscut saw WZ pos.Edging thickness < 2.0 mm - crosscut saw WZ neg.**Circular sawblade - LowNoise, WZ**

WK 250 2, WK 350 2, WK 360 2, WK 370 2, WK 380 2, WK 850 2

Machine	D	SB	BO	NLA	Z	ZF	ID	ID
	mm	mm	mm	mm			LH	RH
Biesse	100	3,2	30		20	WZ pos.	166478 ●	166478 ●
Biesse	160	3,2	20		48	WZ pos.	166428 ●	166428 ●
Brandt	100	2,6	32		30	WZ pos.	166431 ●	166431 ●
Brandt	125	2,4	32		24	WZ pos.	166402 ●	166402 ●
EBM	100	2,4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Felder	100	3,2	22		20	WZ pos.	166438 ●	166438 ●
Felder	110	3,2	30		20	WZ pos.	166475 ●	166475 ●
Hebrock	100	2,4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Holz-Her	110	3,6	22		20	WZ pos.	065663 ●	065663 ●
Holz-Her	120	3,2	22		20	WZ pos.	166474 ●	166474 ●
Holz-Her	140	3,2	22		36	WZ pos.	166441 ●	166441 ●
Holz-Her	160	3,2	20		48	WZ pos.	166428 ●	166428 ●
Holz-Her	160	3,2	30		24	WZ pos.	065664 ●	065664 ●
Homag	100	3,6	32		20	WZ pos.	166451 ●	166451 ●
Homag	100	2,6	32		30	WZ pos.	166431 ●	166431 ●
Homag	110	3,6	32		20	WZ pos.	166452 ●	166452 ●
Homag	120	3,6	40	8/5,6/52	24	WZ pos.	166419 ●	166419 ●
Homag	120	3,2	40	8/5,6/52	36	WZ pos.	166456 ●	166456 ●
Homag	120	3,6	40	8/5,6/52	36	WZ pos.	166457 ●	166457 ●
Homag	125	2,4	30	8/6,5/48	36	WZ pos.	058234 ●	058234 ●
Homag	125	2,4	32		24	WZ pos.	166402 ●	166402 ●
Homag	170	3,2	30	8/5,6/52	36	WZ pos.	166412 ●	166412 ●
Homag	180	3,2	30	4/5,6/52	54	WZ pos.	166460 ●	166460 ●
IMA	160	3,2	22		48	WZ neg.	166414 ●	166414 ●
IMA	180	3,2	22		48	WZ neg.	166464 ●	166464 ●
IMA 08.415	180	3,5	22		42	WZ neg.	166415 ●	166415 ●
IMA 08.492	160	3,0	22		36	WZ pos.	166413 ●	166413 ●
Ott	140	3,2	16		36	WZ pos.	166466 ●	166466 ●
Raimann	100	3,6	32		20	WZ pos.	166451 ●	166451 ●
SCM	90	2,6	20		20	WZ	166483 ●	166483 ●
SCM	107	6,0	40		12	R3	166481 ●	166482 ●
SCM	115	3,2	30		30	WZ pos.	166416 ●	166416 ●
SCM	125	3,2	30		24	WZ	166480 ●	166480 ●

2. Panel processing

2.1 Edge processing

2.1.7 Edge finishing tools

Working processes	<p>Finishing plastic, veneered and solid wood edges of wood material boards.</p> <ul style="list-style-type: none"> – Pre-cutting to remove asymmetric edge protrusions on top and bottom edges and edge trimming solid wood edges. – Profiling a bevel or round edge on top and bottom edges. – Profiling a bevel and round edges on top and bottom edges and front and back. – Profile scrapers to remove knife marks. – Flat scrapers for excellent alignment of edge and workpiece.
Workpiece material	<p>Thick plastic edgebanding made from PVC, PP, ABS, thin plastic edgebanding made from melamine resin, veneer edgebanding, solid wood banding and edgebanding.</p>
Machines	<p>Single or double-sided edgebanding machines, double-end tenoners.</p>
Application	<p>Against feed for plastic edgebanding, preferably with feed for solid wood edge lippings.</p>
Technical features	<p>Tool and touch roller positions are coordinated, requiring constant tool dimensions. It is recommended not to resharpen tipped edge processing tools. Only constant diameter tool systems, such as ProfilCut Q Diamond, can be resharpened.</p>
Chip disposal	<p>Tools with optimised chip collection are designed to the corresponding machines (i-System, ED-System), and guide the chips from the tool cutting edge into the extraction. Even at low extraction air speeds more than 97% of the chips are collected. This improves not only process efficiency and productivity, but also the working environment. New machines require less extraction.</p>



Pre / finishing edge trimming cutter

Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

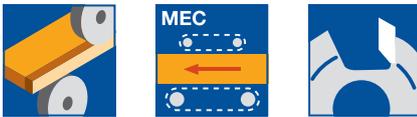
Plastic, softwood, hardwood and veneer edgebander.

Technical information:

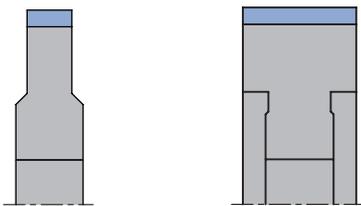
HW/DP tipped tools with cylindrical bore.

Joining cutter

WF 200 2, WF 200 2 DP, WF 210 2, WF 210 2 DP

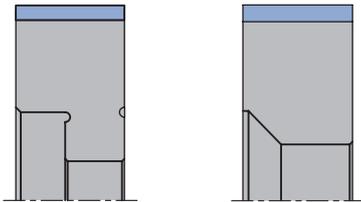


Machine	D mm	SB mm	ND mm	BO mm	Type	Z	QAL	ID LH	ID RH
Biesse	70	10	12	16	DKN 1	6	DP	090899	090899
Biesse	70	20	12	16	DKN 2	6	DP	090893	090893
Biesse	80	22	12	16	DKN 3	6	DP	192103 ●	192102 ●
Brandt	70	10	12	16	DKN 1	6	DP	090899	090899
Brandt	70	20	12	16	DKN 2	6	DP	090893	090893
Brandt	70	25	25	16	DKN 3	4	HW	065588 ●	065589 ●
Fravol	80	30	27,5	20	DKN 3	4	DP	192270	192271
Homag	70	10	12	16	DKN 1	6	DP	090899	090899
Homag	70	20	12	16	DKN 2	6	DP	090893	090893
Homag	70	25	25	16	DKN 3	4	HW	065588 ●	065589 ●
Ott	70	16,5	10	16	DKN 3	4	DP	192283 ●	192284 ●
SCM	80	30	11	16	DKN 2	4	HW	065595 ●	065596 ●
Stefani	80	20	11	16	DKN 2	4	DP	192110	192111



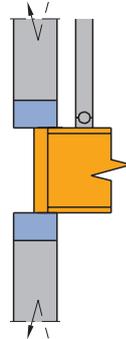
Type 1

Type 2

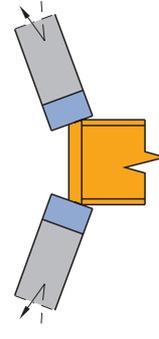


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Type 4



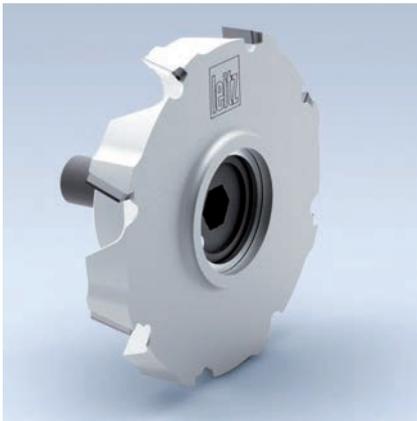
Trimming of edges on horizontal spindle - top motor tracing.



Bevelling of edges with inclined spindle.

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Pre / finishing edge trimming cutter with optimised chip collection

Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

Machine:

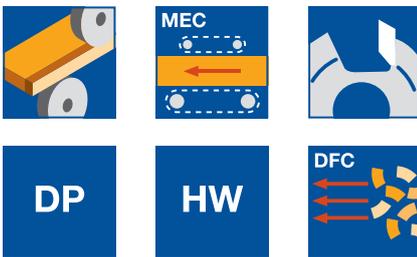
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity.



Jointing cutter - optimised chip collection

WF 200 2 DP, WF 210 2, WF 210 2 DP

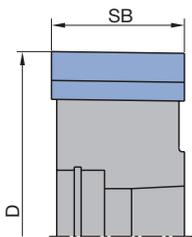
Machine	D mm	SB mm	BO mm	Z	QAL	ID	
						LH	RH
Homag, IMA	70	8	HSK 25 R	4	DP	● 198472	● 198473
Homag, IMA	70	8	HSK 25 R	6	DP	● 198474	● 198475
Homag, IMA	70	8	HSK 25 R	8	DP	● 198404	● 198405
Homag, IMA	70	15	HSK 25 R	4	DP	● 198406	● 198407
Homag, IMA	70	15	HSK 25 R	6	DP	● 198468	□ 198469
Homag, IMA	70	25	HSK 25 R	4	HW	● 073092	● 073093
SCM	80	8	HSK 25 R	4	DP	● 192335	● 192336
SCM	80	30	HSK 25 R	4	HW	● 182001	● 182002
SCM	80	30	16 DKN	4	DP	● 192328	● 192329

Recommended number of teeth:

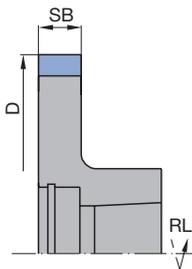
Feed rates of up to 35 m min⁻¹ Z 4

Feed rates of up to 60 m min⁻¹ Z 6

Feed rates of up to 100 m min⁻¹ Z 8 (thin edge)



HW jointing cutter with HSK 25 R adaptor, SB-25 mm



DP jointing cutter with HSK 25 R adaptor



Pre / finishing edge trimming cutter cutterhead design

Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

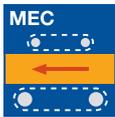
Technical information:

Cutterhead with turnblade knives, cylindrical bore or HSK 25 R adaptor.

Joining cutterhead

WW 200 2 06, WW 200 2 25

Machine	Type	D mm	SB mm	BO mm	Z	ID LH	ID RH
Brandt, Homag	1	70	14,3	16 DKN	4	025130	025130
Homag	1	70	14,3	HSK 25 R	4	073599	073600
Homag	2	70	20	16 DKN	4	025079 ●	025079 ●

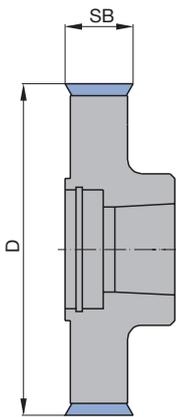


Spare knives:

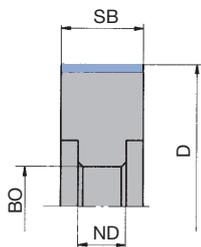
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	20x12x1,5	HW-05F	10	005083 ●
1	Turnblade knife	40x12x1,5	HW-05F	10	005085 ●
5	Turnblade knife	14,3x14,3x2,5	HW	10	005426 ●

Spare parts:

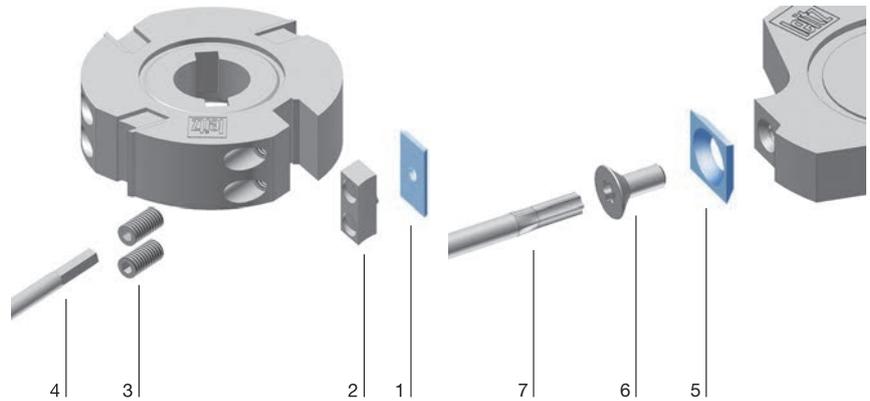
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with pin	18x11,5x7	005272 ●
3	Allen screw	M6x12	006035
6	Countersink screw, Torx® 20	M5x12	006247 ●
7	Torx® key	Torx® 20	006091 ●

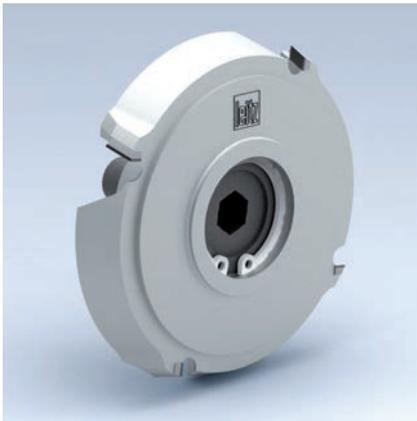


Type 1: WW 200 2 25



Type 2: WW 200 2 06





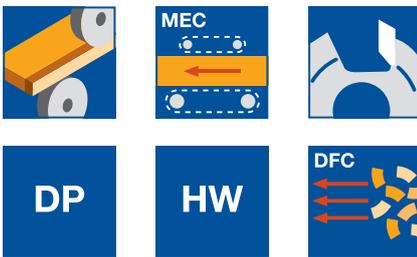
Bevel cutter with optimised chip collection

Application:
To bevel edgebandings.

Machine:
Single or double-sided edgebanding machines.

Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

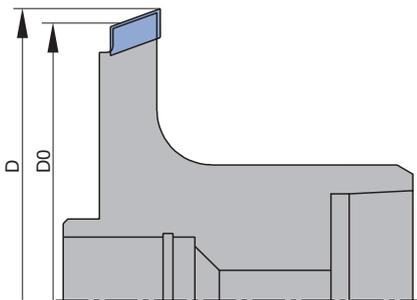
Technical information:
HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. Constant reference diameter. It is not recommended to sharpen the tool.



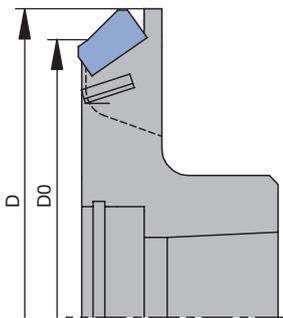
Various bevel angles - optimised chip collection

WF 300 2 DP, WF 350 2 DP, WF 501 2

Machine	D	D ₀	SB	BO	Z	QAL	FAW	NH	ID	ID
	mm	mm	mm	mm		°	mm	LH	RH	
Homag	65,14	62,3	5,7	HSK 32	4	DP	20	31,5	198200 ●	198201 ●
Homag	70	62,3	5,7	HSK 32	4	DP	45	31,5	198240	198241
Homag	65,14	62,3	5,7	HSK 32	6	DP	20	31,5	198202 ●	198203 ●
Homag	68,3	62,3	5,7	HSK 32	6	DP	45	31,5	198242	198243
Homag	72,91	70	5,5	HSK 25 R	4	DP	20	19,5	198408 ●	198409 ●
Homag	78	70	5,5	HSK 25 R	4	DP	45	19,5	198464	198465
Homag	73	70	5,5	HSK 25 R	6	DP	20	19,5	198410	198411
Homag	78	70	5,5	HSK 25 R	6	DP	45	19,5	198466	198467
IMA	72,91	70	5,5	HSK 25 R	4	DP	20	19,5	198408 ●	198409 ●
IMA	78	70	5,5	HSK 25 R	4	DP	45	19,5	198464	198465
IMA	73	70	5,5	HSK 25 R	6	DP	20	19,5	198410	198411
IMA	78	70	5,5	HSK 25 R	6	DP	45	19,5	198466	198467
SCM	69,6	61,7	6,0	HSK 25 R	4	HW	20	21,35	182552	182553
SCM	69,6	62,5	5,5	HSK 25 R	4	DP	45	22	192707 □	192708 □
SCM	69,6	62,5	5,5	HSK 25 R	4	DP	30	22	192705 □	192706 □
SCM	69,6	62,5	5,5	HSK 25 R	4	DP	20	22	192703 □	192704 □



Bevel cutter with HSK 32 adaptor for FK aggregates



Bevel cutter with HSK 25 R adaptor



Profile cutter

Application:

To round edgebandings.

Machine:

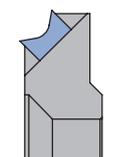
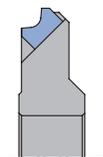
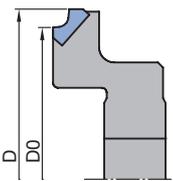
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

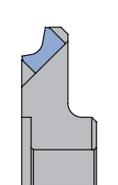
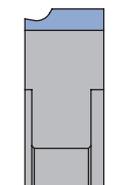
Technical information:

HW/DP tipped tools with cylindrical bore, HSK 25 R adaptor or HSK 32 adaptor for FK-aggregates. High concentricity. D_0 = constant reference diameter. It is not recommended to resharpen the tool.



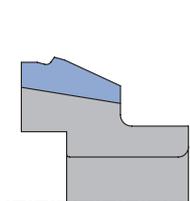
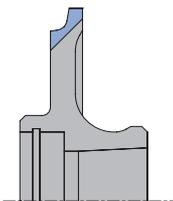
Type 3

Type 4



Type 5

Type 6



Type 7

Type 8

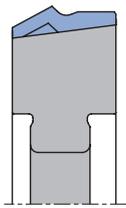
Various radii

WF 210 2 DP, WF 501 2, WF 501 2 DP, WF 502 2, WF 502 2 DP, WF 599 2

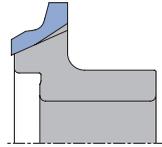
Machine	D	D ₀	BO	Z	QAL	R	FAW	Type	ID	ID
	mm	mm	mm			mm	°		LH	RH
Biesse	67	60	16 DKN	6	DP	1,0		1	091960 □	091961 □
Biesse	68	60	16 DKN	6	DP	2,0		1	091962 □	091963 □
Biesse	70	60	16 DKN	6	DP	3,0		1	091964 □	091965 □
Biesse	72	70	16 KN	6	DP	1,0		5	192518 □	192519 □
Biesse	73	70	16 KN	6	DP	2,0		5	192520 □	192521 □
Biesse	75	70	16 KN	6	DP	3,0		5	192522 □	192523 □
** Brandt	58	50	16	4	DP	1,0		2		192604 □
** Brandt	58	50	16	4	DP	1,5		2		192602 □
* Brandt	58	50	16	4	DP	2,0		2		091966
** Brandt	58	50	16	4	DP	2,0		2		192603 □
Brandt	70	62	HSK 25 R	4	DP	1,0		7	192588 □	192589 □
Brandt	70	62	HSK 25 R	4	DP	1,3		7	192590 □	192591 □
Brandt	70	62	HSK 25 R	4	DP	1,5		7	192592 □	192593 □
Brandt	70	62	HSK 25 R	4	DP	2,0		7	192594 □	192595 □
Brandt	70	62	HSK 25 R	4	DP	3,0		7	192596 □	192597 □
EBM	32	24	14 DKN	2	DP	2,0		3	074526	
Fravol	73	71,15	20 DKN	4	DP	1-3		8	192645 ●	192646 ●
Fravol	76,8	74,71	20 DKN	4	DP	1-3		9	192647	192648
Fravol	50	40,1	15 KN	4	DP	1-3		10	192663	192664 ●
Fravol	50	39,91	15 KN	4	DP	1-3		11		192665
Fravol	50	39,91	15 KN	4	HW	1-3		11		065597
Hebrock	32	24	14 DKN	2	DP	2,0		3	074526	
Holz-Her	57	50	16 DKN	2	DP	2,0		3	192536 □	192537 □
Holz-Her	57	50	16 DKN	2	DP	2,5		3	192538 □	192539 □
Holz-Her	57	50	16 DKN	2	DP	3,0		3	192540 □	192541 □
Holz-Her	56	50	20 DKN	2	DP	2,0		11	192506 ●	192507 ●
Holz-Her	56	50	20 DKN	2	DP	2,5		11	192508 □	192509 □
Holz-Her	57	50	20 DKN	2	DP	3,0		11	192510 □	192511 □
Holz-Her	58,7	50	16 DKN	3	DP	2,0		3	192512 □	192513 □
Holz-Her	58,7	50	16 DKN	3	DP	2,5		3	192514 □	192515 □
Holz-Her	58,7	50	16 DKN	3	DP	3,0		3	192516 □	192517 □
Holz-Her	72,5	61	20 DKN	4	DP	2,0		4	192500 □	192501 □
Holz-Her	72,5	61	20 DKN	4	DP	2,5		4	192502 □	192503 □
Holz-Her	72,5	61	20 DKN	4	DP	3,0		4	192504 □	192505 □

2. Panel processing

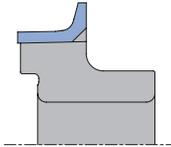
2.1 Edge processing 2.1.7 Edge finishing tools



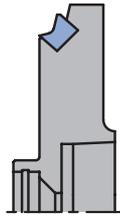
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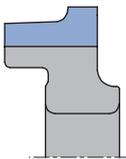
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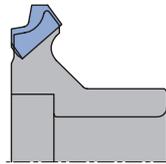
Type 11



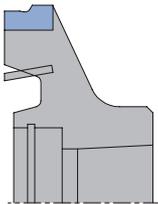
Type 12



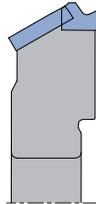
Type 13



Type 14



Type 15



Type 16

Machine	D mm	D ₀ mm	BO mm	Z	QAL	R mm	FAW °	Type	ID LH	ID RH
Holz-Her FR201	57	50	16 DKN	2	DP		45	1	192731 □	192732 □
Holz-Her FR201	57	50	16 DKN	2	DP	1,0		13	192733 □	192734 □
Holz-Her FR201	57	50	16 DKN	2	DP	1,3		13	192735 □	192736 □
Holz-Her FR201	57	50	16 DKN	2	DP	2,0		13	192737 □	192738 □
Holz-Her FR201	57	50	16 DKN	2	DP	2,5		13	192739 □	192740 □
Holz-Her FR201	57	50	16 DKN	2	DP	3,0		13	192741 □	192742 □
Holz-Her FR701	72	68	16 DKN	2+2	DP		45	16	192727 □	192728 □
Holz-Her FR701	72	68	16 DKN	2+2	DP	1		16	192719 □	192720 □
Holz-Her FR701	72	68	16 DKN	2+2	DP	1,3		16	192721 □	192722 □
Holz-Her FR701	72	68	16 DKN	2+2	DP	2		16	192723 □	192724 □
Holz-Her FR701	72	68	16 DKN	2+2	DP	3		16	192725 □	192726 □
** Homag	58	50	16	4	DP	1,0		2		192604 □
** Homag	58	50	16	4	DP	1,5		2		192602 □
* Homag	58	50	16	4	DP	2,0		2		091966
** Homag	58	50	16	4	DP	2,0		2		192603 □
Homag	70	62	HSK 25 R 4	4	DP	1,0		7	192588 □	192589 □
Homag	70	62	HSK 25 R 4	4	DP	1,3		7	192590 □	192591 □
Homag	70	62	HSK 25 R 4	4	DP	1,5		7	192592 □	192593 □
Homag	70	62	HSK 25 R 4	4	DP	2,0		7	192594 □	192595 □
Homag	70	62	HSK 25 R 4	4	DP	3,0		7	192596 □	192597 □
Homag	67,1	62	HSK 32	4	DP	1,0		12	091500 □	091501 □
Homag	68,1	62	HSK 32	4	DP	1,5		12	091502 □	091503 □
Homag	69,1	62	HSK 32	4	DP	2,0		12	091504 □	091505 □
Ott	69	61	16 DKN	3	DP	2,0		1	192649 ●	192650 ●
Ott	69	61	16 DKN	4	DP	2,0		1	192651 ●	192652 ●
SCM	55,3	49,33	16 DKN	3	DP	2,0		13	192701	
SCM	55,3	49,33	16 DKN	3	DP	2,0		13		192702
SCM	55,3	49,33	16 DKN	3	HW	2,0		13	182510 ●	182511 ●
SCM	55,7	48	16 DKN	3	HW	1,0		14	182512 ●	182513 ●
SCM	55,7	48	16 DKN	3	HW	1,5		14	182514 ●	182515 ●
SCM	55,7	48	16 DKN	3	HW	2,0		14	182516 ●	182517 ●
SCM	55,7	48	16 DKN	3	HW	3,0		14	182518 ●	182519 ●
SCM	65,82	63,88	HSK 25 R 4	4	HW	1,0		15	182526	182527
SCM	66,44	63,88	HSK 25 R 4	4	HW	1,5		15	182528	182529
SCM	67,09	63,88	HSK 25 R 4	4	HW	2,0		15	182530	182531
SCM	67,55	63,88	HSK 25 R 4	4	HW	2,5		15	182532	182533
SCM	68	63,88	HSK 25 R 4	4	HW	3,0		15	182534	182535
Stefani	70	60	16 DKN	4	DP	1,0		6	192524 □	192525 □
Stefani	70	60	16 DKN	4	DP	2,0		6	192526 □	192527 □
Stefani	70	60	16 DKN	4	DP	3,0		6	192528 □	192529 □
Stefani	51,5	49,71	16 DKN	4	HW	1,0		8	192657	192658
Stefani	51,5	49,71	16 DKN	4	HW	1,5		8	192659	192660
Stefani	51,5	49,71	16 DKN	4	HW	2,0		8	192661	192662
Törk Makine	46	39	16	4	DP	2,0		3	192643	192644

* For Brandt edge trimming cutter with keyed and torque support.

** = For Brandt edge trimming cutter with keyed (without torque support).



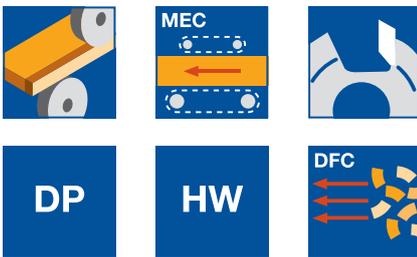
Profile cutter with optimised chip collection

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

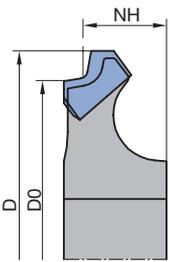
Technical information:
HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter. It is not recommended to resharpen the tool.



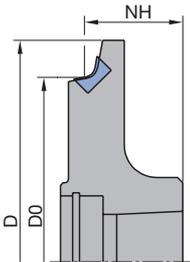
Various radii - optimised chip collection

WF 210 2 DP, WF 501 2, WF 501 2 DP

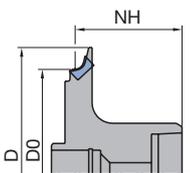
Machine	D	D ₀	NH	BO	Z	QAL	R	ID	ID
	mm	mm	mm	mm			mm	LH	RH
Homag	75	62	31,5	HSK 32	4	DP	1,0	198212 ●	198213 ●
Homag	75	62	31,5	HSK 32	4	DP	1,5	198214 □	198215 □
Homag	75	62	31,5	HSK 32	4	DP	2,0	198216 ●	198217 ●
Homag	75	62	31,5	HSK 32	4	DP	2,5	198220 □	198221 □
Homag	75	62	31,5	HSK 32	4	DP	3,0	198222	198223
Homag	75	62	31,5	HSK 32	6	DP	1,0	198246 □	198247 □
Homag	75	62	31,5	HSK 32	6	DP	1,5	198244 ●	198245 ●
Homag	75	62	31,5	HSK 32	6	DP	2,0	198218 □	198219 □
Homag	75	62	31,5	HSK 32	6	DP	3,0	198224	198225
Homag, IMA	76	70	17,5	HSK 25 R	4	DP	1,0	198494 ●	198484 ●
Homag, IMA	76	70	17,5	HSK 25 R	4	DP	1,5	198495 ●	198485 ●
Homag, IMA	76	70	18,5	HSK 25 R	4	DP	2,0	198496 ●	198486 ●
Homag, IMA	76	70	17,5	HSK 25 R	6	DP	1,0	198499 ●	198489 □
Homag, IMA	76	70	17,5	HSK 25 R	6	DP	1,5	198500 ●	198490 ●
Homag, IMA	76	70	18,5	HSK 25 R	6	DP	2,0	198501 ●	198491 ●
Homag, IMA	78	70	19	HSK 25 R	4	DP	2,5	198497 □	198487 □
Homag, IMA	78	70	19,5	HSK 25 R	4	DP	3,0	198498 ●	198488 ●
SCM	55,3	48	11,4	16 DKN	3	DP	1,0	192699	192700
SCM	55,3	48	11,4	16 DKN	3	HW	1,0	182502 ●	182503 ●
SCM	55,3	48	11,4	16 DKN	3	HW	1,5	182504 ●	182505 ●
SCM	55,3	48	11,4	16 DKN	3	DP	2,0	192697 ●	192698 ●
SCM	55,3	48	11,4	16 DKN	3	HW	2,0	182506 ●	182507 ●
SCM	55,3	48	11,4	16 DKN	3	HW	3,0	182508 ●	182509 ●
SCM	69,6	61,7	21,35	HSK 25 R	4	HW	1,0	182546	182547
SCM	69,6	61,7	21,35	HSK 25 R	4	HW	1,5	182548	182549
SCM	69,6	61,7	21,35	HSK 25 R	4	HW	2,0	182550	182551
SCM	69,6	61,7	21,35	HSK 25 R	4	HW	2,5	182554	182555
SCM	69,6	61,7	21,35	HSK 25 R	4	HW	3,0	182556	182557
SCM	69,9	62,3	22	HSK 25 R	4	DP	1,0	192709 □	192710 □
SCM	69,9	62,3	22	HSK 25 R	4	DP	1,5	192711 □	192712 □
SCM	69,9	62,3	22	HSK 25 R	4	DP	2,0	192713 □	192714 □
SCM	69,9	62,3	22	HSK 25 R	4	DP	2,5	192715 □	192716 □
SCM	69,9	62,3	22	HSK 25 R	4	DP	3,0	192717 □	192718 □



Radius cutter with cylindrical bore



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 adaptor for FK aggregates



Multi-profile cutter

Application:

For a choice of radii or bevels on edgebandings.

Machine:

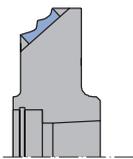
Single or double-sided edgebanding machines.

Workpiece material:

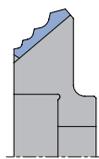
Plastic, softwood, hardwood and veneer edgebander.

Technical information:

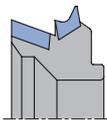
HW/DP tipped tools with cylindrical bore or HSK 25 R adaptor. Profiling with e.g. radii 2.0 and 3.0 mm and bevel 20°. D₀ = constant reference diameter. It is not recommended to resharpen the tool.



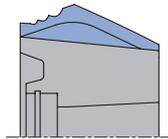
Type 1



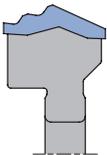
Type 2



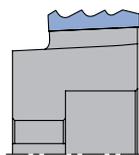
Type 3



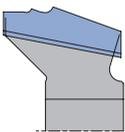
Type 4



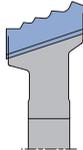
Type 5



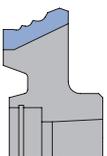
Type 6



Type 7



Type 8



Type 9

Multi-profile cutter

WF 210 2, WF 210 2 DP, WF 501 2, WF 501 2 DP, WF 501 2 DP, WF 502 2, WF 502 2 DP, WF 502 2 DP

Machine	D	D ₀	BO	Z	QAL	R	FAW	Type	ID	ID
	mm	mm	mm			mm	°	LH	RH	
Biesse	75,4	60	16 DKN	6	DP	1/2/3	25	2	091996	091995
Holz-Her	58	50	20 DKN	2	DP	2		3	192530	192531
Holz-Her	58	50	20 DKN	2	DP	2,5		3	192532	192533
Holz-Her	58	50	20 DKN	2	DP	3		3	192534	192535
Holz-Her	58	50	20 DKN	2	DP	2		3	192530	192531
Holz-Her	58	50	20 DKN	2	DP	2,5		3	192532	192533
Holz-Her	58	50	20 DKN	2	DP	3		3	192534	192535
Holz-Her	71	68	16 DKN	4	DP	3/2/1,3	45	6	192673	192674
Holz-Her	71	68	16 DKN	4	DP	1,3/1/0,8	45	6	192681	192682
Holz-Her	71	68	16 DKN	4	DP	3/2/1,3	10	6	192679	192680
Holz-Her	71	68	16 DKN	4	DP	2/1,3/1,3	45	6	192677	192678
Holz-Her	71	68	16 DKN	4	DP	2/2/1,3	45	6	192675	192676
Holz-Her	71	68	16 DKN	4	DP	3/2/2	45	6	192743	192744
Holz-Her	71	68	16 DKN	4	DP	2/1,3	45	6	192745	192746
Holz-Her	71,5	68	16 DKN	4	DP	2/1,3/2/1,3	6	6	192691	192692
Holz-Her	71,5	68	16 DKN	4	DP	2/1,3	31	6	192693	192694
Homag	74,33	65,7	HSK 25 R	4	DP	1/2		4	198506	198507
Homag	74,67	65,7	HSK 25 R	4	DP	1,3/2		4	198508	198509
Homag	74,33	62,99	16 DKN	4	DP	1/2		5	192683	192684
Homag	74,66	65,69	16 DKN	4	DP	1,3/2		5	192685	192686
SCM	74,5	63,9	HSK 25 R	4	HW	1/1,5/2		9	182538	182539
SCM	74,5	63,9	HSK 25 R	4	HW	1/1,5/3		9	182540	182541
SCM	74,5	63,9	HSK 25 R	4	HW	1/2/3		9	182542	182543
SCM	75,7	63,9	HSK 25 R	4	HW	1,5/2/3		9	182544	182545
SCM	75,7	63,9	HSK 25 R	4	HW	1/1,5/2,5		9	182558	182559
SCM	75,7	63,9	HSK 25 R	4	HW	2/2,5/3		9	182560	182561
SCM	62,03	49,44	16 DKN	4	HW	1/1,5		7	182522	182523
SCM	62,47	50,12	16 DKN	4	HW	1/2		7	182520	182521
SCM	73	60	16 DKN	4	HW	2/3		8	182501	182500
SCM	73	60	16 DKN	4	DP	2/3		8	192696	192695
SCM	77,4	63,1	16 DKN	4	HW	1/1,5/2		8	182524	182525
Stefani	74,5	63,88	HSK 25 R	4	DP	1/1,5/2	20	1	192653	192654
Stefani	74,5	63,88	HSK 25 R	4	DP	1/1,5/2	20	4	192655	192656

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.



Multi-profile cutter with optimised chip collection

Application:

For a choice of radii or bevels on edgebandings.

Machine:

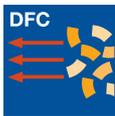
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

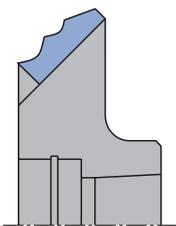
DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. It is not recommended to resharpen the tool.



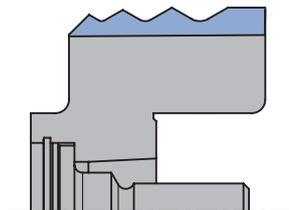
Multi-profile cutter - optimised chip collection

WF 501 2 DP, WF 502 2 DP

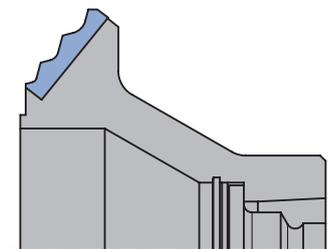
Machine	D	D ₀	B	BO	Z	QAL	R	FAW	Type	ID	ID
	mm	mm	mm	mm			mm	°		LH	RH
Homag, IMA 85	62			HSK 25 R 4 DP	2/3		20	1		198444 □	198445 □
Homag, IMA 85	62			HSK 25 R 4 DP	1,5/2		20	1		198504 ●	198505 ●
Homag, IMA 85	62			HSK 25 R 6 DP	2/3		20	1		198456 □	198457 □
IMA Multi-profiler	75		30	HSK 25 R 6 DP	1/2/3		15	2		091916 ●	091917 ●
IMA Multi-profiler	75		30	HSK 25 R 6 DP	1/1,5/2		20	2		091922 ●	091923 ●
IMA Multi-profiler KFA	75		28	HSK 25 R 6 DP	1/2/3		15	2		091912 □	091913 □
IMA Multi-profiler KFA	75		28	HSK 25 R 6 DP	1/1,5/2		20	2		091924 ●	091925 □
IMA Multi-profiler KFA	75		28	HSK 25 R 6 DP	1/2/3		45	2		091926 ●	091927 □
IMA MFA	89	62		HSK 25 R 6 DP	1/2		15	3		091918	091919
IMA MFA	89	57		HSK 25 R 6 DP	1/2/3		15	3		091920	091921



Type 1



Type 2



Type 3

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutterhead ProfilCut Q Diamond

Application:

For processing edgebandings.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Low tool life cost thanks to resharpenable exchangeable knives. Plug & play – no adjustment work required after service. Reusable tool body. Six tool lives per diamond knife.



Pre / finishing edge trimming cutter - ProfilCut Q Diamond

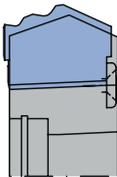
WE 500 2 54

Machine	D	SB	BO	Z	QAL	ID	ID
	mm	mm	mm			LH	RH
Homag, IMA	70	10	HSK 25 R	4	DP	198510	198511
Homag, IMA	70	10	HSK 25 R	6	DP	198512	198513

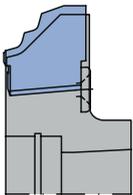
Profile cutter - ProfilCut Q Diamond

WE 500 2 54

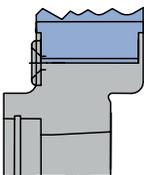
Machine	D	D ₀	NH	BO	Z	QAL	R	ID	ID
	mm	mm	mm	mm			mm	LH	RH
Homag, IMA	76	70	17,5	HSK 25 R	4	DP	1,0	198514	198515
Homag, IMA	76	70	17,5	HSK 25 R	4	DP	1,5	198516	198517
Homag, IMA	76	70	17,5	HSK 25 R	4	DP	2,0	198518	198519
Homag, IMA	76	70	17,5	HSK 25 R	6	DP	1,0	198520	198521
Homag, IMA	76	70	17,5	HSK 25 R	6	DP	1,5	198522	198523
Homag, IMA	76	70	17,5	HSK 25 R	6	DP	2,0	198524	198525



Type 1



Type 2



Type 3

Multi-profile cutter - ProfilCut Q Diamond

WE 500 2 54

Machine	D	B	BO	Z	QAL	R	FAW	Type	ID	ID
	mm	mm	mm			mm	°		LH	RH
Homag	74,33	24,3	HSK 25 R	4	DP	1/2		1	198526	198527
Homag, IMA	81,6	27	HSK 25 R	4	DP	1,5/2	20	2	198528	198529
IMA	75	30	HSK 25 R	6	DP	1/2/3	15	3	198530	198531
IMA	75	30	HSK 25 R	6	DP	1/1,5/2	20	3	198532	198533
IMA	75	28	HSK 25 R	6	DP	1/1,5/2	20	3	198534	198535
IMA	75	28	HSK 25 R	6	DP	1/2/3	45	3	198536	198537



Multi-profile cutter with optimised chip collection

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of three profiles for automatic profile resetting.

Machine:

Homag edgebanding machines with profile FK31 trimming aggregate.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Three profiles in one tool. DFC design for highly efficient chip clearance of more than 97%. D_0 = constant reference diameter. Low noise DP tool. Maximum concentricity. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.

Diamaster PRO, FK31 aggregate

WF 501 2 DP

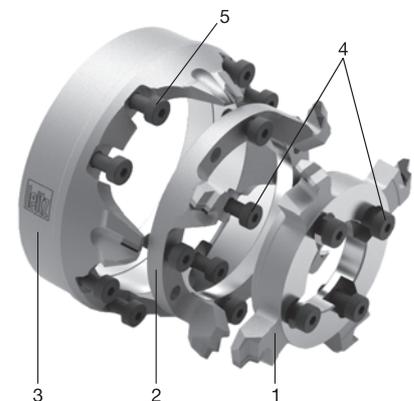
Machine	Tool no.	D mm	D_0 mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID RH
Homag	1	88	80,1	46	4	DP	1,5		192558 □	192559 □
Homag	1	88	80,1	46	4	DP	2,0		192556 ●	192557 ●
Homag	1	88	80,1	46	4	DP	2,5		192554 □	192555 □
Homag	1	88	80,1	46	4	DP	3,0		192552 □	192553 □
Homag	2	87	80,1	55	4	DP	1,0		192568 ●	192569 □
Homag	2	87	80,1	55	4	DP	1,5		192566 □	192567 □
Homag	2	87	80,1	55	4	DP	2,0		192564 □	192565 □
Homag	3	92	80,1	73	4	DP	1,0		192574 □	192575 ●
Homag	3	92	80,1	73	4	DP	1,5		192572 □	192573 □
Homag	3	92	80,1	73	4	DP	2,0		192570 □	192571 □
Homag	3	92	80,1	73	4	DP		20		192119
Homag	3	92	80,1	73	4	DP		45	192116 ●	192117 ●

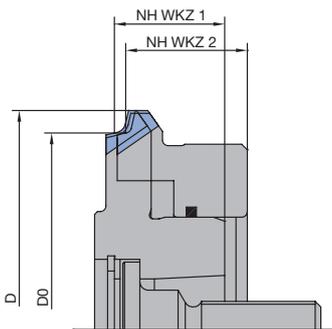
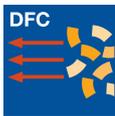
Differing radii available at short notice from a tool bank. Tool 1 radius must be greater than tool 2 and 3. The larger radius defines the maximal bevel size of the moveable bevel tools 2 and 3.

Spare parts:

Part-no.	BEZ	ABM mm	ID
4	Cylindrical screw with ISK	M5x12	114046 ●
5	Cylindrical screw with ISK	M5x30	114045 ●

Tools supplied with mounting screws.





Profile cutter flexTrim

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of two profiles for automatic profile resetting in the workpiece gap.

Machine:

Homag edgebanding machines with cutting unit type FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Two profiles in one tool. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, $RPM n_{max} = 18000 \text{ min}^{-1}$. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to resharpen the tool.

Multi-profile cutterset flexTrim - Diamaster PRO

SF 542 2 15

Machine	D	D ₀	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	19,5	HSK 25 R 4	DP	1,5/1,0			194300 □	194301 □
Homag	78	70	19,5	HSK 25 R 4	DP	2,0/1,0			194302 ●	194303 ●
Homag	78	70	19,5	HSK 25 R 4	DP	2,0/1,5			194304 □	194305 □
Homag	78	70	19,5	HSK 25 R 4	DP	3,0/2,0			194306 □	194307 □
Homag	78	70	19,5	HSK 25 R 4	DP	2,0	20		194308 □	194309 □
Homag	78	70	19,5	HSK 25 R 4	DP	2,0	45		194310 ●	194311 ●

Tool 1 fix + tool 2 flexible

All tools and further profile variants available in various dimensions from blank at short notice. Further combinations possible on request.

Spare parts:

Part-no.	Tool no.	BEZ	ABM	ID
			mm	
3	2	O-Ring	40x1.78 NBR70	118300 ●



- 1 = Tool 1
- 2 = Tool 2
- 3 = O-Ring



Profile cutter flexTrim

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of two profiles for automatic profile resetting.

Machine:

Homag edgebanding machines with cutting unit type FF6210.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, $RPM n_{max} = 12000 \text{ min}^{-1}$. It is not possible to sharpen the tool.

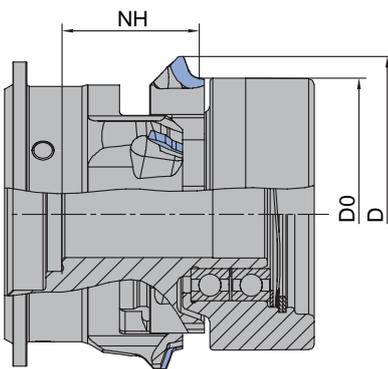


Multi-profile cutterset flexTrim - Diamaster PRO, aggregate FF6210

SF 542 2 18, WF 501 2 18

Machine	D mm	D_0 mm	NH mm	BO mm	Z	QAL	R mm	FAW °	ID RH
Homag	58	50	25	16	3	DP	3,0/1,0		194700 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	3,0/1,3		194701 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	3,0/2,0		194702 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	2,0/1,0		194703 ●
Homag	58	50	25	16	3	DP	2,0/1,3		194704 ●
Homag	58	50	25	16	3	DP	2,0/1,5		194705 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	2,0	45	194706 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	1,5/1,5		194707 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	3,0		194724 ●
Homag	58	50	25	16	3	DP	2,0		194725 ●
Homag	58	50	25	16	3	DP	1,5		194726 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	1,3		194727 <input type="checkbox"/>
Homag	58	50	25	16	3	DP	1,0		194728 ●
Homag	58	50	25	16	3	DP		45	194729 <input type="checkbox"/>
Homag	58	50	25	16	3	DP		30	194730 <input type="checkbox"/>
Homag	58	50	25	16	3	DP		15	194731 <input type="checkbox"/>

Further profile variants and combinations possible on request.





Profile cutter flexTrim

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of two profiles for automatic profile resetting.

Machine:

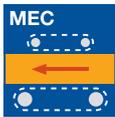
Homag edgebanding machines with cutting unit type MF50, MF60.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, $RPM n_{max} = 12000 \text{ min}^{-1}$. It is not possible to sharpen the tool.

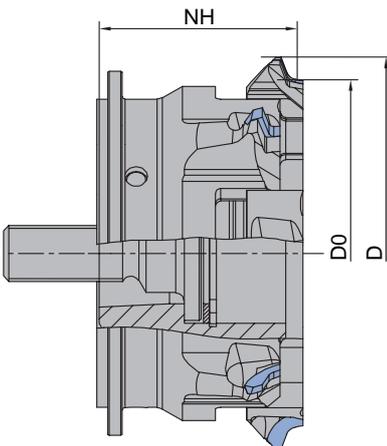


Multi-profile cutterset flexTrim - Diamaster PRO, aggregate MF50, MF60

SF 542 2 18, WF 501 2 18

Machine	D	D ₀	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	70	62	35	HSK 25 R	4	DP	3,0/1,0		194708 ●	194709 ●
Homag	70	62	35	HSK 25 R	4	DP	3,0/1,3		194710 ●	194711 ●
Homag	70	62	35	HSK 25 R	4	DP	3,0/2,0		194712 □	194713 □
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,0		194714 ●	194715 ●
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,3		194716 ●	194717 ●
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,5		194718 □	194719 □
Homag	70	62	35	HSK 25 R	4	DP	2,0	45	194720 □	194721 □
Homag	70	62	35	HSK 25 R	4	DP	1,5/1,5		194722 □	194723 □
Homag	70	62	35	HSK 25 R	4	DP	1,3/1,0		194732 □	194733 □
Homag	70	62	35	HSK 25 R	4	DP	3,0		194740 □	194741 □
Homag	70	62	35	HSK 25 R	4	DP	2,0		194742 ●	194743 ●
Homag	70	62	35	HSK 25 R	4	DP	1,5		194744 □	194745 □
Homag	70	62	35	HSK 25 R	4	DP	1,3		194746 □	194747 □
Homag	70	62	35	HSK 25 R	4	DP	1,0		194748 □	194749 □
Homag	70	62	35	HSK 25 R	4	DP		45	194750 □	194751 □
Homag	70	62	35	HSK 25 R	4	DP		30	194752 □	194753 □
Homag	70	62	35	HSK 25 R	4	DP		15	194754 □	194755 □

Further profile variants and combinations possible on request.





Profile cutter flexTrim3

Application:

For multi-profile cutting with radii on edges. Combination of three profiles for automatic profile resetting.

Machine:

Homag edgebanding machines with cutting unit type FF32 with flexTrim cutting head.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

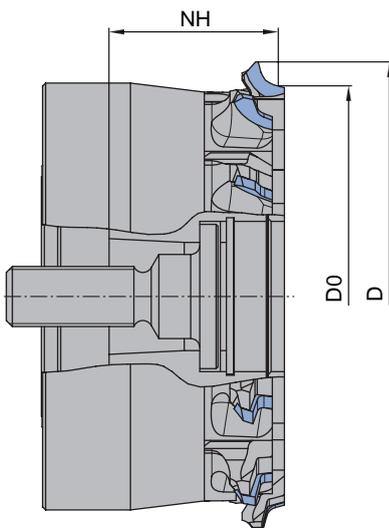
Technical information:

Three profiles in one tool. Maximum processing quality through high running accuracy and quiet running. D_0 = constant reference diameter, $RPM n_{max} = 12.000 \text{ min}^{-1}$. Replacement of tool components only by qualified personnel of the tool or machine manufacturer. It is not possible to sharpen the tool.

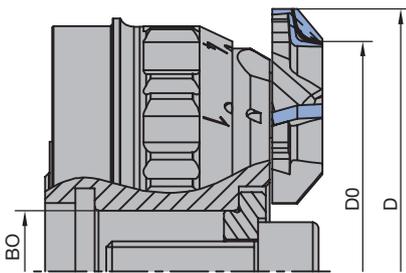
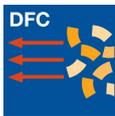
Multi-profile cutterset flexTrim3 - Diamaster PRO

SF 541 2 17

Machine	D	D_0	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	28	HSK 25 R	4	DP	2/1,5/1		194500 □	194501 □
Homag	78	70	28	HSK 25 R	4	DP	2/1,3/1		194502 □	194503 □
Homag	78	70	28	HSK 25 R	4	DP	2/1	45	194514 □	194515 □
Homag	78	70	28	HSK 25 R	4	DP	2/1,3	45	194518 □	194519 □



Further profile variants and combinations possible on request. Single tools available on request.



Profile cutter Quattro^{Form}

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of four profiles for automatic profile resetting.

Machine:

Holz-Her model Lumina and Accura 2015 and newer models. Application on revolver cutting unit Quattro Form (FF 701 Multi).

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

DP composite tool with four profiles and mounting screw. Profiles automatically adjustable by the machine control. Patented system. D_0 = constant reference diameter, $RPM\ n = 18000\ min^{-1}$. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to sharpen the tool.

Multi-profile cutter Quattro^{Form} - Diamaster PRO

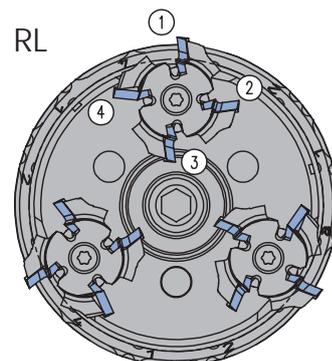
SF 540 2 10

Machine	D mm	D ₀ mm	BO mm	Z	R	FAW °	ID	
							LH	RH
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/2	45	193901 ●	193900 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1,3/2	45	193903 □	193902 □
Holz-Her FF 701 Multi	70	61	16	3	3/1,3/2	10	193905 □	193904 □
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/1,3	45	193907 ●	193906 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,5/1	45	193909 □	193908 □
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/2/1,3		193917 ●	193916 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/1,3/1,3		193921 □	193920 □

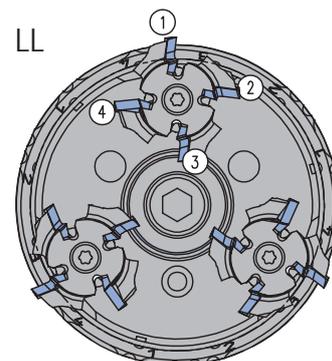
All tools and further profile variants are available in various dimensions from blanks at short notice. Profile radius maximum 3 mm.

Spare parts:

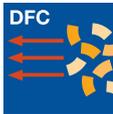
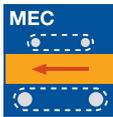
BEZ	ID
Maintenance set Quattro Form	008383 ●



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	193900	5073458
R3	R1.3	R2	F45°	193902	5073461
R3	R1.3	R2	F10°	193904	5073463
R2	R1.3	R1.3	F45°	193906	5073466
R2	R1.5	R1	F45°	193908	5073468
R2	R1.3	R2	R1.3	193916	5073449
R2	R1.3	R1.3	R1.3	193920	5073456



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	193901	5073457
R3	R1.3	R2	F45°	193903	5073459
R3	R1.3	R2	F10°	193905	5073462
R2	R1.3	R1.3	F45°	193907	5073465
R2	R1.5	R1	F45°	193909	5073467
R2	R1.3	R2	R1.3	193917	5073447
R2	R1.3	R1.3	R1.3	193921	5073454



Profile cutter Multi-Edge

Application:

For multi-profile cutting with radii of edges. Combination of three profiles for automatic profile resetting.

Machine:

Stefani.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Three profiles in one tool. DFC design for efficient chip collection.

Maximum processing quality through high running accuracy and smooth running.

D_0 = constant reference diameter, RPM $n_{max} = 18000 \text{ min}^{-1}$. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service. It is not possible to resharpen the tool.

Diamaster PRO

WF 501 2 16

Machine	Tool no.	D mm	D_0 mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID RH
Stefani	1	68	61,7	10 DKN	4	DP	1,0		192606 □	192605 □
Stefani	1	68	61,7	10 DKN	4	DP	1,5		192610 ●	192609 ●
Stefani	1	68	61,7	10 DKN	4	DP	2,0		192612 ●	192611 ●
Stefani	1	68	61,7	10 DKN	4	DP	2,5		192614 □	192613 □
Stefani	1	68	61,7	10 DKN	4	DP	3,0		192616 ●	192615 ●
Stefani	2	68	61,7	23	4	DP	1,0		192618 ●	192617 ●
Stefani	2	68	61,7	23	4	DP	1,5		192622 ●	192621 ●
Stefani	2	68	61,7	23	4	DP	2,0		192624 □	192623 □
Stefani	3	68	61,5	38	4	DP	1,0		192672 □	192671 □
Stefani	3	68	61,7	38	4	DP	1,0		192629 □	192630 □
Stefani	3	68	61,7	38	4	DP	2,0		192636 □	192635 □
Stefani	3	68	61,7	38	4	DP		45	192730 □	192729 □

Further profile variants in various dimensions available on request at short notice.



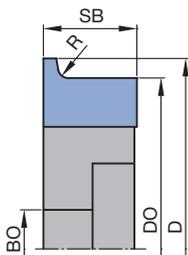
Profile cutterhead / bevel cutterhead

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

Technical information:
Cutterheads with HW knives and cylindrical bore with DKN. One cutterhead basic body for R 1.5 to 3.0 mm. D_0 = constant reference diameter.



Various radii - Hebrock/EBM

WE 500 2

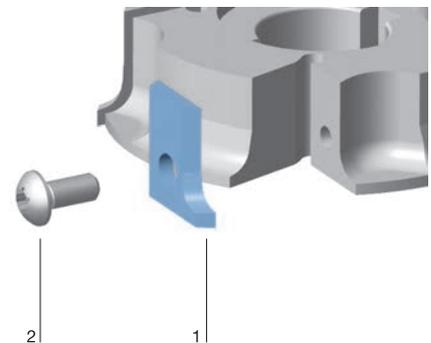
Machine	D mm	D_0 mm	SB mm	BO mm	Z	R mm	ID LH	ID RH
Hebrock, EBM	56	49,7	14,5	16 DKN	4	2,0	074559	074560
Hebrock, EBM	56	49,7	14,5	16 DKN	4	2,5	074557	074558

Spare knives:

Part-no.	Type	BEZ	ABM mm	QAL	R	VE PCS	ID LH	ID RH
1	1	Combi exchange knife	14.5x14.5x2	HW	2,0	2	074632 ●	074633 ●
1	1	Combi exchange knife	14.5x14.5x2	HW	2,5	2	074630 ●	074631 ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Screw	M3.5x8	005723 ●





Profile cutterhead / bevel cutterhead

Application:

To round and bevel edgebandings.

Machine:

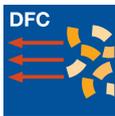
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

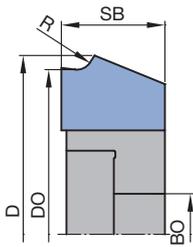
Cutterheads with HW knives and cylindrical bore with DKN. D_0 = constant reference diameter. DFC design for highly efficient chip clearance of more than 97%.



Various profiles - DFC, Brandt, Homag

WE 500 2

Machine	D	SB	BO	Z	R	FAW	ID	ID
	mm	mm	mm		mm	°	LH	RH
Brandt, Homag	69,98	20,28	16 DKN	4		45	075016 □	075017 □
Brandt, Homag	70,57	20,28	16 DKN	4	1,0		075018 ●	075019 ●
Brandt, Homag	70,57	20,28	16 DKN	4	1,3		075072 ●	075073 ●
Brandt, Homag	70,57	20,28	16 DKN	4	1,5		075022 □	075023 □
Brandt, Homag	70,57	20,28	16 DKN	4	2,0		075024 ●	075025 ●
Brandt, Homag	70,57	20,28	16 DKN	4	3,0		075028 ●	075029 ●

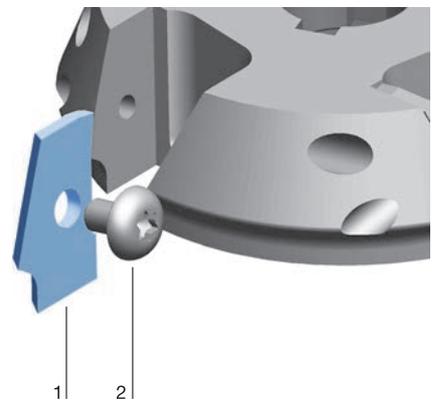


Spare knives:

Part- no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	22,3x14x2	HW	1,0		2	075315 ●	075314 ●
1	1	Exchange knife	22,3x14x2	HW	1,2		2	075317 □	075316 □
1	1	Exchange knife	22,3x14x2	HW	1,3		2	075272 ●	075271 ●
1	1	Exchange knife	22,3x14x2	HW	1,5		2	075319 ●	075318 ●
1	1	Exchange knife	22,3x14x2	HW	2,0		2	075307 ●	075306 ●
1	1	Exchange knife	22,3x14x2	HW	3,0		2	075309 ●	075308 ●
1	1	Exchange knife	22,3x14x2	HW		15	2	075311 ●	075310 ●
1	1	Exchange knife	22,3x14x2	HW		30	2	075331 □	075332 □
1	1	Exchange knife	22,3x14x2	HW		45	2	075313 ●	075312 ●

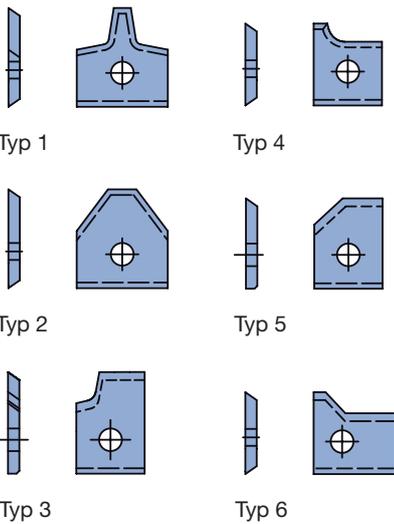
Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Oval head screw Torx® 15	M4x6	006225 ●
	Torx® key	Torx® 15	117507 ●



2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutterhead / bevel cutterhead

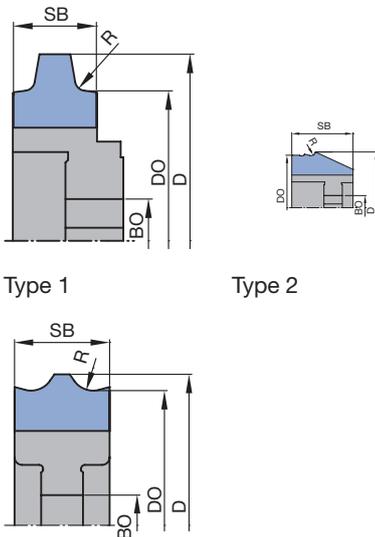
Profile knives for edge finishing

TM 135 0

SB	H	DIK	QAL	Knife	R	FAW	VE	ID	ID
mm	mm	mm			mm	°	PCS	LH	RH
16	17,5	2	HW	1	2,0		2	005132 ●	005132 ●
16	17,5	2	HW	1	3,0		2	005133 ●	005133 ●
16	17,5	2	HW	1	4,0		2	005134 ●	005134 ●
16	17,5	2	HW	1	5,0		2	005135 ●	005135 ●
16	17,5	2	HW	2		45	2		009525 ●
12	17	2	HW	3	2,0		2	073554 ●	073555 ●
12	18	2	HW	3	2,0		2	074033 □	074034 □
12	17	2	HW	3	3,0		2	073558 ●	073559 ●
12	18	2	HW	3	3,0		2	074035 □	074036 □
13	15	2	HW	3	2,0		2	073505 ●	073504 ●
13	15	2	HW	3	3,0		2	073509 ●	073508 ●
12	14,5	2	HW	4	2,0		2	075342 ●	075341 ●
14,5	14,5	2	HW	4	2,5		2		073544 ●
12	14,5	2	HW	4	3,0		2	075301 □	075300 □
12	16	2	HW	5		45	2	073541 ●	073540 ●

Profile knives for system Biesse

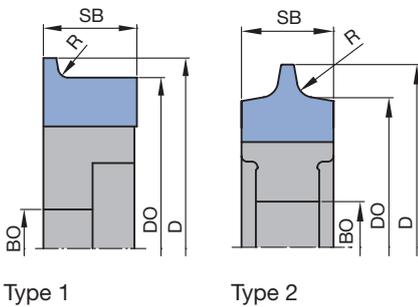
TM 135 0



Type	BEZ	ABM	QAL	R	VE	ID	ID
		mm		mm	PCS	LH	RH
1	Exchange knife	16x17x2	HW	1,0	2	074600 □	074600 □
1	Exchange knife	16x17x2	HW	1,5	2	074601 □	074601 □
1	Exchange knife	16x17x2	HW	2,0	2	074602 ●	074602 ●
1	Exchange knife	16x17x2	HW	2,5	2	074603 □	074603 □
1	Exchange knife	16x17x2	HW	3,0	2	074604 □	074604 □
2	Exchange knife	40x17x2	HW	1,0	2	074610 □	074611 □
2	Exchange knife	40x17x2	HW	1,5	2	074612 □	074613 □
2	Exchange knife	40x17x2	HW	2,0	2	074614 ●	074615 ●
2	Exchange knife	40x17x2	HW	2,5	2	074616 □	074617 □
2	Exchange knife	40x17x2	HW	3,0	2	074618 □	074619 □
3	Exchange knife	20x16x2	HW	1,0	2	074620 □	074620 □
3	Exchange knife	20x16x2	HW	1,5	2	074621 □	074621 □
3	Exchange knife	20x16x2	HW	2,0	2	074622 □	074622 □
3	Exchange knife	20x16x2	HW	2,5	2	074623 □	074623 □
3	Exchange knife	20x16x2	HW	3,0	2	074624 □	074624 □

Profile knives for system Brandt, Homag

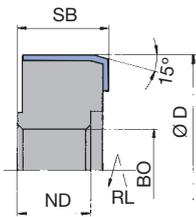
TM 135 0



Type	BEZ	ABM	QAL	R	VE	ID	ID
		mm		mm	PCS	LH	RH
2	Exchange knife	12x13x2	HW	1,5	2	075339 □	075339 □
1	Exchange knife	19,6x15,2x2	HW	2,5	2	075338 □	075337 □
1	Exchange knife	19,6x15,2x2	HW	2,0	2	075336 ●	075335 ●
1	Exchange knife	19,6x15,2x2	HW	1,5	2	075334 ●	075333 ●
2	Exchange knife	12x13x2	HW	2,0	2	075330 ●	075330 ●
1	Exchange knife	16x13,4x2	HW	3,0	2	075329 □	075328 □
1	Exchange knife	16x13,4x2	HW	2,0	2	075327 □	075326 □
1	Exchange knife	16x13,4x2	HW	1,5	2	075325 □	075324 □
2	Exchange knife	12x13x2	HW	3,0	2	075304 ●	075304 ●
1	Exchange knife	19,6x15,2x2	HW	3,0	2	075303 ●	075302 ●

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools

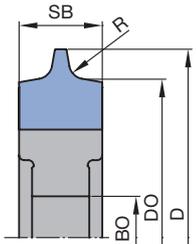


Type 4: WW 500 2 03

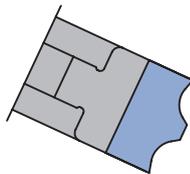
Profile knives for system Holz-Her

TM 435 0

BEZ	ABM mm	QAL	VE PCS	DRI	ID
Turnblade knife	30x12x1,5,PT1,3	HW	2	RH	005088 ●
Turnblade knife	30x12x1,5,PT1,3	HW	2	LH	005089 ●



Type 1

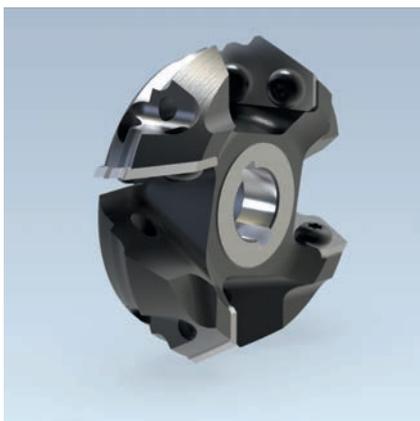


Type 2

Profile knives for system Ott

TM 135 0

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x17,5x2	HW	1,0	2	074540 □	074540 □
2	Exchange knife	16x17,5x2	HW	1,5	2	009539 ●	009539 ●
1	Exchange knife	16x17,5x2	HW	2,0	2	005132 ●	005132 ●
1	Exchange knife	16x18,5x2	HW	2,5	2	074543 □	074543 □
2	Exchange knife	16x17,5x2	HW	3,0	2	005133 ●	005133 ●
1	Exchange knife	16x19,5x2	HW	3,5	2	074545 □	074545 □
2	Exchange knife	25x15x2	HW	1,0	3	619194	619194
2	Exchange knife	25x15x2	HW	2,0	3	619196 ●	619196 ●



Multi-profile cutterhead / bevel cutterhead

Application:

For a choice of radii or bevels on edgebandings.

Machine:

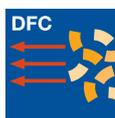
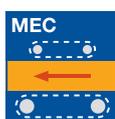
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

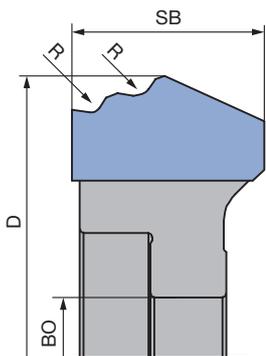
Cutterheads with HW knives and cylindrical bore with DKN. D_0 = constant reference diameter. DFC design for highly efficient chip clearance of more than 97%. Various radii bevel combinations available.



Various profiles - DFC, Homag

WE 500 2

Machine	D mm	SB mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Homag	74,67	25,28	16 DKN	4	1/2		075092 ●	075093 ●
Homag	74,67	25,28	16 DKN	4	1,3/2		075100 ●	075101 ●
Homag	74,67	25,28	16 DKN	4	1/3		075094 ●	075095 ●
Homag	74,67	25,28	16 DKN	4	2/3		075112 □	075113 □
Homag	74,67	25,28	16 DKN	4	1/1,5		075090 ●	075091 ●
Homag	74,67	25,28	16 DKN	4	1,5/2		075106 □	075107 □
Homag	74,67	25,28	16 DKN	4	1,5/3		075108 □	075109 □
Homag	74,67	25,28	16 DKN	4	1	15	075114 □	075115 □
Homag	74,67	25,28	16 DKN	4	1,3/3		075102 □	075103 □
Homag	74,67	25,28	16 DKN	4	2	30	075130 □	075131 □
Homag	74,67	25,28	16 DKN	4	2	15	075120 □	075121 □
Homag	74,67	25,28	16 DKN	4	1/1,3		075088 □	075089 □
Homag	74,67	25,28	16 DKN	4	2	45	075140 □	075141 □
Homag	74,67	25,28	16 DKN	4	1	45	075134 □	075135 □
Homag	74,67	25,28	16 DKN	4	1,3	45	075136 □	075137 □
Homag	74,67	25,28	16 DKN	4	1,5	45	075138 □	075139 □
Homag	74,67	25,28	16 DKN	4	1,5	30	075128 □	075129 □
Homag	74,67	25,28	16 DKN	4	2/2		075110 □	075111 □
Homag	74,67	25,28	16 DKN	4	1,3/1,3		075096 □	075097 □
Homag	74,67	25,28	16 DKN	4	1,5/1,5		075104 □	075105 □
Homag	74,67	25,28	16 DKN	4	1	30	075124 □	075125 □
Homag	74,67	25,28	16 DKN	4	1,3/1,5		075098 □	075099 □
Homag	74,67	25,28	16 DKN	4	1,3	30	075126 □	075127 □
Homag	74,67	25,28	16 DKN	4	3	30	075132 □	075133 □
Homag	74,67	25,28	16 DKN	4	3	45	075142 □	075143 □
Homag	74,67	25,28	16 DKN	4	1/1		075086 □	075087 □



Further radii combinations available at short notice.

Spare knives:

Part- no.	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	25.67x16.5x2	HW	1/2		2	075706 ●	075707 ●
1	Exchange knife	25.67x16.5x2	HW	1,3/2		2	075714 ●	075715 ●
1	Exchange knife	25.67x16.5x2	HW	1/3		2	075708 ●	075709 ●
1	Exchange knife	25.67x16.5x2	HW	2/3		2	075726 □	075727 □
1	Exchange knife	25.67x16.5x2	HW	1/1,5		2	075704 ●	075705 ●
1	Exchange knife	25.67x16.5x2	HW	1,5/2		2	075720 □	075721 □
1	Exchange knife	25.67x16.5x2	HW	1,5/3		2	075722 □	075723 □
1	Exchange knife	25.67x16.5x2	HW	1	15	2	075728 □	075729 □
1	Exchange knife	25.67x16.5x2	HW	1,3/3		2	075716 ●	075717 ●
1	Exchange knife	25.67x16.5x2	HW	2	30	2	075744 □	075745 □
1	Exchange knife	25.67x16.5x2	HW	2	15	2	075734 □	075735 □
1	Exchange knife	25.67x16.5x2	HW	1/1,3		2	075702 ●	075703 ●
1	Exchange knife	25.67x16.5x2	HW	2	45	2	075754 ●	075755 ●
1	Exchange knife	25.67x16.5x2	HW	1	45	2	075748 ●	075749 □
1	Exchange knife	25.67x16.5x2	HW	1,3	45	2	075750 □	075751 □
1	Exchange knife	25.67x16.5x2	HW	1,5	45	2	075752 □	075753 □
1	Exchange knife	25.67x16.5x2	HW	1,5	30	2	075742 □	075743 □
1	Exchange knife	25.67x16.5x2	HW	2/2		2	075724 ●	075725 ●

2. Panel processing

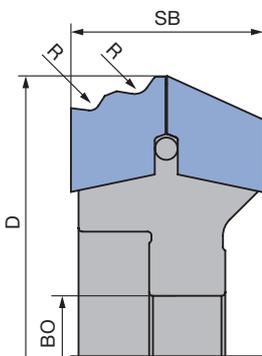
2.1 Edge processing 2.1.7 Edge finishing tools

Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	25.67x16.5x2	HW	1,3/1,3		2	075710 □	075711 □
1	Exchange knife	25.67x16.5x2	HW	1,5/1,5		2	075718 □	075719 □
1	Exchange knife	25.67x16.5x2	HW	1	30	2	075738 □	075739 □
1	Exchange knife	25.67x16.5x2	HW	1,3/1,5		2	075712 □	075713 □
1	Exchange knife	25.67x16.5x2	HW	1.3	30	2	075740 □	075741 □
1	Exchange knife	25.67x16.5x2	HW	3	30	2	075746 □	075747 □
1	Exchange knife	25.67x16.5x2	HW	3	45	2	075756 □	075757 □
1	Exchange knife	25.67x16.5x2	HW	1/1		2	075700 □	075701 □

Further radii combinations available at short notice.

Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Oval head screw Torx® 15	M4x6	006225 ●
	Torx® key	Torx® 15	005466 ●



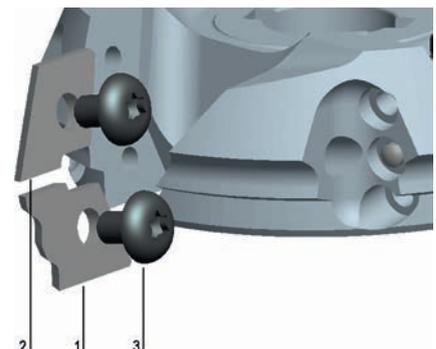
Spare knives - two-part knife design (until 03/2023)

TM 135 0

Type	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	17,9x14,2x2	HW	1/1,5		2	075365 ●	075366 ●
1	Exchange knife	17,9x14,2x2	HW	1/2		2	075347 ●	075348 ●
1	Exchange knife	17,9x14,2x2	HW	1/3		2	075351 ●	075352 ●
1	Exchange knife	17,9x14,2x2	HW	1,3/2		2	075349 ●	075350 ●
1	Exchange knife	17,9x14,2x2	HW	1,3/3		2	075373 ●	075374 ●
1	Exchange knife	17,9x14,2x2	HW	1,5/2		2	075367 ●	075368 ●
1	Exchange knife	17,9x14,2x2	HW	1,5/3		2	075369 □	075370 □
1	Exchange knife	17,9x14,2x2	HW	2/3		2	075353 ●	075354 ●
1	Exchange knife	17,9x14,2x2	HW	1	15	2	075371 □	075372 □
1	Exchange knife	17,9x14,2x2	HW	2	30	2	075201 □	075202 □
2	Exchange knife	18,1x13,5x2	HW			2	075355 ●	075356 ●

Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Oval head screw Torx® 15	M4x6	006225 ●
	Torx® key	Torx® 15	005466 ●





Profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic edgebandings.

Technical information:

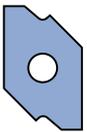
Bevel and radius scraper for scraper holder.

Profile scrapers

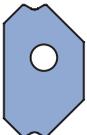
TM 130 0, TM 435 0



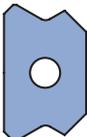
Type 1



Type 3



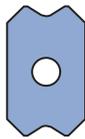
Type 5



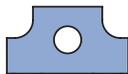
Type 7



Type 2



Type 4



Type 6



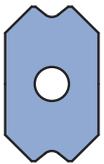
Type 8

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	12,7	12,7	3,18	1,0		1	HW	2	074548	●
Biesse	12,7	12,7	3,18	1,5		1	HW	2	074549	●
Biesse	12,7	12,7	3,18	2,0		1	HW	2	074550	●
Biesse	12,7	12,7	3,18	3,0		1	HW	2	074551	□
Fravol	12	20	2	1-3		2	TDC	2	074640	● 074639 ●
Holz-Her	12	20	2		45	4	HW	2	074037	●
Holz-Her	12	20	2	1,0		4	HW	2	074039	●
Holz-Her	12	20	2	1,5		4	HW	2	074074	●
Holz-Her	12	20	2	2,0		4	HW	2	074040	●
Holz-Her	12	20	2	2,5		4	HW	2	074075	□
Holz-Her	12	20	2	3,0		4	HW	2	074041	●
Holz-Her ZK701	12	19	2		10	3	HW	2	074576	□ 074575 □
Holz-Her ZK701	12	19	2	1,0		3	HW	2	074562	□ 074561 □
Holz-Her ZK701	12	19	2	1,3		3	HW	2	074564	□ 074563 □
Holz-Her ZK701	12	19	2	2,0		3	HW	2	074568	□ 074567 □
Holz-Her ZK701	12	19	2	3,0		3	HW	2	074572	□ 074571 □
Homag	12	20	2		45	4	HW	2	074037	●
Homag	12	20	2	1,0		4	HW	2	074039	●
Homag	12	20	2	1,5		4	HW	2	074074	●
Homag	12	20	2	2,0		4	HW	2	074040	●
Homag	12	20	2	2,5		4	HW	2	074075	□
Homag	12	20	2	3,0		4	HW	2	074041	●
Homag	12	20	2		45	5	HW	2	073724	□
Homag	12	20	2	1,0		5	HW	2	073725	●
Homag	12	20	2	1,5		5	HW	2	073726	●
Homag	12	20	2	2,0		5	HW	2	073727	●
Homag	12	20	2	2,5		5	HW	2	073728	□
Homag	12	20	2	3,0		5	HW	2	073729	●
Homag	20	11,5	2	1,0		6	HW	2	073713	●
Homag	20	11,5	2	1,5		6	HW	2	073714	□
Homag	20	11,5	2	2,0		6	HW	2	073715	●
Homag	20	11,5	2	3,0		6	HW	2	073716	□
IMA	12	20	2		45	4	HW	2	074037	●
IMA	12	20	2	1,0		7	HW	2	074044	●
IMA	12	20	2	1,5		7	HW	2	074076	●
IMA	12	20	2	2,0		7	HW	2	074021	●
IMA	12	20	2	2,5		7	HW	2	074077	□
IMA	12	20	2	3,0		7	HW	2	074022	●
Ott	12	13,3	3,3	1,0		8	HW	2	074653	●
Ott	12	13,3	3,3	2,0		8	HW	2	074654	●
SCM	12	20	2	2,0		4	HW	2	074040	●
Stefani	12,7	12,7	3,18	1,0		1	HW	2	074548	●
Stefani	12,7	12,7	3,18	1,5		1	HW	2	074549	●
Stefani	12,7	12,7	3,18	2,0		1	HW	2	074550	●
Stefani	12,7	12,7	3,18	3,0		1	HW	2	074551	□

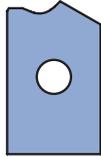
Additional scrapers available on request at short notice.

2. Panel processing

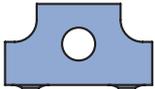
2.1 Edge processing 2.1.7 Edge finishing tools



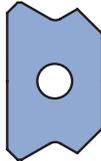
Type 1



Type 2



Type 3



Type 4

Technical information:

Prevention of stress-whitening and rework through special cutting geometry and quality. Scraper turnblades with different radii for adaption in scraper holder.

Profile scrapers with anti-stress whitening bevel

TM 435 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Brandt	12	20	2		45	1	HW	2	074103	□
Brandt	12	20	2	1,0		1	HW	2	074095	●
Brandt	12	20	2	1,3		1	HW	2	074096	●
Brandt	12	20	2	1,5		1	HW	2	074097	●
Brandt	12	20	2	2,0		1	HW	2	074098	●
Brandt	12	20	2	3,0		1	HW	2	074100	□
EBM	12	20	2		45	1	HW	2	074103	□
EBM	12	20	2	1,0		1	HW	2	074095	●
EBM	12	20	2	1,3		1	HW	2	074096	●
EBM	12	20	2	1,5		1	HW	2	074097	●
EBM	12	20	2	2,0		1	HW	2	074098	●
EBM	12	20	2	3,0		1	HW	2	074100	□
Fravol	15,44	20	2	1-3		2	TDC	2	074642	● 074641 ●
Hebrock	12	20	2	1,0		1	HW	2	074095	●
Hebrock	12	20	2	1,3		1	HW	2	074096	●
Hebrock	12	20	2	1,5		1	HW	2	074097	●
Hebrock	12	20	2	2,0		1	HW	2	074098	●
Hebrock	12	20	2	3,0		1	HW	2	074100	□
Holz-Her	12	20	2		45	1	HW	2	074103	□
Holz-Her	12	20	2	1,0		1	HW	2	074095	●
Holz-Her	12	20	2	1,3		1	HW	2	074096	●
Holz-Her	12	20	2	1,5		1	HW	2	074097	●
Holz-Her	12	20	2	2,0		1	HW	2	074098	●
Holz-Her	12	20	2	3,0		1	HW	2	074100	□
Homag	12	20	2		45	1	HW	2	074103	□
Homag	12	20	2	1,0		1	HW	2	074095	●
Homag	12	20	2	1,3		1	HW	2	074096	●
Homag	12	20	2	1,5		1	HW	2	074097	●
Homag	12	20	2	2,0		1	HW	2	074098	●
Homag	12	20	2	3,0		1	HW	2	074100	□
Homag	20	11,5	2	1,0		3	HW	2	073719	□
Homag	20	11,5	2	1,5		3	HW	2	073720	□
Homag	20	11,5	2	2,0		3	HW	2	073721	●
Homag	20	11,5	2	3,0		3	HW	2	073723	●
IMA	12	20	2		45	1	HW	2	074103	□
IMA	12	20	2	1,0		4	HW	2	074090	●
IMA	12	20	2	1,3		4	HW	2	074101	□
IMA	12	20	2	1,5		4	HW	2	074091	●
IMA	12	20	2	2,0		4	HW	2	074092	●
IMA	12	20	2	3,0		4	HW	2	074094	□

Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	005466 ●
Oval head screw Torx® 15	M4x6	006225 ●



Multi-profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

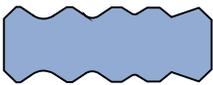
Single or double-sided edgebanding machines.

Workpiece material:

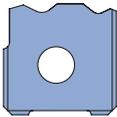
Plastic edgebandings.

Technical information:

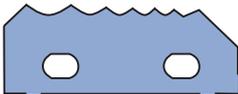
Multi-profile scraper with a choice of bevels and radii.



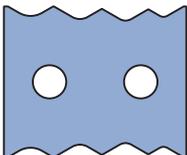
Type 1



Type 2



Type 3



Type 4

Multi-profile scrapers

TM 135 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	34	12,7	3	1/2/3	Fase	1	HW	2	074082 ●	
Brandt	13,5	13,38	2	1/3		2	HW	2	075362 ●	075361 ●
Brandt	13,5	13,38	2	1/2		2	HW	2	075358 ●	075357 ●
Brandt	13,5	13,38	2	1/1,5		2	HW	2	075376 ●	075375 □
Brandt	13,5	13,38	2	1,3/3		2	HW	2	075380 ●	075379 ●
Brandt	13,5	13,38	2	1,3/2		2	HW	2	075360 ●	075359 ●
Brandt	13,5	13,38	2	1,5/2		2	HW	2	075378 ●	075377 ●
Brandt	13,5	13,38	2	2/3		2	HW	2	075364 ●	075363 ●
Brandt	13,5	13,38	2	2	30	2	HW	2	075398 □	075397 □
Homag	13,5	13,38	2	1/3		2	HW	2	075362 ●	075361 ●
Homag	13,5	13,38	2	1/2		2	HW	2	075358 ●	075357 ●
Homag	13,5	13,38	2	1/1,5		2	HW	2	075376 ●	075375 □
Homag	13,5	13,38	2	1,3/3		2	HW	2	075380 ●	075379 ●
Homag	13,5	13,38	2	1,3/2		2	HW	2	075360 ●	075359 ●
Homag	13,5	13,38	2	1,5/2		2	HW	2	075378 ●	075377 ●
Homag	13,5	13,38	2	2/3		2	HW	2	075364 ●	075363 ●
Homag	13,5	13,38	2	2	30	2	HW	2	075398 □	075397 □
Homag	45,8	17,95	2	1/1,5/2/3/5	25	3	HW	2	074050 ●	074049 ●
IMA	24	20	2	1/1,5/2/3		4	HW	2	074106 ●	
IMA	24	20	2	1/2/3		4	HW	2	074107 ●	
Stefani	34	12,7	3	1/2/3	Fase	1	HW	2	074080 □	

Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	117507 ●
Oval head screw Torx® 15	M4x6	006225 ●

Technical information:

Prevention of stress-whitening and rework through special bevel. Multi-profile scraper with different bevels and radii.

Multi-profile scraper with anti stress-whitening bevel

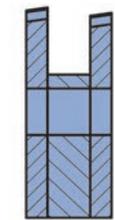
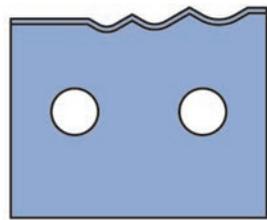
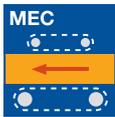
TM 135 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Homag	45,8	17,074	2	1/1,5/2/2,5/3	25	3	HW	2	073105 ●	073104 ●
Homag	45,8	17,23	2	1/1,3/1,5/2/3	25	3	HW	2	073107 ●	073106 ●

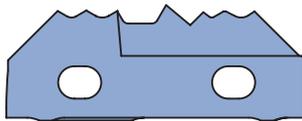
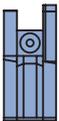
Further radii combinations with anti-stress whitening bevel available at short time.

Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	117507 ●
Oval head screw Torx® 15	M4x6	006225 ●



Duo multi-profile scraper Type 1
(all profiles in Duo design)



Duo multi-profile scraper Type 2
(2 profiles in Duo design)

Multi-profile scrapers

Application:

For scraping edgebandings with radii or bevels. Especially for colour fastness and anti-stress whitening for dark edges and high gloss PMMA edges.

Machine:

Single or double-sided edgebanding machines or double-end tenoners.

Workpiece material:

Plastic edgebander as PP, ABS, PMMA etc.

Technical information:

Duo multi-profile scraper with different radii and bevels for 4 profiles in total. Staggered cut on two consecutively arranged scrapers with special micro geometry for high edge quality, colour fastness, high gloss level and without stress-whitening. Especially in conjunction with jointless edgebanding.

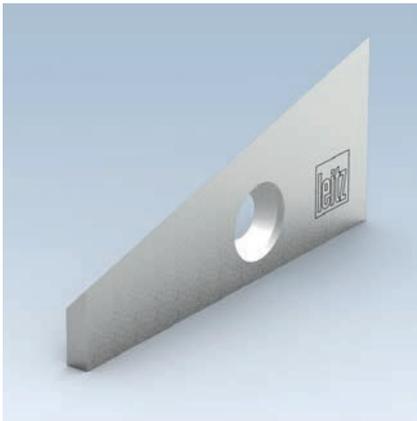
Attention: Only applicable on standard scraper aggregates with special profile scraper holders.

Duo multi-profile scraper

TM 135 0, TM 435 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	ID	ID left
Homag	45,8	19,94	8	1,3/2,0 (Duo) 0,6/1,5	5	2	HW	073731 □	073730 □
IMA	24	19,8	8	1/2/3	45	1	HW	074089 □	074088 □
IMA	23,7	19,8	8	1,3/1,5/2	45	1	HW	074085 □	074084 □

Further radii combinations available at short notice.



Flat scrapers

Application:

For scraping edgebandings and glue.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic edgebandings.

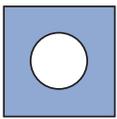
Technical information:

Different profile flat scrapers.

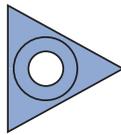
Flat scraper knives

TC 105 0, TM 135 0, TM 405 0, TM 440 0, TM 480 0

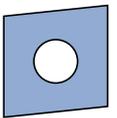
Machine	SB mm	H mm	DIK mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	16	16	4,7		1	HW	2	074556	
Biesse	22,9	22,9	2,5		2	HW	2	074555 ●	
Brandt	15	14,3	2,5	6	3	MC	2	074579 ●	074578 ●
Brandt	15	14,3	2,5	6	3	HW	2	074501 ●	074500 ●
EBM	36	30	3		4	HW	2	074635 ●	074634 ●
Fravol	20	12	1,5		5	HW	2	074638 ●	
Hebrock	36	30	3		4	HW	2	074635 ●	074634 ●
Holz-Her	14	14	2		1	HW	2	009546 ●	
Homag	14,3	14,3	2,5		1	HW	10	005426 ●	
Homag	15	14,3	2,5	6	3	MC	2	074579 ●	074578 ●
Homag	15	14,3	2,5	6	3	HW	2	074501 ●	074500 ●
Homag	32	55	4,5	15	6	HW	2	074048 ●	074047 ●
IMA	14,3	14,3	2,5		1	HW	2	074305 ●	
IMA	55	25	3	15	7	HW	2	074024 ●	074023 ●
IMA BAZ	11	14,3	2,5		5	HW	2	074306	
Ott	15	14,3	2,5	6	3	MC	2	074579 ●	074578 ●
Ott	15	14,3	2,5	6	3	HW	2	074501 ●	074500 ●
SCM	14	14	2		1	HW-F	10	005099 ●	



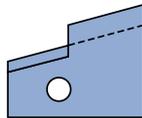
Type 1



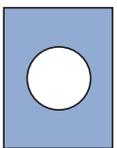
Type 2



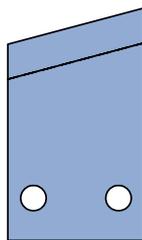
Type 3



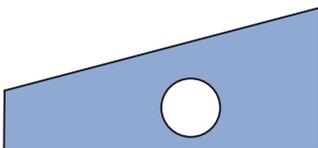
Type 4



Type 5



Type 6



Type 7



Profile cutterhead / bevel cutterhead for stationary machines

Application:

To round/bevel edgebandings.

Machine:

Homag BAZ.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

Cutterheads with HW knives for edge trimming cutter aggregate. Tool centering at recess diameter 19 mm. The same cutterhead tool body suitable for R 1.0 to 3.0 mm. D_0 = constant reference diameter.



Various radii / bevels - Homag

WE 500 2

D	D ₀	BO	NLA	Z	QAL	R	FAW	Type	n _{max}	ID	ID
mm	mm	mm	mm			mm	°		min ⁻¹	LH	RH
59	50	15	3/4,2/25	3	HW	1,0		1	18000	073001 □	073000 □
59	50	15	3/4,2/25	3	HW	1,5		1	18000	073003 □	073002 □
59	50	15	3/4,2/25	3	HW	2,0		1	18000	073005 ●	073004 ●
59	50	15	3/4,2/25	3	HW	3,0		1	18000	073009 □	073008 □
60	50	15	3/4,2/25	3	HW		45	2	18000	073041	073040
62	50	15	3/4,2/25	3	HW		15	3	18000	073101	073100

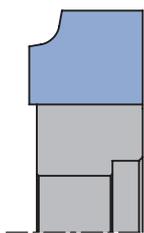
Type 3 for special thin edgebandings.

Spare knives:

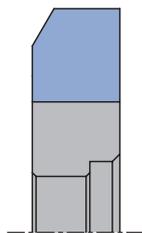
Part-no.	SB	H	DIK	QAL	R	FAW	Type	VE	ID	ID
	mm	mm	mm		mm	°		PCS	LH	RH
1	13	15	2	HW	1,0		1	3	073501 ●	073500 ●
1	13	15	2	HW	1,5		1	3	073503 ●	073502 ●
1	13	15	2	HW	2,0		1	2	073505 ●	073504 ●
1	13	15	2	HW	3,0		1	2	073509 ●	073508 ●
1	12	16	2	HW		45	2	2	073541 ●	073540 ●
1	14	14	2	HW-F			3	10	005099 ●	005099 ●

Spare parts:

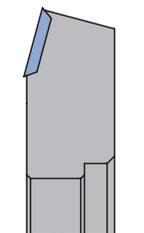
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge RH	11,5x14,4x7	073400 ●
2	Clamping wedge LH	11,5x14,4x7	073401 ●
3	Allen screw	M6x12	006035
3	Countersink screw, Torx® 20	M6x0,5x4,9	006243 ●
	Torx® key	Torx® 20	006091 ●
	Setting gauge for knives	43x12x6	005350 ●



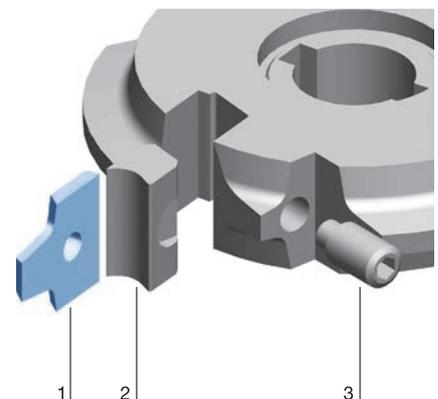
Type 1



Type 2



Type 3



2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutter / bevel cutter for stationary machines

Application:

To round/bevel edgebandings.

Machine:

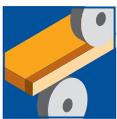
Homag BAZ.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

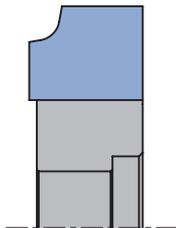
DP tipped tool with interface for edge trimming cutter aggregate. Tool centering at recess diameter 19 mm. D_0 = constant reference diameter.



Radii cutter DP - Homag

WF 501 2 DP

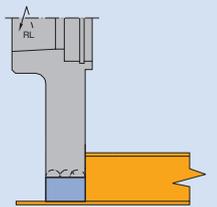
D	D_0	BO	NLA	Z	QAL	R	n_{max}	ID	ID
mm	mm	mm	mm			mm	min^{-1}	LH	RH
57	50	15	3/4,2/25	3	DP	2,0	18000	073103 <input type="checkbox"/>	073102 <input type="checkbox"/>
57	50	15	3/4,2/25	3	DP	3,0	18000	091522 <input type="checkbox"/>	091523 <input type="checkbox"/>



Type 1

Rebating

Milling off the wooden composite board to uncover the cover layer, application mostly with feed.

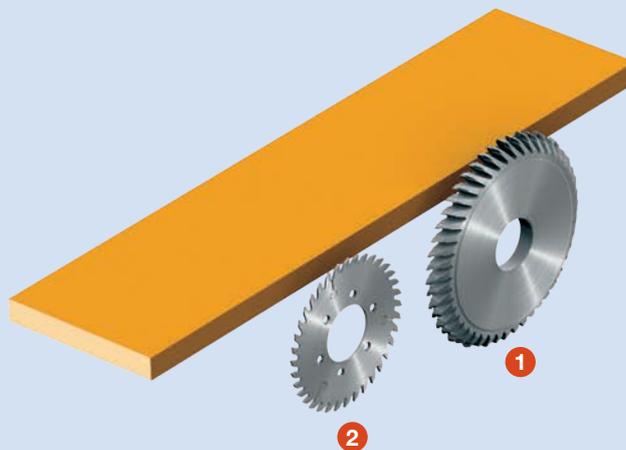
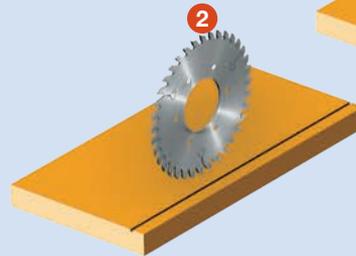
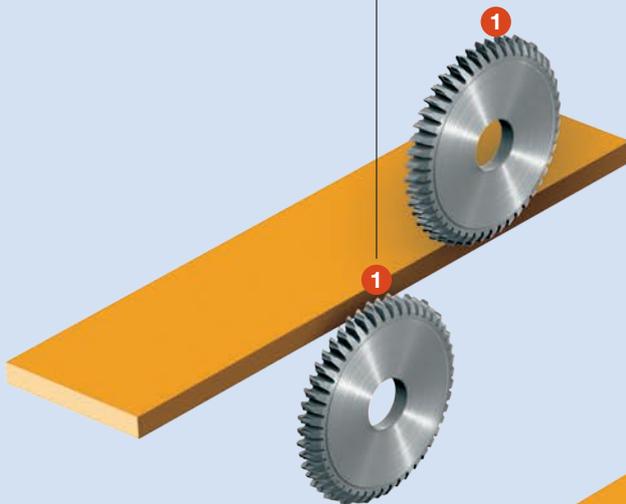


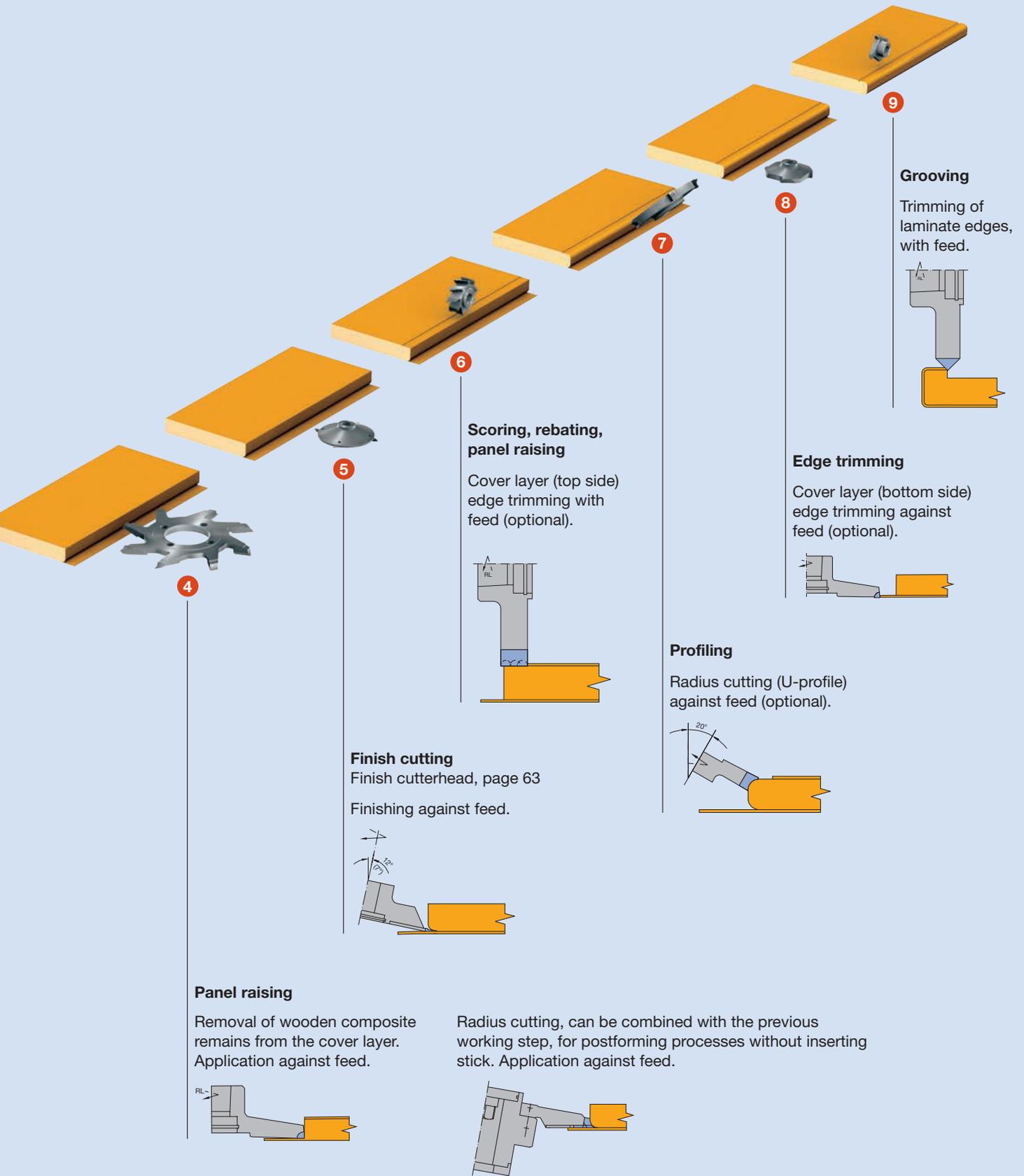
Scoring



Hogging

Compact hogger DT Premium, page 17
Cutting and segment hogger, page 19





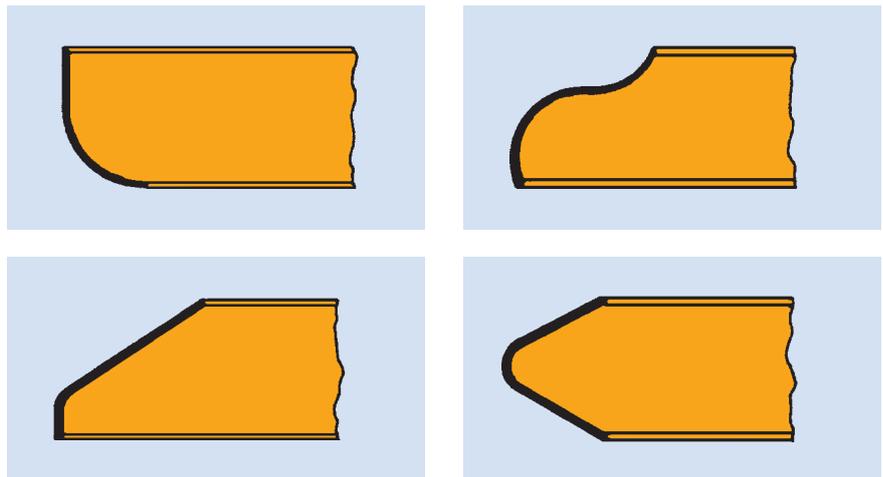
2. Panel processing

2.2 Postforming processing

2.2.2 Postforming tools

Working processes	Production of workpieces with narrow edges for profiling and coating with edging material.
Workpiece material	Chipboard and fibre materials (e.g. MDF boards).
Machines	Single or double-sided soft forming machines.
Procedure	Sizing panel by scoring hogging or double hogging, protection milling, if required. Scoring and removing the coating on the workpiece surface by horizontal spindle. Profiling the narrow edge with vertical, horizontal or inclined spindles. Cutting the edgebanding on the sized side to a precise dimension with the tracing spindle. Edge trimming of the banding on the side banded first with tracing spindle. Scraping, if required.
Important order data	<ul style="list-style-type: none"> - Profile - Coating thickness - Coating material - Machine side - Number of sides to be coated - Expected profile production volume <p>Given the diversity of products, standard tools and special tools are used in soft forming according to requirements.</p>

Profile examples



Working process	Production of workpieces with profiled narrow edges with jointless HPL, CPL or veneer surface coating material wrapped around the narrow face.
Workpiece material	Chipboard and fibre materials (e.g. MDF).
Machines	Single or double-sided post forming machines.
Important ordering information	<div style="display: flex; align-items: flex-start;"> <div style="flex: 1;"> </div> <div style="flex: 2;"> <ul style="list-style-type: none"> - Radius and internal radius - Coating thickness - Material thickness - Type of coating - Post forming with or without inlay rod - Machine side <p>R = External radius, e.g. R9 RI = Internal radius, e.g. R8,65</p> </div> </div>



Finishing cutterhead

Application:

To finish cut the radius of postforming profiles.

Machine:

Postforming machines.

Workpiece material:

HPL, CPL or veneer-coated chip- and fibre boards (particle board, MDF etc.).

Technical information:

Spare knives for cutterhead with DP profile knives and cylindrical bore or HSK 25 R adaptor. Suitable for finish cutting radii up to R 14. Non-resharpenable knives 0.5 mm optimised for sensitive coatings, veneer postforming and maximum contour accuracy.

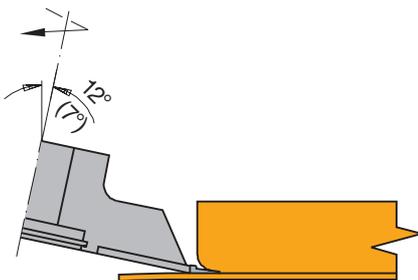


Spare knives for finishing cutterheads

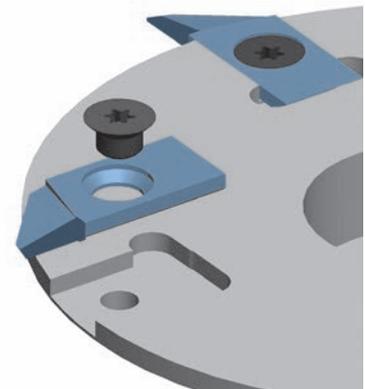
TM 160 0

BEZ	ABM	QAL	ID	ID
	mm		LH	RH
Knife	12x31x2,5x0,5, SB2,5	DP	008208 ●	008204 ●

Spare knives for 7° and 12° inclined spindles.



Finish cutting radii up to R 14 mm at 7° and 12° spindle angle



2. Panel processing

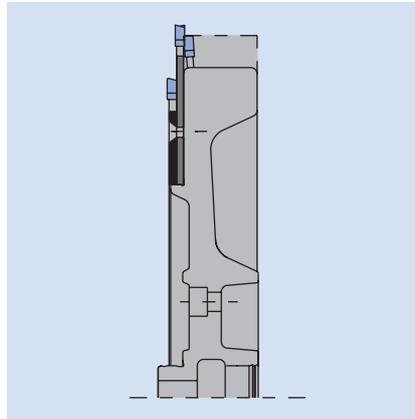
2.3 Panel processing

2.3.1 Segment hoggers for sizing

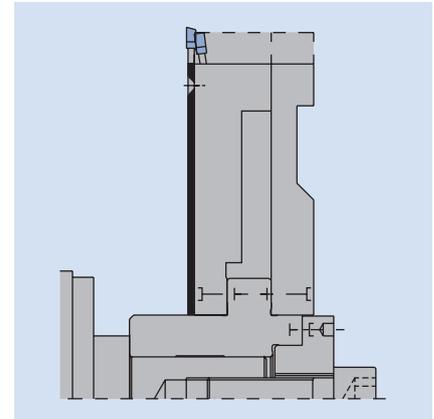
Segment hogger

The cut edge quality of the sizing and finish cuts depends on the circular sawblades. Tool body in steel or aluminium. Staggered cut with tungsten carbide segments. Assembly on flanged sleeve or direct assembly on the motor spindle without flanged sleeve depends on the design.

Designs



Toolset for finish-production unit with sizing and finish cut



Toolset for sizing unit mounted on flanged sleeve



Segment hogger for sizing unit

Application:

For hogging along and across grain with/without scoring sawblade.

Machine:

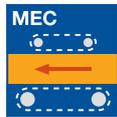
Sizing station in production lines.

Workpiece material:

Chip and fibre boards (MDF etc.) uncoated, veneered, plastic coated.

Technical information:

The cut edge quality depends on the circular sawblade. Tool body D 305 mm in steel or D 355 mm in aluminium. Staggered cut with six tungsten carbide segments. Build up option with extension hogger unit. For D 305 mm the hogger is mounted directly on the spindle without flanged sleeve.



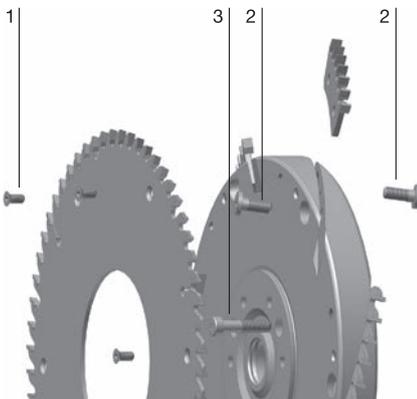
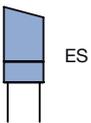
Hogger for sizing unit

SZ 300 2, SZ 301 2

Machine	D	SB	BO	Z/ZF _{Sawblade}	QAL	ID	ID
	mm	mm	mm			LH	RH
Siempelkamp	305	60,1	30	60/ES	HW	064700 □	064701 □
Siempelkamp	355	60,5	40 DKN	72/ES	HW	064702	064703

Spare parts:

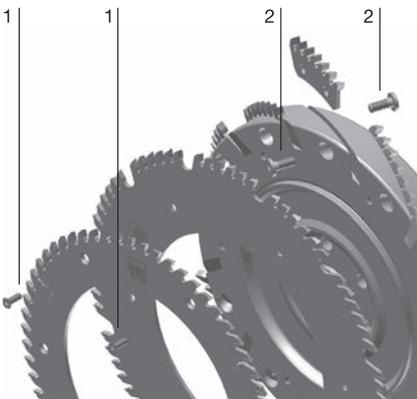
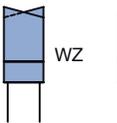
Part- no.	BEZ	ABM	Z	ZF	QAL	BEM	ID
		mm					
	Basic hogger	300x28,0x30	6x7	FZ	HW		064440 ●
	Basic hogger	300x28,0x30	6x7	FZ	HW		064441 ●
	Basic hogger	350x36,5x80	6x10	FZ	HW		064442
	Basic hogger	350x36,5x80	6x10	FZ	HW		064443
	Extension cutter	300x28,0x30	6x7	FZ	HW		064444 ●
	Extension cutter	300x28,0x30	6x7	FZ	HW		064445 ●
	Extension cutter	350x20,2x80	6x10	FZ	HW		064446
	Extension cutter	350x20,2x80	6x10	FZ	HW		064447
	Hogging segment	D 300/340	7	FZ	HW		064970 ●
	Hogging segment	D 300/340	7	FZ	HW		064971 ●
	Hogging segment	D 350	10	FZ	HW		064962 ●
	Hogging segment	D 350	10	FZ	HW		064963 ●
1	Countersink screw, Torx® 20	M6x12				Torx® 20	006084 ●
2	Screw with ISK	M8x17				for D = 250, 350, 305, 355	006237 ●
3	Cylindrical screw with ISK	M8x60				for D = 305	005878 ●
3	Cylindrical screw with ISK	M8x35				for D = 305, 350	005874 ●
3	Cylindrical screw with ISK	M8x25				for D = 355	005947 ●



Hogging sawblade

WK 801 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
305	4,4	120	60	ES	HW	061844 ●	061845 ●
355	4,4	80	72	ES	HW	061846 ●	061847 ●



Segment hogger for splitting unit

Application:

For hogging along and across grain with/without scoring sawblade.

Machine:

Sizing station in production lines.

Workpiece material:

Chip and fibre boards (MDF etc.) uncoated, veneered, plastic coated.

Technical information:

Cut edge quality of the trim and finish cuts is defined by the sawblades. Set assembled with finish cut, trim sawblade and twelve tungsten carbide tipped segments. Staggered cut by twelve hogging segment. The hogger is mounted directly on the motor spindle without flanged sleeve.

Hogger for splitting unit

SZ 300 2

Machine	D mm	SB mm	BO mm	Z/ZF _{Sawblade}	QAL	ID LH	ID RH
Siempel- kamp	350	42,1	30	60 ES/FA 72 WZ	HW	064704	064705

Spare parts:

Part- no.	BEZ	ABM mm	Z	ZF	QAL	BEM	ID
	Basic hogger	340x34,5x30	12x7	FZ	HW		064448
	Basic hogger	340x34,5x30	12x7	FZ	HW		064449
	Hogging segment	D 300/340	7	FZ	HW		064970 ●
	Hogging segment	D 300/340	7	FZ	HW		064971 ●
1	Countersink screw, Torx® 20	M6x16				Torx® 20	006086 ●
2	Cylindrical screw with ISK	M8x35				for D = 305, 350	005874 ●

Hogging sawblade

WK 802 2, WK 850 2

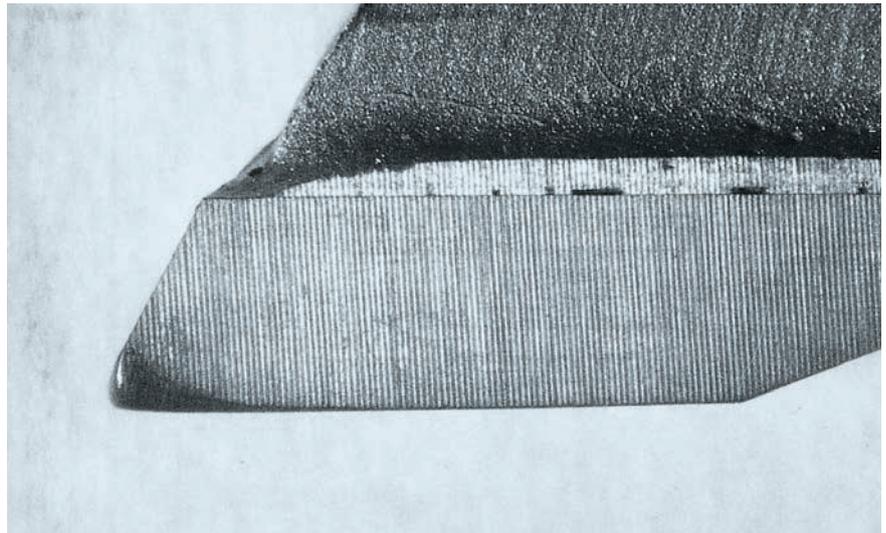
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
300	4,4	200	60	ES/FA	HW	061848 ●	061849 ●
350	4,4	200	72	WZ	HW	061850 ●	061850 ●

Problem	Possible cause	Action
Break outs at the edge of the workpiece top edge	- Incorrect height adjustment of hogging motor and tilt in feed direction	Correct setting Check position of tools in feed direction, adjust standard value of 0.1 mm to the panel edge
	- Too much axial play in spindle bearing or damaged bearing	Check motor bearings and tolerances
	- Track vibrates due to low chain tension and damaged guides	Check the chain tension, replace damaged parts
	- Incorrect top pressure adjustment	Check top pressure
	- Run out tolerance too high, possible tool imbalance	Measure tool, correct and check for imbalance
	- Insufficient number of teeth, feed rate too high	Increase number of teeth or adjust feed speed
Break outs at the edge of the workpiece bottom edge	- Workpiece projection too large or thin workpieces	Provide additional support in the tool area
	- Incorrect adjustment in feed direction of scoring or hogging tool	Produce trial sample and adjust motors
	- Scoring sawblade not adjusted to the accuracy required in feed direction or hogging tool tilted too far	Check angles of scoring sawblade and hogging tool in feed direction
Tooth pattern at workpiece edge wavy surface	- Tool position setting angle is too high	Correct the tool setting angle
	- Transport of workpiece not consistent during through feed	Check chain and drive
	- Inconstant workpiece feed rate	Increase number of teeth or adjust feed speed
	- Run out tolerance too high, possible imbalanced tool	Measure tool, correct and check for imbalance
Surface of middle layer rough, uneven (with steps)	- Tool worn, blunt	Repair and service the tool
	- Insufficient number of teeth, feed speed too high	Increase number of teeth, adjust feed speed
	- Adjustment of top and bottom tools (scoring/hogging tool) not level with feed direction	Produce trial sample and adjust motors
	- Adjustment of hogging tool not at correct angle to the track	Check angle with dial gauge on the horizontal moving spindle
	- Incorrect tooth shape of tool and angle geometry	Check and correct
	- Insufficient middle layer quality of the workpiece	Improve by removing resin and sharpening more frequently
Break outs at edge of workpiece end grain, front	- Adjustment of jump head to the hogging tool not level with feed direction	Produce trial sample and adjust motors
Break outs at edge of workpiece end grain, back	- Adjustment of the controlled scoring motor not level with the hogging unit in feed direction	Check movement of the jump scoring motor and correct adjustment to the hogging unit
	- Poor quality of middle layer of workpiece material (large chip flow, poor pressing)	Improve by removing resin and sharpening tools more often
	- Insufficient number of teeth, feed speed too high	Increase number of teeth or adjust feed speed
	- Incorrect tooth shape and angle geometry	Check and adjust through resharpening

Rounding of the cutting edge

When hogging solid wood and wood-derived materials with or without coating, the teeth of the hogging sawblade and hogger parts are subject to mechanical and chemical wear.

The surface quality determines the size of the cutting edge abrasion. An extremely worn sawblade tooth requires additional sharpening and reduces the number of possible resharpenings.



Typical cutting edge wear when machining solid wood.

Cutting edge destruction through improper use

If the relationship between the number of teeth and feed speed is incorrect, the cutting forces will be too high when hogging solid wood, especially with a high moisture content. This leads to choking the gullet and consequently destruction of the saw tooth.

Action:

Reduce the number of teeth to increase the gullet area; adjust feed speed so the cutting quality is still adequate.



Cutting edge destruction through improper use.

Cutting edge destruction through overstress

If the material to be removed is wider than the cutting width of the hogger, the outside teeth of the raised hogger segments are destroyed by overstress.

The hogging width must always be smaller than the cutting width of the hogging tool.



Destruction of saw tooth through overstress.

2. Panel processing

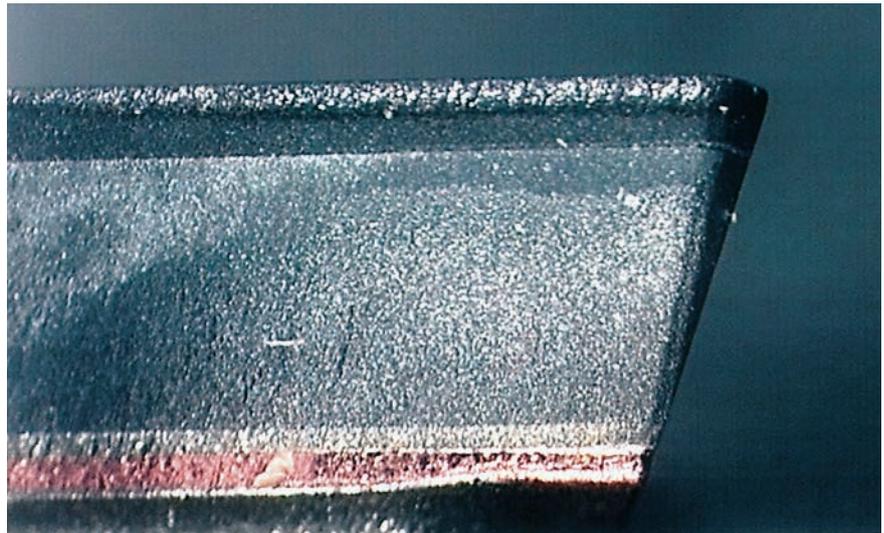
Signs of wear on the DP cutting edges

Rounding of cutting edges

The illustration opposite shows a typical blunt cutting edge, resulting from mechanical abrasion when machining uniform materials.

Removing the resin from the sides of the teeth between resharpening intervals leads to a considerably longer performance time, as it prevents the loss of side relief.

The area of wear should be approx. 0.2 to max. 0.3 mm.

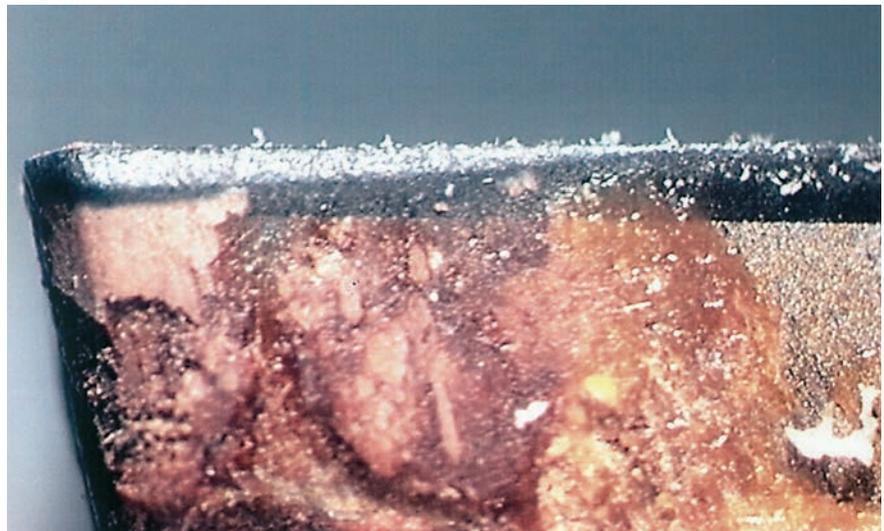


Wear to cutting edges after machining MDF.

Cutting edge rounding and resin build up

Apart from cutting edge wear, a build-up also forms at the side of the teeth from adhesive dust and chip particles (resin build-up) when the workpiece material has a high resin content or the tool has been run for a long time.

This leads to higher cutting forces and power consumption, low surface and middle layer quality and a considerably reduced tool life.

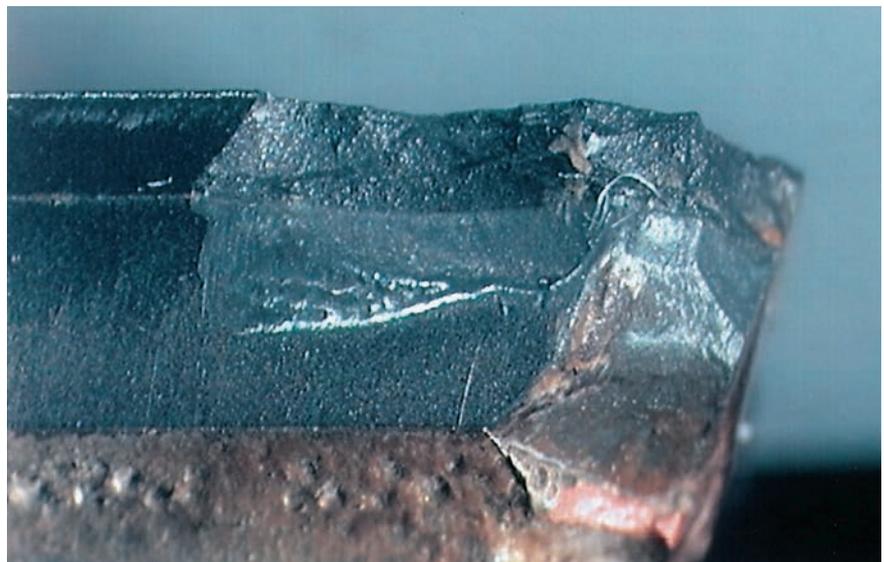


Wear to cutting edges and resin build-up after machining chipboard.

Cutting edge destruction

The cutting edges can be destroyed when machining workpiece materials with a high sand content, a grain size up to 2 - 3 mm diameter (l) or containing metallic particles.

Using DP (DIA) tools when machining such workpiece materials is problematic and use is not recommended for efficient machining.

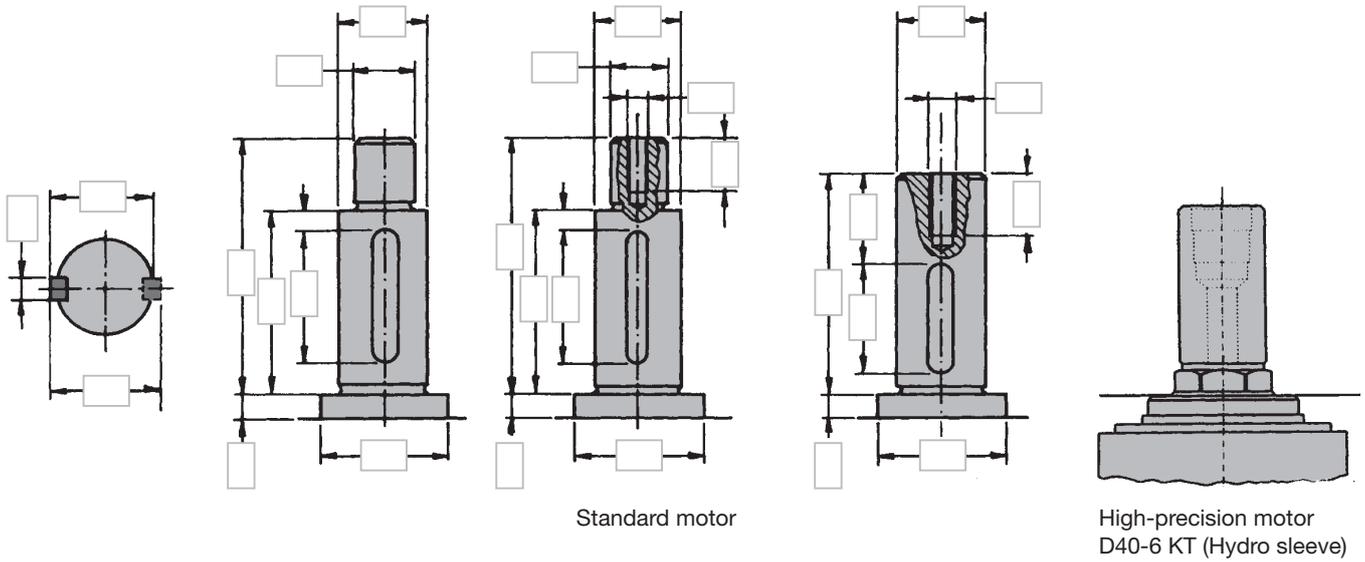


Cutting edge destruction from metallic particles.

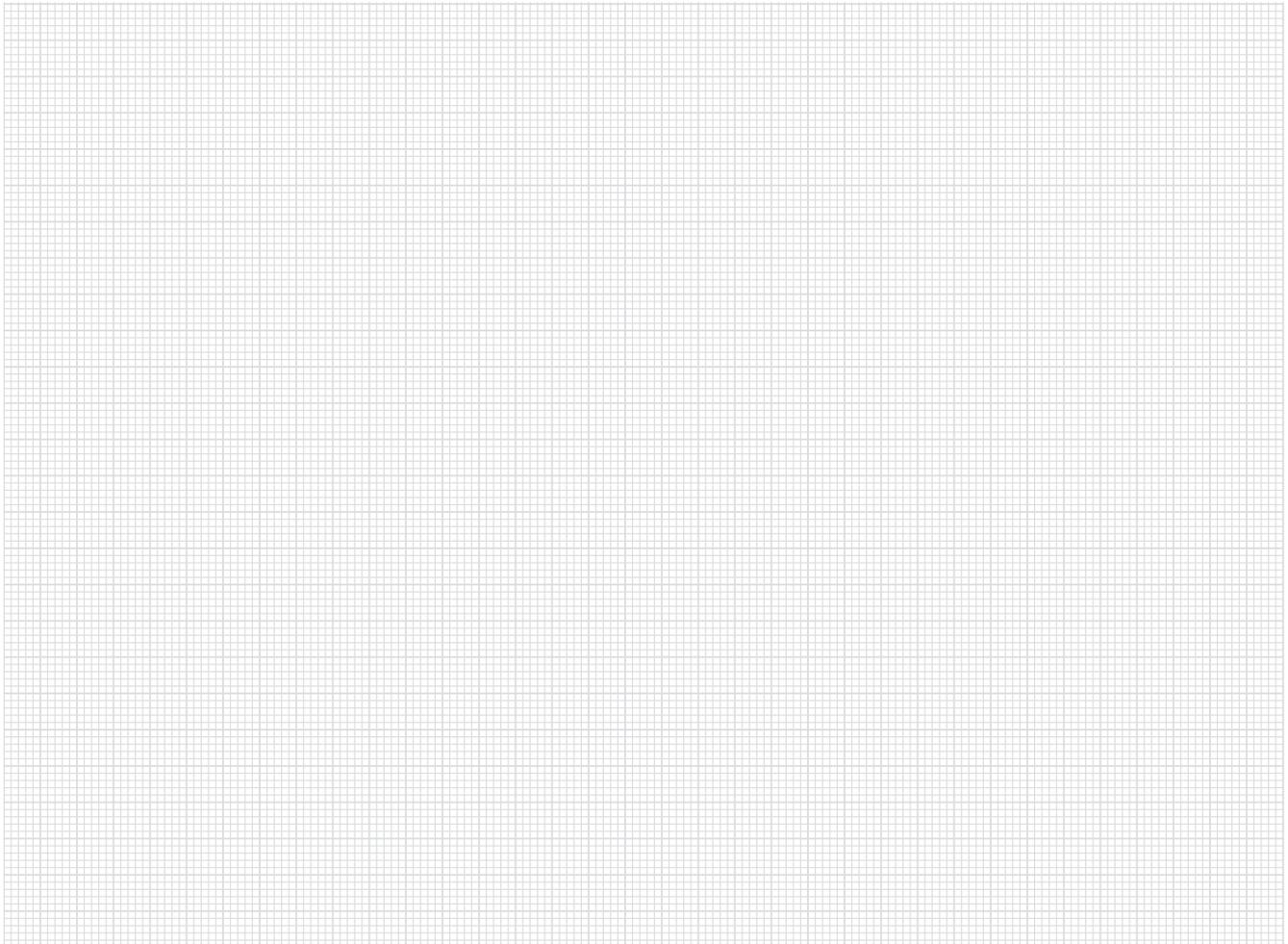
Enquiry/order form special tools – panel processing

Hogging motor/spindle details:

(Enter dimensions on drawing or state in space for sketches)



Sketch for application plan, motor spindle etc.



Key to pictograms

	Scoring hogging		Tipped tool
	Hogging		Light alloy body
	Double hogging		Interchangeable knives
	End trimming		Mechanical knife clamping, reversible
	Edge trimming		Resharpenable cutting face
	Grooving, horizontal and vertical		Resharpenable clearance face
	Jointing		Low noise
	Rebating		DFC Optimised chip flow
	Profiling		HW Tungsten carbide
	Profiling joints		DP Polycrystalline diamond (PCD)
	MEC Mechanical feed		

