

# Panel processing

Leitz Lexicon Edition 7

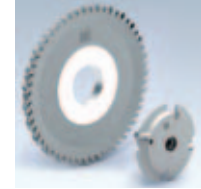


## Explanation of abbreviations

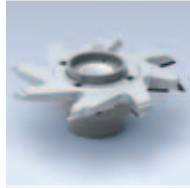
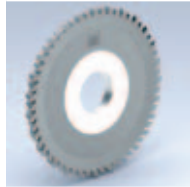
A	= dimension A	LL	= left hand rotation
$a_e$	= cutting thickness (radial)	M	= metric thread
$a_p$	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	$\text{min}^{-1}$	= revolutions per minute (RPM)
AL	= working length	MK	= morse taper
AM	= number of knives	$\text{m min}^{-1}$	= metres per minute
AS	= anti sound (low noise design)	$\text{m s}^{-1}$	= metres per second
b	= overhang	n	= RPM
B	= width	$n_{\text{max}}$	= 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	RL	= 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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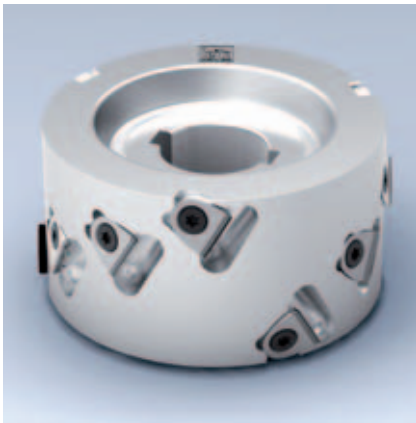
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#### WhisperCut jointing / milling cutter - cutterhead design

**Application:**

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

**Machine:**

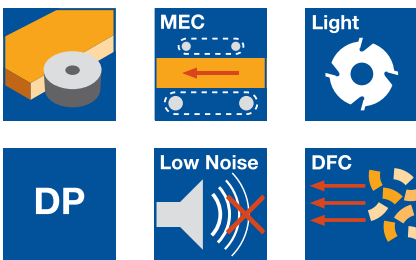
Edgebanding machines, copy shaping machines, double-end tenoners etc.

**Workpiece material:**

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

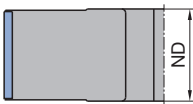
**Technical information:**

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.

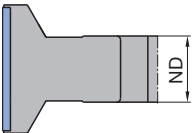


**Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body**

WF 230 2 DP, WM 230 2 01



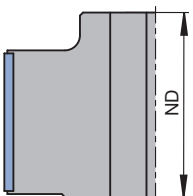
Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3



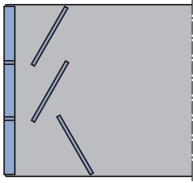
Position of boss (NAL) 4

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
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	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	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	85	85	30	DKN 3	3x8	24xA	AS	090889	090890
Brandt	100	105	85	30	DKN 3	3x10	30xA	AS	090891	090892
Cehisa	100	54	25	20	DKN 2	2x5	10xA	AS	192078 ●	192079 ●
Felder	60	63	63.5	25	DKN 3	2x7	12xC	AS°		192278 ●
Felder	60	63	63.5	25	DKN 3	2x7	12xC	AS°	192277 ●	
Felder	80	48.5	64	25	DKN 3	3x6	12xB	AS°	192281 ●	192282 ●
Felder	80	64	64	25	DKN 3	3x7	18xB	AS°	192279 ●	
Felder	80	64	64	25	DKN 3	3x7	18xB	AS°		192280 ●
Fraval	60	63	63.5	25	DKN 3	2x7	12xC	AS°		192248 ●
Fraval	60	63	63.5	25	DKN 3	2x7	12xC	AS°	192247 ●	
Fraval	60	84	61	25	DKN 3	2x8	14xC	AS°		192242 ●
Fraval	60	84	61	25	DKN 3	2x8	14xC	AS°	192241 ●	
Fraval	100	65	56.5	30	DKN 3	2x6	12xA	AS	192243 ●	192244 ●
Fraval	100	124	96	30	DKN 2	2x11	22xA	AS	192245 ●	192246 ●
Hebrock/EBM	70	43	61	25	DKN 4	2x4	8xB	AS	192237 ●	192238 ●
Hebrock/EBM	70	63	81	25	DKN 4	2x6	12xB	AS	192239 ●	192240 ●
Hebrock/EBM	100	43	61	30	DKN 3	2x4	8xB	AS	192233 ●	192234 ●
Hebrock/EBM	100	63	81	30	DKN 3	2x6	12xB	AS	192235 ●	192236 ●
Holz-Her	70	48	41	30	DKN 4	2x5	8xD	AS°	192222 ●	
1801/1802							2xD1			

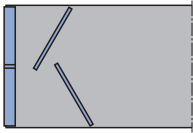
## 2. Panel processing

### 2.1 Edge processing

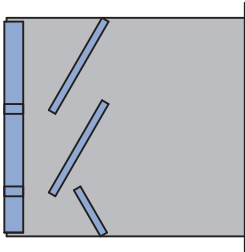
#### 2.1.2 Jointing cutters



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



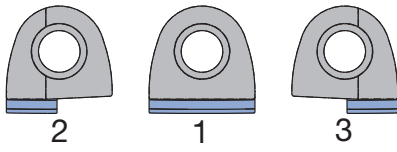
Type AS° = asymmetric tip arrangement with a narrow row of teeth below

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Holz-Her 1801/1802	70	48	41	30	DKN	4	2x5 8xD 2xD2	AS°		<b>192221 •</b>
Holz-Her 1801/1802	70	64	41	30	DKN	4	2x7 12xD 2xD1	AS°	<b>192224 •</b>	
Holz-Her 1801/1802	70	64	41	30	DKN	4	2x7 12xD 2xD2	AS°		<b>192223 •</b>
Holz-Her 1804	100	63	39.5	30	DKN	2	3x6 18xB	S	<b>192147 •</b>	<b>192148 •</b>
Holz-Her 1891	100	43	25	30	DKN	2	2x4 8xA	AS	<b>192082 •</b>	<b>192083 •</b>
Holz-Her 1891	100	65	25	30	DKN	2	2x6 12xA	AS	<b>192084 •</b>	<b>192085 •</b>
Homag	125	43	40	30	DKN	2	3x4 12xE	S	<b>075627 •</b>	<b>075627 •</b>
Homag	125	63	40	30	DKN	2	3x6 18xE	S	<b>075626 •</b>	<b>075626 •</b>
IMA	125	32	34	30	DKN	1	3x4 12xD	AS	<b>192092 •</b>	<b>192093 •</b>
IMA	125	43	42	30	DKN	2	3x5 15xD	AS	<b>192094 •</b>	<b>192095 •</b>
IMA	125	63	42	30	DKN	3	3x7 21xD	AS	<b>192096 •</b>	<b>192097 •</b>
IMA Advantage	125	43	57	30	DKN	4	3x5 15xD	AS	<b>192098 •</b>	<b>192099 •</b>
IMA Advantage	125	65	57	30	DKN	4	3x7 21xD	AS	<b>192100 •</b>	<b>192101 •</b>
Ott	85	48	50	30	DKN	3	3x5 12xB 3xB1	AS°		<b>192209 •</b>
Ott	85	48	50	30	DKN	3	3x5 12xB 3xB2	AS°		<b>192210 •</b>
Ott	85	65	45	30	DKN	2	3x6 18xB	AS	<b>192227 •</b>	<b>192228 •</b>
Ott	85	85	50	30	DKN	3	3x8 24xB	AS	<b>192229 •</b>	<b>192230 •</b>
SCM	100	51	60	30	DKN	3	2x6 8xB 2xB1 2xB2	AS°	<b>192215 •</b>	<b>192216 •</b>
SCM	100	51	60	30	DKN	3	3x6 12xB 3xB1 3xB2	AS°	<b>192217 •</b>	<b>192218 •</b>
SCM	100	66	60	30	DKN	3	2x7 12xB 2xB1	AS°	<b>192213 •</b>	
SCM	100	66	60	30	DKN	3	2x7 12xB 2xB2	AS°		<b>192214 •</b>
SCM	100	66	60	30	DKN	3	3x7 18xB 3xB1	AS°	<b>192219 •</b>	
SCM	100	66	60	30	DKN	3	3x7 18xB 3xB2	AS°		<b>192220 •</b>
Stefani	100	51	60	30	DKN	3	2x6 8xB 2xB1 2xB2	AS°	<b>192215 •</b>	<b>192216 •</b>
Stefani	100	51	60	30	DKN	3	3x6 12xB 3xB1 3xB2	AS°	<b>192217 •</b>	<b>192218 •</b>
Stefani	100	66	60	30	DKN	3	2x7 12xB 2xB1	AS°	<b>192213 •</b>	
Stefani	100	66	60	30	DKN	3	2x7 12xB 2xB2	AS°		<b>192214 •</b>
Stefani	100	66	60	30	DKN	3	3x7 18xB 3xB1	AS°	<b>192219 •</b>	
Stefani	100	66	60	30	DKN	3	3x7 18xB 3xB2	AS°		<b>192220 •</b>
Törk Makine	100	65.2	40.6	30	DKN	3	3x6 18xA	AS	<b>090887 •</b>	<b>090888 •</b>

## 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	<b>091052 ●</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	<b>091066 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	2	<b>091067 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B2	3	<b>091068 ●</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	D	1	<b>091071 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D2	2	<b>091072 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D1	3	<b>091073 ●</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	E	1	<b>091074 ●</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	C	1	<b>091077 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C1	2	<b>091079 ●</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C2	3	<b>091078 ●</b>

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	<b>116011 ●</b>
Spindle nut	38x28 M25x1.5	Felder, Fraval	<b>066566 ●</b>



### WhisperCut 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:**

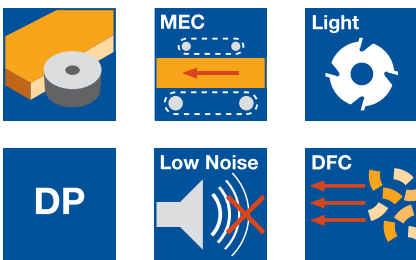
Edgebanding machines, copy shaping machines, double-end tenoners etc.

**Workpiece material:**

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

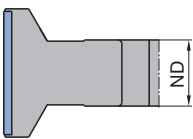
**Technical information:**

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 edge-banding. 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.



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

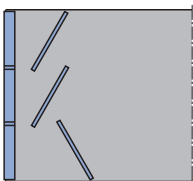
Machine	D mm	SB mm	ND mm	BO mm	NAL	$n_{max}$ min <sup>-1</sup>	Z	Type	ID	
									LH	RH
Biesse	125	43	40	30	DKN 2	13700	3x6	S	192249 ●	192249 ●
Biesse	125	63	40	30	DKN 2	13700	3x8	S	192250 ●	192250 ●
Homag	125	43	40	30	DKN 2	13700	3x6	S	192249 ●	192249 ●
IMA	125	43	40	30	DKN 3	13700	3x6	AS	192251 ●	192252 ●
IMA	125	63	40	30	DKN 3	13700	3x8	AS	192253 ●	192254 ●



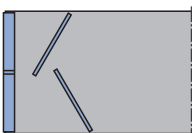
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement

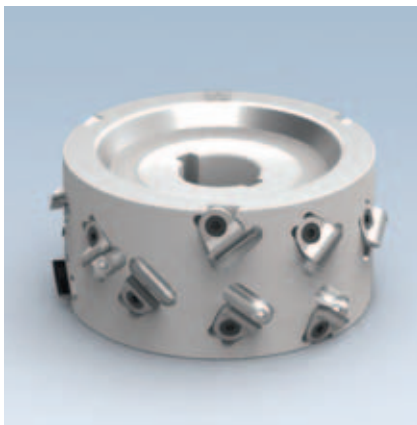


Type S = symmetric tip arrangement

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### WhisperCut 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:**

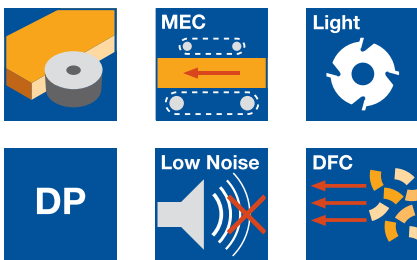
Edgebanding machines, copy shaping machines, double-end tenoners etc.

**Workpiece material:**

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

**Technical information:**

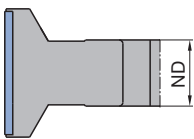
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edge-banding. 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. 3.1 mm resharpening area.



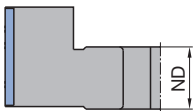
**Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body**

WM 230 2 02

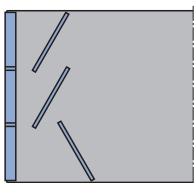
Machine	D	SB	ND	BO	NAL	$n_{max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$min^{-1}$			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
IMA	125	43	40	30 DKN	3	13700	3x6	AS	192256 ●	192257 ●



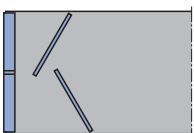
Position of boss (NAL) 2



Position of boss (NAL) 3

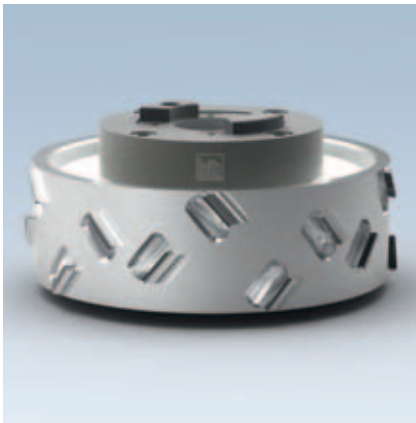


Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement





### 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:**

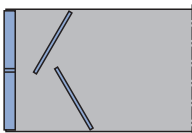
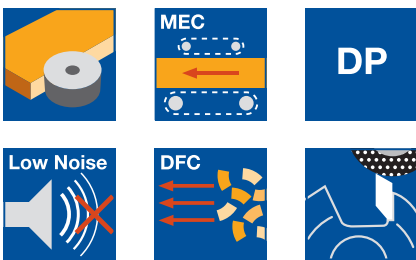
Edgebanding machines with zero joint technology.

**Workpiece material:**

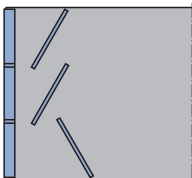
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

**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.



Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement

**Diamaster PRO mounted on hydro sleeve**

HF 230 2, HF 230 2 DP

Machine	D mm	SB mm	BO mm	n <sub>max</sub> min <sup>-1</sup>	Z	Type	ID	
							LH	RH
Homag	125	43	30	13600	5x4	S	<b>192133</b> □	<b>192134</b> □
Homag	125	63	30	13600	5x6	S	<b>192135</b> □	<b>192136</b> □
Homag	150	43	30	13600	5x4	S	<b>192205</b> □	<b>192206</b> □
Homag	150	63	30	13600	5x6	S	<b>192207</b> □	<b>192208</b> □

**Diamaster WhisperCut EdgeExpert mounted on hydro sleeve**

HM 230 2 01

Machine	D mm	SB mm	BO mm	n <sub>max</sub> min <sup>-1</sup>	Z	Type	ID	
							LH	RH
IMA	125	43	30	13700	4x6	AS	<b>192259</b> □	<b>192258</b> □
IMA	125	63	30	13700	4x8	AS	<b>192261</b> □	<b>192260</b> □
IMA	150	43	30	13700	4x6	AS	<b>192263</b> □	<b>192262</b> □
IMA	150	63	30	13700	4x8	AS	<b>192265</b> □	<b>192264</b> □

**Spare parts:**

BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 30	<b>066563</b> ●
Allen Key	SW 5, L 150	<b>005501</b> ●

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### Jointing / milling cutter on HSK-F 63 arbor

**Application:**

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

**Machine:**

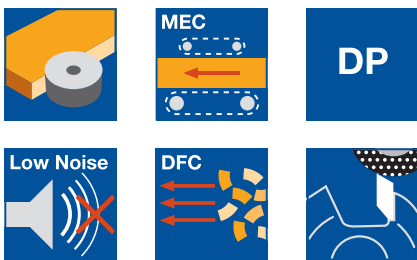
Edgebanding machines with zero joint technology.

**Workpiece material:**

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

**Technical information:**

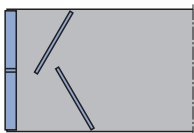
Increase of the processing quality through zero clearance HSK adaptor. Composite tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces hollow cut for tightly closing edgebanding. 1.5 mm resharpening area.



**Diamaster PRO mounted on HSK-F 63 mod.**

WF 230 2 DP

Machine	D mm	SB mm	BO mm	$n_{max}$ min <sup>-1</sup>	Z	Type	ID LH	ID RH
Homag	150	43	HSK-F 63 mod.	13600	5x4	S	<b>192197</b> □	<b>192198</b> □
Homag	150	63	HSK-F 63 mod.	13600	5x6	S	<b>192199</b> □	<b>192200</b> □



Type S = symmetric knife arrangement



#### Jointing / milling cutter

**Application:**

For jointing/milling rebates in panel edges.

**Machine:**

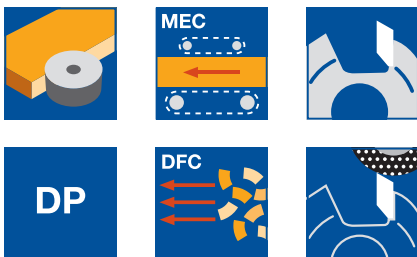
Edgebanding machines and double-end tenoners.

**Workpiece material:**

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

**Technical information:**

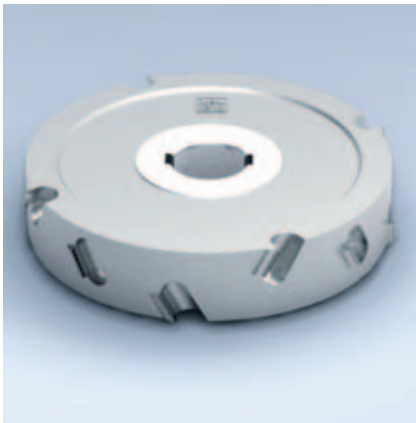
Composite tool with alternate shear angle for tear-free edges. DFC design for chip flow and efficient chip clearance (>95%). 1.5 mm resharpening area.



**Diamaster PLUS - DFC**

WF 230 2 DP

D mm	SB mm	ND mm	BO mm	$n_{max}$ min <sup>-1</sup>	Z	ID LH	ID RH
150	45	39	30 DKN	11400	4x5	<b>192266</b>	<b>192267</b>
150	64	39	30 DKN	11400	4x7	<b>192268</b>	<b>192269</b>



#### Protection milling / jump cutting

**Application:**

For tear-free jointing with and against feed (e.g. jump cutting).

**Machine:**

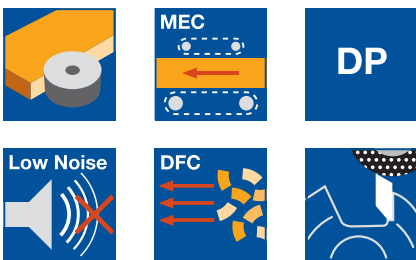
Edgebanding machines and double-end tenoners.

**Workpiece material:**

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

**Technical information:**

Tool with alternate shear angle for tear-free edges and jointed edge. Low noise design with noise reduction of up to 5 dB(A) and efficient chip clearance (>95%). 1.5 mm resharpener area.



**Diamaster PRO - DFC, LowNoise**

WF 230 2 DP

Machine	D	SB	ND	BO	NAL	$n_{max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$min^{-1}$			LH	RH
Homag, IMA	180	34	42	35 DKN	1	9500	4x3	AS	<b>090851</b>	<b>090852</b>
Homag, IMA	180	43	46	35 DKN	1	9500	4x4	AS	<b>090841</b>	<b>090842</b>
Homag, IMA	180	63	46	35 DKN	3	9500	4x6	AS	<b>090839</b>	<b>090840</b>



#### Protection milling / jump cutting

**Application:**

For tear-free jointing with and against feed (e.g. jump cutting).

**Machine:**

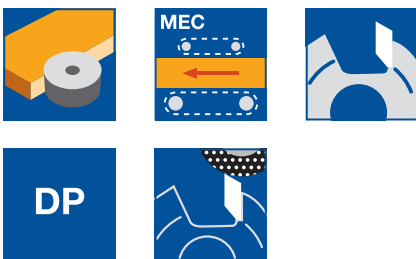
Edgebanding machines and double-end tenoners.

**Workpiece material:**

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

**Technical information:**

Tool with large, alternate shear angle for tear-free edges and straight jointed edge. 4.0 mm resharpener area.



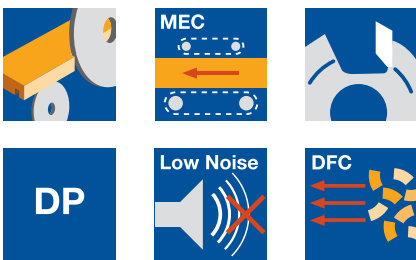
**Diamaster PLUS**

WF 230 2

Machine	D	SB	ND	BO	NAL	$n_{max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$min^{-1}$			LH	RH
Homag, IMA	180	34	34	35 DKN	2	9500	6x3	AS	<b>090847</b>	<b>090848</b>
Homag, IMA	180	43	46	35 DKN	1	9500	6x4	AS	<b>192056</b>	<b>192057</b>
Homag, IMA	180	63	46	35 DKN	3	9500	6x6	AS	<b>192058</b>	<b>192059</b>
Homag, IMA	180	34	34	35 DKN	2	9500	8x3	AS	<b>192060</b>	<b>192061</b>
Homag, IMA	180	43	46	35 DKN	1	9500	8x4	AS	<b>192062</b>	<b>192063</b>
Homag, IMA	180	63	46	35 DKN	3	9500	8x6	AS	<b>192064</b>	<b>192065</b>

**Recommended feed rate for 6000  $min^{-1}$  for veneered or coated particle and fibre materials.**

Z=4	25 $m\ min^{-1}$
Z=6	35 $m\ min^{-1}$
Z=8	45 $m\ min^{-1}$
Z=10	55 $m\ min^{-1}$
Z=12	65 $m\ min^{-1}$
Z=14	80 $m\ min^{-1}$



### Diamaster DT Score PLUS

#### Application:

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

Excellent efficiency with 13 tool lives and constant cutting width after servicing. Edge quality enhanced with DFC-technology and near vibration free tool body. Optimizing workplace ergonomics by noise reduction of 3 dB(A) achieved by vibration reducing geometry and an irregular pitch of the gullet.

#### For mounting on flanged sleeve or quick clamping sleeve

HZ 210 2

D	SB	BO	Z	$v_f^*$	ID	ID
mm	mm	mm		m min <sup>-1</sup>	LH	RH
250	10	80	36 (30+6)	25	<b>190346</b> □	<b>190347</b> □
250	10	80	48 (40+8)	30	<b>190348</b> □	<b>190349</b> □
250	10	80	60 (50+10)	40	<b>190350</b> □	<b>190351</b> □

#### For mounting on hydro clamping or hydro quick clamping sleeve

HZ 210 2

D	SB	BO	Z	$v_f^*$	ID	ID
mm	mm	mm		m min <sup>-1</sup>	LH	RH
250	10	60	36 (30+6)	25	<b>190340</b> □	<b>190341</b> □
250	10	60	48 (40+8)	30	<b>190342</b> □	<b>190343</b> □
250	10	60	60 (50+10)	40	<b>190344</b> □	<b>190345</b> □

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

\* Recommended feed rate for veneered and coated chip and fibre boards.

#### Order example:

Hogging set D-250 mm, Z 60, right

Hogging set consisting of:

DT Score PLUS hogger D-250 ID **190351**

Hydro clamping sleeve ID **061702**

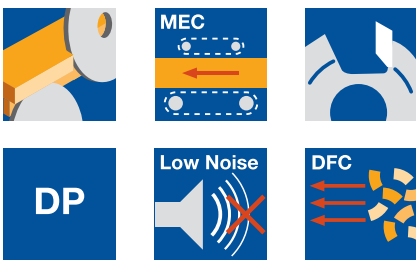
#### Special information:

Including assembly, machine model

Interface	Quick change sleeve	Hydro clamping sleeve
	Hydro quick change sleeve	Flanged sleeve
Variation number	<b>711XX0</b>	<b>711XX1</b>

Extension cutting edge	Without extension cutting edge	With extension cutting edge
	Variation number	<b>711X0X</b>

Variation number	Tooth shape and application
<b>7111XX</b>	Basic type for melamine coated chipboard
<b>7112XX</b>	Paper coated and veneered wood derived materials, loose medium layer, honeycomb board
<b>7113XX</b>	Isolated edges (problem solution for machining across grain), low cutting forces on finish cutting edge
<b>7114XX</b>	High gloss and HPL laminated wood derived materials, dense medium layer



#### Order example:

Hogging set D-250 mm, Z 60, right  
Hogging set consisting of:  
DT PLUS hogger D-250 ID **190339**  
Hydro clamping sleeve ID **061702**

#### Special information:

Including assembly, machine model

### Diamaster DT PLUS

#### Application:

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

#### Machine:

Double-end tenoners, edgbanding machines etc.

#### Workpiece material:

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

#### Technical information:

Excellent efficiency with 13 tool lives and constant cutting width after servicing. Edge quality enhanced with DFC-technology and near vibration free tool body. Optimizing workplace ergonomics by noise reduction of 3 dB(A) achieved by vibration reducing geometry and an irregular pitch of the gullet.

#### For mounting on flanged sleeve or quick clamping sleeve

HZ 210 2

D	SB	BO	Z	$v_f^*$	ID	ID
mm	mm	mm		m min <sup>-1</sup>	LH	RH
250	10	80	24 (20+4)	30	<b>190326</b> □	<b>190327</b> □
250	10	80	30 (25+5)	35	<b>190328</b>	<b>190329</b>
250	10	80	36 (30+6)	40	<b>190330</b> □	<b>190331</b> □
250	10	80	42 (35+7)	45	<b>190332</b>	<b>190333</b>
250	10	80	48 (40+8)	50	<b>190334</b> □	<b>190335</b> □
250	10	80	54 (45+9)	60	<b>190336</b>	<b>190337</b>
250	10	80	60 (50+10)	80	<b>190338</b> □	<b>190339</b> □

#### For mounting on hydro clamping or hydro quick clamping sleeve

HZ 210 2

D	SB	BO	Z	$v_f^*$	ID	ID
mm	mm	mm		m min <sup>-1</sup>	LH	RH
250	10	60	24 (20+4)	30	<b>190312</b> □	<b>190313</b> □
250	10	60	30 (25+5)	35	<b>190314</b>	<b>190315</b>
250	10	60	36 (30+6)	40	<b>190316</b> □	<b>190317</b> □
250	10	60	42 (35+7)	45	<b>190318</b>	<b>190319</b>
250	10	60	48 (40+8)	50	<b>190320</b> □	<b>190321</b> □
250	10	60	54 (45+9)	60	<b>190322</b>	<b>190323</b>
250	10	60	60 (50+10)	80	<b>190324</b> □	<b>190325</b> □

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

#### Hogger DT PLUS mounted on hydro sleeve (40 hydro) or flanged sleeve (35 DKN)

KZ 221 2, SZ 210 2

D	SB	BO	Z	$v_f^*$	VAR	ID	ID
mm	mm	mm		m min <sup>-1</sup>		LH	RH
250	10	40	36 (30+6)	40	711101	<b>190353</b> ●	<b>190352</b> ●
250	10	40	48 (40+8)	50	711101	<b>190355</b> ●	<b>190354</b> ●
250	10	35 DKN	36 (30+6)	40	711101	<b>190357</b> ●	<b>190356</b> ●

\* Recommended feed rate for veneered and coated chip and fibre boards.



### Compact hogger

#### Application:

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

#### Machine:

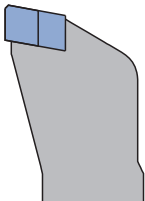
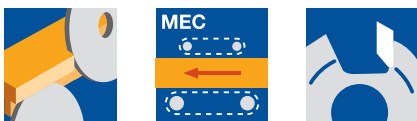
Double-end tenoners, edgebanding machines etc.

#### Workpiece material:

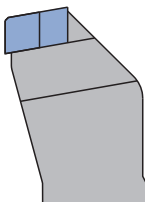
Particle and fibre materials (MDF etc.) uncoated, veneered, plastic and paper coated, lightweight panels (honeycomb).

#### Technical information:

Resharpenable 10 times. **Tooth with decreasing bevel** for higher cutting performance, particularly suitable for materials with a loose middle layer. **Tooth with increasing bevel** for maximum stability, particularly suitable for materials with high mineral content and boards with a large material overhang.



Tooth with decreasing bevel for higher cutting performance, particularly suitable for material with a loose middle layer.



Tooth with increasing bevel for maximum stability, particularly suitable for materials with high mineral content and boards with large material overhang. At decreasing bevel and low overlap remain strips, which won't be hogged.

#### For mounting on hydro clamping or hydro quick clamping sleeve

HZ 210 2

D	SB	BO	Z	ZF	$v_f^*$	ID	ID
mm	mm	mm			$m\ min^{-1}$	LH	RH
250	10	60	35	decreasing	35	<b>190358</b> ●	<b>190359</b> ●
250	10	60	45	decreasing	45	<b>190360</b> ●	<b>190361</b> ●
250	10	60	55	decreasing	55	<b>190362</b>	<b>190363</b>
253	10	60	35	increasing	35	<b>190364</b> ●	<b>190365</b> ●
253	10	60	45	increasing	45	<b>190366</b> ●	<b>190367</b> ●
253	10	60	55	increasing	55	<b>190368</b>	<b>190369</b>

#### For mounting on flanged sleeve or quick clamping sleeve

HZ 210 2

D	SB	BO	Z	ZF	$v_f^*$	ID	ID
mm	mm	mm			$m\ min^{-1}$	LH	RH
250	10	80	35	decreasing	35	<b>190370</b>	<b>190371</b>
250	10	80	45	decreasing	45	<b>190372</b>	<b>190373</b>
250	10	80	55	decreasing	55	<b>190374</b>	<b>190375</b>
253	10	80	35	increasing	35	<b>190376</b>	<b>190377</b>
253	10	80	45	increasing	45	<b>190378</b>	<b>190379</b>
253	10	80	55	increasing	55	<b>190380</b>	<b>190381</b>

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.



### 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.



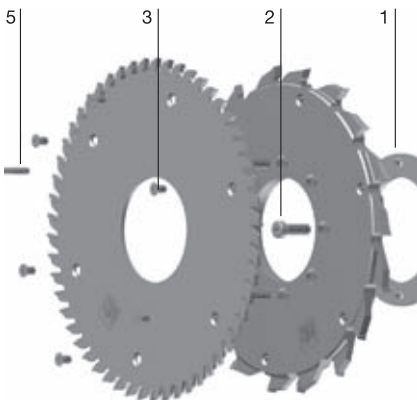
#### Basic hogger - steel tool body without flanged sleeve

WZ 210 2 01

BEZ	ABM mm	QAL	Z	ID LH	ID RH
Basic hogger	251x12x80	HW	18	<b>062602</b> ●	<b>062603</b> ●
Basic hogger	301x12x80	HW	24	<b>062604</b> ●	<b>062605</b> ●

#### Spare parts:

Part- no.	BEZ	ABM mm	BEM	ID
1	Spacer	115x5x80		<b>028046</b> ●
2	Cylindrical screw with ISK	M8x20		<b>005946</b> ●
3	Countersink screw, Torx® 20	M6x10	Torx® 20	<b>006083</b> ●
4	Screw with ISK	M8x17	for D = 250/350/305/355	<b>006237</b> ●
5	Allen key	SW 6		<b>005494</b> ●
6	Torx® key	Torx® 20		<b>117503</b> ●



#### Additional hogger - steel tool body

WZ 210 2 02

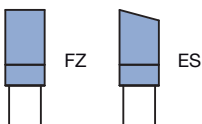
D mm	SB mm	BO mm	Z	QAL	ID LH	ID RH
251	12	80	18	HW	<b>062652</b> ●	<b>062653</b> ●
251	12	80	24	HW	<b>062654</b> ●	<b>062655</b> ●

#### Application:

Tear-free sizing along and across the grain for working against the feed only with a scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

#### Circular sawblade

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



D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	4.4	80	54	FZ	HW	<b>061825</b> ●	<b>061826</b> ●
250	4.4	80	54	ES	HW	<b>061837</b> ●	<b>061838</b> ●
250	4.4	80	72	FZ	HW	<b>061945</b> ●	<b>061946</b> ●
260	4.4	80	72	ES	HW	<b>061860</b> ●	<b>061861</b> ●
300	4.4	80	48	FZ	HW	<b>061827</b> ●	<b>061828</b> ●
300	4.4	80	48	ES	HW	<b>062028</b> ●	<b>062029</b> ●
300	4.4	80	72	FZ	HW	<b>061949</b> ●	<b>061950</b> ●



### 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:

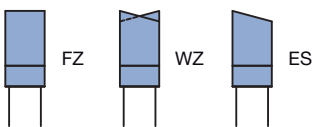
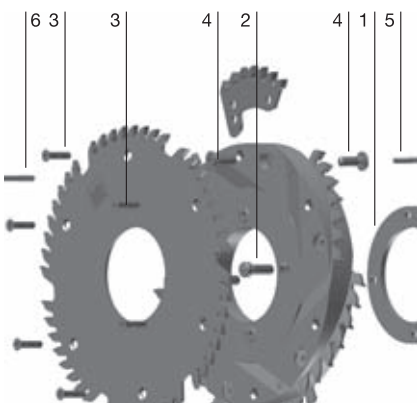
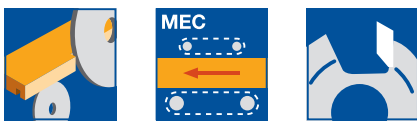
Double-end tenoners, finger joint machine with trimming aggregate, plug cutter.

#### Workpiece material:

All types of solid wood, chip and fibre boards (MDF etc.) raw, 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	<b>064410 ●</b>	<b>064411 ●</b>
300	31.5	30	6x9	FZ	HW	<b>064412 ●</b>	<b>064413 ●</b>
350	36.5	30	6x10	FZ	HW	<b>064414 ●</b>	<b>064415 ●</b>

#### Spare parts:

Part-no.	BEZ	ABM	BEM	ID
		mm		
1	Spacer	115x5x80		<b>028046 ●</b>
2	Cylindrical screw with ISK	M8x20		<b>005946 ●</b>
3	Countersink screw, Torx® 20	M6x10	Torx® 20	<b>006083 ●</b>
4	Screw with ISK	M8x17	for D = 250/350/305/355	<b>006237 ●</b>
5	Allen key	SW 6		<b>005494 ●</b>
6	Torx® key	Torx® 20		<b>117503 ●</b>

#### Spare circular sawblade for segment hogging set

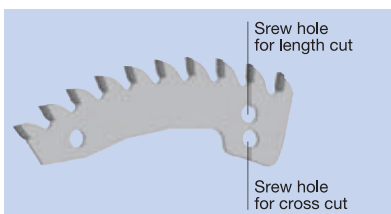
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	3.2	80	42	WZ	HW	<b>058219 ●</b>	<b>058220 ●</b>
250	4.4	80	48	FZ	HW	<b>061831 ●</b>	<b>061832 ●</b>
250	4.4	80	48	ES	HW	<b>061878 ●</b>	<b>061879 ●</b>
250	4.4	80	66	FZ	HW	<b>061953 ●</b>	<b>061954 ●</b>
260	4.4	80	48	ES	HW	<b>061963 ●</b>	<b>061964 ●</b>
260	4.4	80	66	ES	HW	<b>061965 ●</b>	<b>061966 ●</b>
300	4.4	30	42	FZ	HW	<b>061833 ●</b>	<b>061834 ●</b>
300	3.2	30	54	WZ	HW	<b>058221 ●</b>	<b>058222 ●</b>
300	4.4	30	66	FZ	HW	<b>061055 ●</b>	<b>061056 ●</b>
350	3.2	30	66	WZ	HW	<b>058223 ●</b>	<b>058224 ●</b>

#### Spare segments for segment hogger

TM 170 0

BEZ	ABM	SB	QAL	ZF	Z	ID	ID
	mm	mm				LH	RH
Hogging segment	D 250	5.7	HW	FZ	7	<b>064958 ●</b>	<b>064959 ●</b>
Hogging segment	D 300	5.7	HW	FZ	9	<b>064960 ●</b>	<b>064961 ●</b>
Hogging segment	D 350	5.7	HW	FZ	10	<b>064962 ●</b>	<b>064963 ●</b>



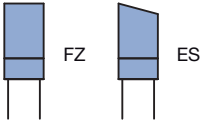
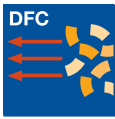
Spare segments for segment hogger



## 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	54	ES	HW	061858 ●	061859 ●
260	4.4	80	72	ES	HW	061860 ●	061861 ●

##### Circular sawblades:

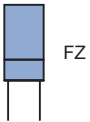
Tooth shape **ES** is optimised to cut across grain on softwood, hardwood, wood derived materials, veneered and paper coated and veneered composite materials.

##### 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

Type	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

Type	for D	SB	Z	ZF	QAL	ID	ID
	mm	mm				LH	RH
1	200/250	4	4	FZ	HW	064976 ●	064977 ●

Type 1 for Leuco.

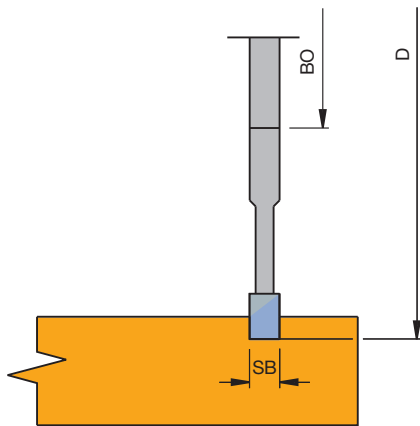
## 2. Panel processing

### 2.1 Edge processing

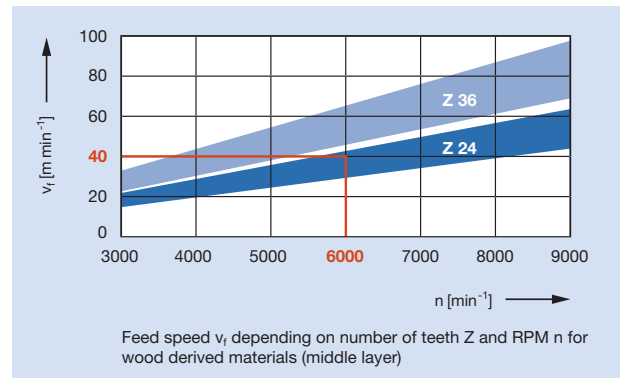
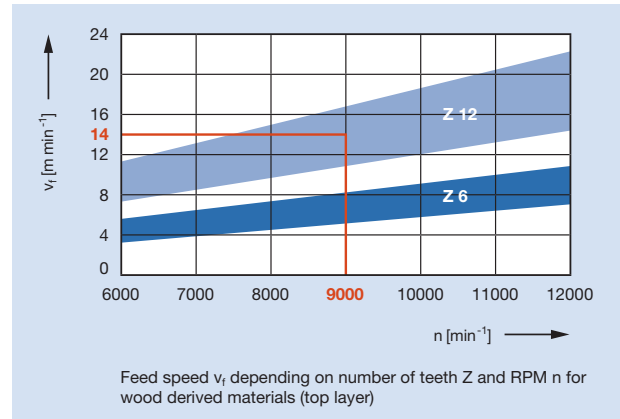
#### 2.1.5 Grooving cutters

##### Grooving with feed

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



Cutting rear panel grooves

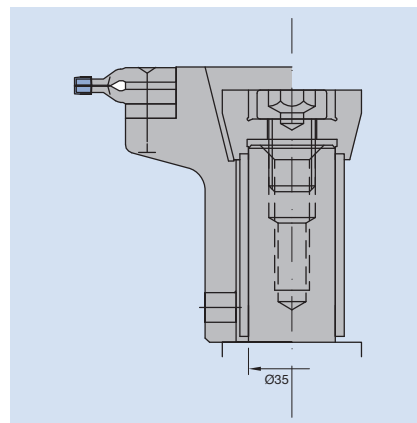


##### Grooving against feed

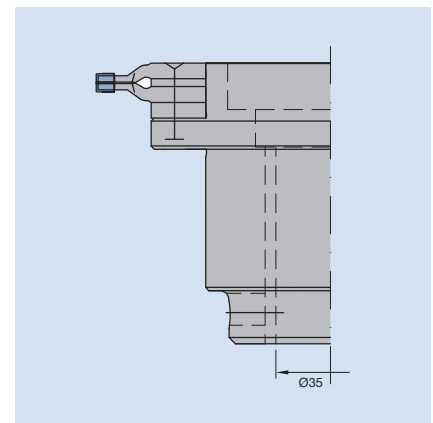
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

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<sup>-1</sup>. 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:**

For grooving with feed (MEC).

**Machine:**

Moulders and double- end tenoners.

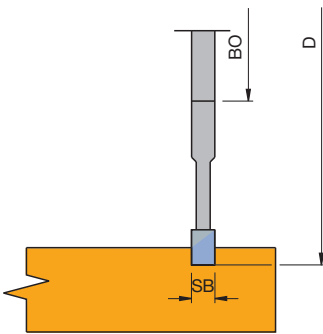
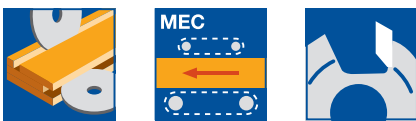
**Workpiece material:**

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

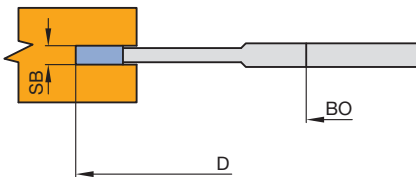
**Z 12**

WF 100 2 02

D	SB	TDI	BO	BO <sub>max</sub>	DKN	Z	n <sub>max</sub>	ID
mm	mm	mm	mm	mm	mm		min <sup>-1</sup>	
120	4.0	2.5	20	30	6x25.6	12	14200	020308 ●
120	5.0	3.5	20	30	6x25.6	12	14200	020309 ●
120	10.0	7.0	20	30	6x25.6	12	14200	020100 ●
125	1.5	0.8	30	50		12	13700	020145 ●
125	1.8	1.0	30	50		12	13700	020146 ●
125	2.0	1.2	30	50		12	13700	020147 ●
125	2.2	1.2	30	50		12	13700	020148 ●
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	9.0	6.5	30	50		12	13700	020195 ●
125	10.0	7.0	30	50		12	13700	020196 ●
150	3.0	2.0	30	60		12	11400	020154 ●
150	3.5	2.2	30	60		12	11400	020155 ●
150	4.0	2.5	30	60		12	11400	020156 ●
150	4.5	3.0	30	60		12	11400	020157 ●
150	5.0	3.5	30	60		12	11400	020158 ●
150	6.0	4.5	30	60		12	11400	020159 ●
150	7.0	5.0	30	60		12	11400	020160 ●
150	8.0	6.0	30	60		12	11400	020161 ●
150	9.0	6.5	30	60		12	11400	020162 ●
150	10.0	7.0	30	60		12	11400	020163 ●



Cutting the rear panel groove



Grooving the narrow side



#### Grooving cutter for mechanical feed

**Application:**

For grooving with feed (MEC).

**Machine:**

Moulders and double-end tenoners.

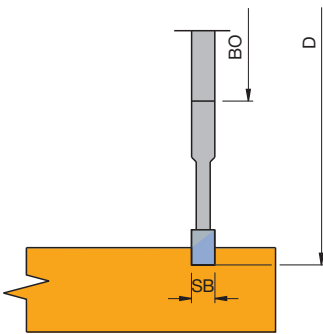
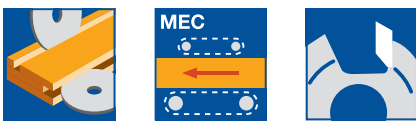
**Workpiece material:**

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

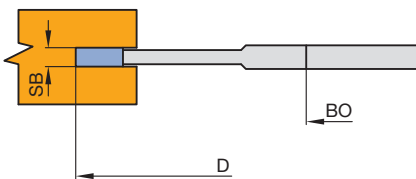
**Z 18**

WF 100 2 03

D mm	SB mm	TDI mm	BO mm	BO <sub>max</sub> mm	DKN mm	Z	$n_{max}$ min <sup>-1</sup>	ID
150	1.5	0.8	30	60		18	11400	020164 ●
150	1.8	1.0	30	60		18	11400	020165 ●
150	2.0	1.2	30	60		18	11400	020166 ●
150	2.2	1.2	30	60		18	11400	020167 ●
150	2.5	1.4	30	60		18	11400	020168 ●
150	3.0	2.0	30	60		18	11400	020169 ●
150	4.0	2.5	30	60		18	11400	020170 ●
150	5.0	3.5	30	60		18	11400	020171 ●
150	6.0	4.5	30	60		18	11400	020172 ●
150	8.0	6.0	30	60		18	11400	020173 ●
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	10.0	7.0	30	60		18	9500	020201 ●
200	2.0	1.2	35	80	10x45	18	8500	020299 ●
200	2.2	1.2	35	80	10x45	18	8500	020300 ●
200	2.5	1.4	35	80	10x45	18	8500	020301 ●
200	3.0	2.0	35	80	10x45	18	8500	020302 ●
200	4.0	2.5	35	80	10x45	18	8500	020303 ●
200	5.0	3.5	35	80	10x45	18	8500	020304 ●
200	6.0	4.5	35	80	10x45	18	8500	020305 ●
200	8.0	6.0	35	80	10x45	18	8500	020306 ●
200	10.0	7.0	35	80	10x45	18	8500	020307 ●



Cutting the rear panel groove



Grooving the narrow side



### Circular sawblade for end trim on edgebanding machines

#### Application:

For low noise edgebanding trim cuts.

#### Machine:

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

#### Workpiece material:

Softwood, hardwood, veneered, melamine and plastic edging.

#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

#### Veneered and plastic edging:

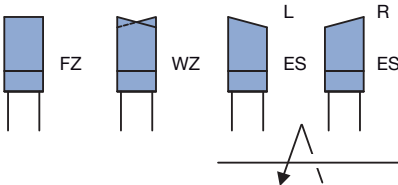
Edging thickness > 2.0 mm - crosscut saw ES pos.

Edging thickness < 2.0 mm - crosscut saw ES neg.

#### 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

SK 499 2, WK 101 2, WK 250 2, WK 300 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 350 2, WK 360 2, WK 360 2, WK 370 2, WK 372 2, WK 380 2, WK 380 2, WK 850 2

Machine	D mm	SB mm	BO mm	Z	ZF	n <sub>max</sub> min <sup>-1</sup>	ID	
							LH	RH
Biesse	115	3.2	52	30	ES pos.	19900	166421 ●	166420 ●
Biesse	115	3.2	56	30	ES pos.	19900	166423 ●	166422 ●
Biesse	130	3.6	30	24	ES pos.	17600	166425 ●	166424 ●
Biesse	140	3.2	30	36	ES pos.	16300	166426 ●	166427 ●
Biesse	160	3.2	20	48	WZ pos.	14300	166428 ●	166428 ●
Brandt	100	2.6	32	30	ES neg.	22900	166400 ●	166401 ●
Brandt	100	2.6	32	30	ES pos.	22900	166429 ●	166430 ●
Brandt	100	2.6	32	30	WZ pos.	22900	166431 ●	166431 ●
Brandt	110	2.4	32	40	ES pos.	20800	166432 ●	166433 ●
Brandt	125	2.4	32	24	WZ pos.	18300	166402 ●	166402 ●
Brandt	125	2.6	32	30	ES neg.	18300	166403 ●	166404 ●
Brandt	150	2.8	20	36	ES pos.	15200	166434 ●	166435 ●
Cehisa	100	3.0	32	30	ES pos.	22900	166436 ●	166437 ●
Felder	100	3.2	22	20	WZ pos.	22900	166438 ●	166438 ●
Fravol	100	3.2	22	24	ES pos.	22900	166407 ●	166406 ●
Fravol	100	3.2	30	24	ES pos.	22900	166408 ●	166409 ●
Fravol	125	3.2	22	30	ES pos.	18300	166411 ●	166410 ●
Hebrock/EBM	100	2.4	22	20	WZ neg.	22900	166405 ●	166405 ●
Holz-Her	110	3.6	22	16	ES	20800	166439 ●	166440 ●
Holz-Her	140	3.2	22	36	WZ pos.	16300	166441 ●	166441 ●
Holz-Her	160	3.2	20	48	WZ pos.	14300	166428 ●	166428 ●
Holz-Her	160	2.8	30	24	WZ pos.	14300	166442 ●	166442 ●
Homag	80	3.2	34	30	ES pos.	28600	166444 ●	166443 ●
* Homag	100	3.0	32	20	ES pos.	22900	166445 ●	166446 ●
Homag	100	3.0	32	20	ES pos.	22900	166448 ●	166447 ●
Homag	100	3.2	32	20	ES neg.	22900	166449 ●	166450 ●
Homag	100	3.6	32	20	WZ pos.	22900	166451 ●	166451 ●
Homag	100	2.6	32	30	ES pos.	22900	166429 ●	166430 ●
Homag	100	2.6	32	30	WZ pos.	22900	166431 ●	166431 ●
Homag	110	3.6	32	20	WZ pos.	20800	166452 ●	166452 ●
Homag	110	2.4	32	40	ES pos.	20800	166432 ●	166433 ●
Homag	110	1.7	40	30	FZ/TR pos.	20800	166453 ●	166453 ●
Homag	120	3.6	40	24	WZ pos.	19000	166419 ●	166419 ●
* Homag	120	3.2	40	30	ES pos.	19000	166454 ●	166455 ●
Homag	120	3.2	40	36	WZ pos.	19000	166456 ●	166456 ●
Homag	120	3.6	40	36	WZ pos.	19000	166457 ●	166457 ●
Homag	150	2.8	20	36	ES pos.	15200	166434 ●	166435 ●
Homag	150	3.5	30	40	ES pos.	15200	166459 ●	166458 ●
Homag	170	3.2	30	36	WZ pos.	13400	166412 ●	166412 ●
Homag	180	3.2	30	54	WZ pos.	12700	166460 ●	166460 ●
IDM	90	3.0	30	20	FZ pos.	25400	166461 ●	166461 ●
IMA	160	3.5	22	36	WZ neg.	14300	166462 ●	166462 ●
IMA	160	3.2	22	48	WZ neg.	14300	166414 ●	166414 ●
IMA	180	3.2	22	48	WZ pos.	12700	166463 ●	166463 ●

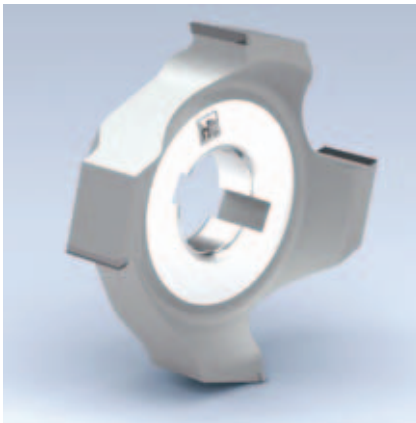
● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)

Machine	D	SB	BO	Z	ZF	$n_{\max}$ min <sup>-1</sup>	ID LH	ID RH
	mm	mm	mm					
IMA	180	3.2	22	48	WZ neg.	12700	<b>166464</b> ●	<b>166464</b> ●
IMA	200	3.2	30	64	WZ pos.	11400	<b>166465</b> ●	<b>166465</b> ●
IMA 08.415	180	3.5	22	42	WZ neg.	12700	<b>166415</b> ●	<b>166415</b> ●
IMA 08.492	160	3.0	22	36	WZ pos.	12700	<b>166413</b> ●	<b>166413</b> ●
Ott	140	3.2	16	36	WZ pos.	16300	<b>166466</b> ●	<b>166466</b> ●
Raimann	100	3.6	32	20	WZ pos.	22900	<b>166451</b> ●	<b>166451</b> ●
Raimann	120	3.2	32	20	WZ neg.	19000	<b>166467</b> ●	<b>166467</b> ●
SCM	115	3.2	30	30	WZ pos.	19900	<b>166416</b> ●	<b>166416</b> ●
SCM	150	3.8	35	24+6	ES pos.	15200	<b>166469</b> ●	<b>166468</b> ●
Türk Makine	140	3.2	30	36	ES pos.	16300	<b>166417</b> ●	<b>166418</b> ●
Wilmsmeyer	100	3.2	32	20	ES neg.	22900	<b>166449</b> ●	<b>166450</b> ●

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



### 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:**

Softwood, hardwood, veneer and plastic edgebander.

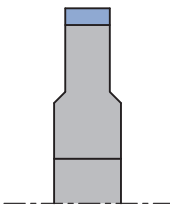
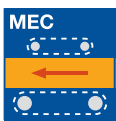
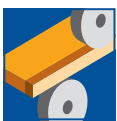
**Technical information:**

HW/DP tipped tools with cylindrical bore. DP tools - 3 mm tip height.

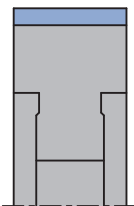
**Joining cutter**

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

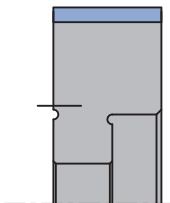
Machine	D mm	SB mm	ND mm	BO mm	Type	Z	QAL	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Biesse	70	10	12	16	DKN 1	6	DP	18000	090899 ●	090899 ●
Biesse	70	20	12	16	DKN 2	6	DP	18000	090893	090893
Biesse	80	22	12	16	DKN 3	6	DP	18000	192103 ●	192102 ●
Brandt	70	10	12	16	DKN 1	6	DP	18000	090899 ●	090899 ●
Brandt	70	20	12	16	DKN 2	6	DP	18000	090893	090893
Brandt	70	25	25	16	DKN 3	4	HW	18000	065588 ●	065589 ●
Fraval	80	30	27.5	20	DKN 3	4	DP	18000	192270 ●	192271 ●
Holz-Her 1828	70	19.5	19.5	20	DKN 4	4	HW	18000	065592	065593
Ott	70	16.5	10	16	DKN 3	4	DP	18000	192283 ●	192284 ●
Stefani	80	20	11	16	DKN 2	4	DP	18000	192110 ●	192111 ●



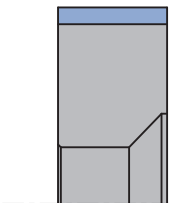
Type 1



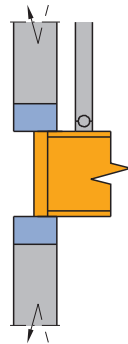
Type 2



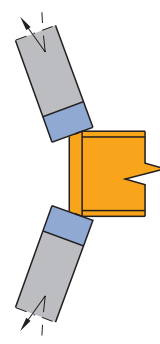
Type 3



Type 4



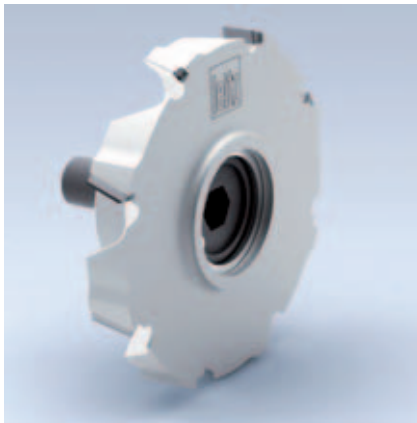
Trimming of edges on horizontal spindle  
- top motor tracing.



Bevelling of edges with inclined spindle.

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



#### Pre / finishing edge trimming cutter - *iQsystem*

**Application:**

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

**Machine:**

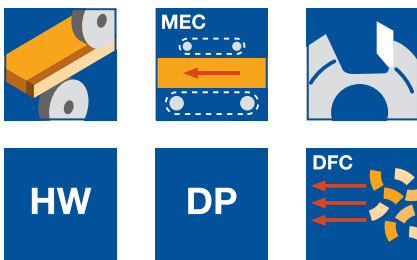
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

HW/DP tipped tools with HSK 25 R adaptor and a special extraction hood i-System for efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity.  
DP tools - 3 mm tip height.



#### Jointing cutter *iQsystem* - HSK 25 R

WF 200 2 DP, WF 210 2

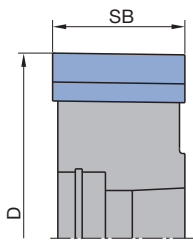
Machine	D	SB	BO	Z	QAL	$n_{\max}$ min <sup>-1</sup>	ID	ID
	mm	mm	mm				LH	RH
Homag, IMA	70	25	HSK 25 R	4	HW	18000	073092 ●	073093 ●
Homag, IMA	70	8	HSK 25 R	4	DP	18000	198472 ●	198473 ●
Homag, IMA	70	8	HSK 25 R	6	DP	18000	198474 ●	198475 ●
Homag, IMA	70	8	HSK 25 R	8	DP	18000	198404 ●	198405 ●
Homag, IMA	70	15	HSK 25 R	4	DP	18000	198406 ●	198407 ●
Homag, IMA	70	15	HSK 25 R	6	DP	18000	198468 ●	198469 ●

**Recommended number of teeth:**

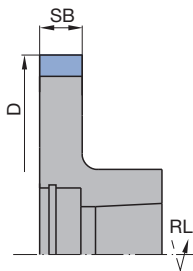
Feed rates of up to 35 m min<sup>-1</sup> Z 4

Feed rates of up to 60 m min<sup>-1</sup> Z 6

Feed rates of up to 100 m min<sup>-1</sup> Z 8 (thin edge)

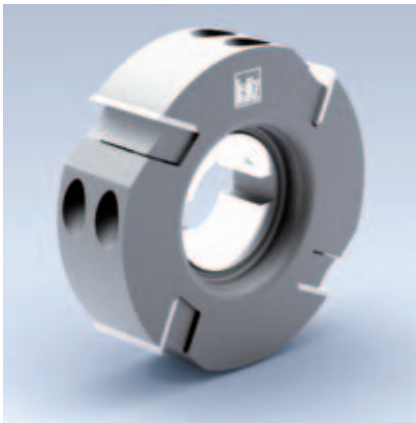


HW jointing cutter with HSK 25 R adaptor, SB-25 mm



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 side edgebanding machines.

**Workpiece material:**

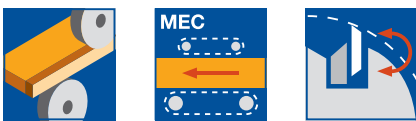
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

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

**Joining cutterhead**

WW 200 2, WW 200 2 06, WW 200 2 25



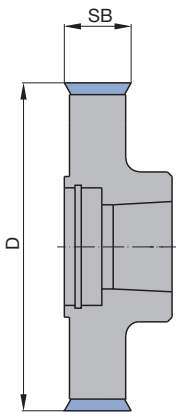
Machine	Type	D mm	SB mm	BO mm	Z	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Brandt	1	70	14.3	16 DKN	4	18000	025130 ●	025130 ●
Homag	1	70	14.3	HSK 25 R	4	12000	073599 ●	073600 ●
Homag	2	70	20	16 DKN	4	18000	025079 ●	025079 ●
Ott, Holz-Her	2	70	20	16	4	18000	025078	025078
Holz-Her 1962	2	80	40	30 KN	4	18000	024414 ●	024414 ●

**Spare knives:**

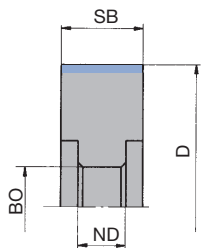
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	20x12x1.5	HW-05F	10	005083 ●
1	Turnblade knife	40x12x1.5	HW	10	602017 ●
5	Turnblade knife	14.3x14.3x2.5	HW	10	005426 ●

**Spare parts:**

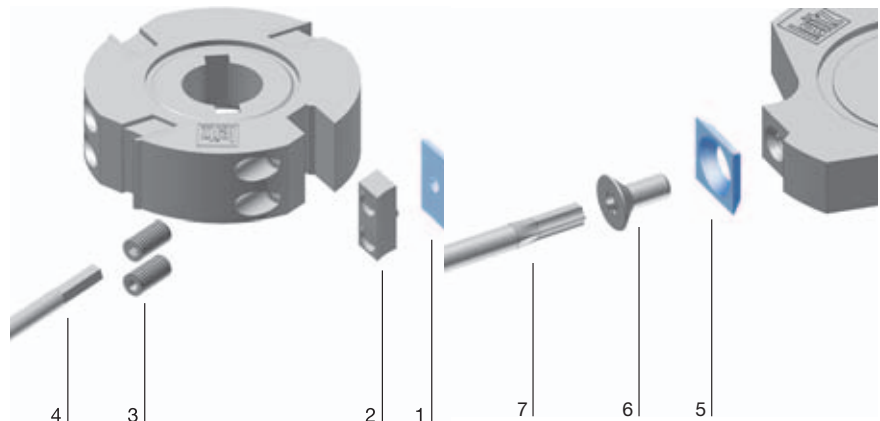
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with pin	18x11.5x7	005272 ●
3	Allen screw	M6x12	006035 ●
4	Allen key	SW 3	005444 ●
6	Countersink screw, Torx® 20	M5x12	006247 ●
7	Torx® key	Torx® 20	006091 ●

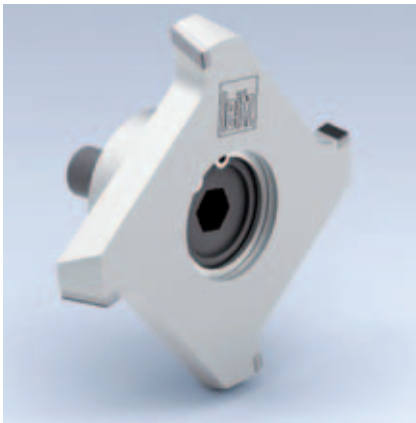


Type 1: WW 200 2 25



Type 2: WW 200 2 06





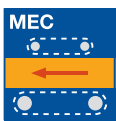
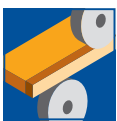
### Bevel cutter

**Application:**  
To bevel edgebandings.

**Machine:**  
Single or double-sided edgebanding machines.

**Workpiece material:**  
Softwood, hardwood, veneer and plastic edgebander.

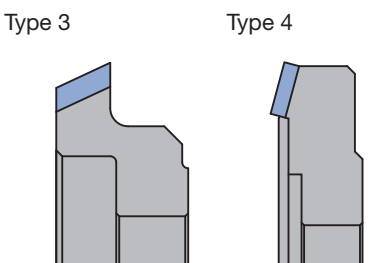
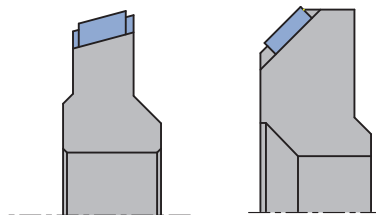
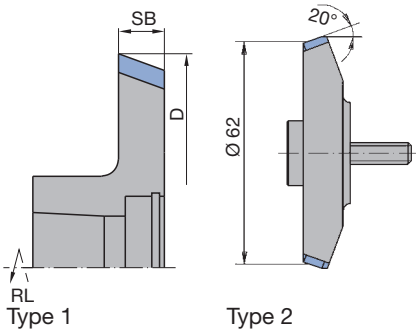
**Technical information:**  
DP tipped tools with cylindrical bore, HSK 25 R or HSK 32 adaptor for FK aggregates.  
DP tools - 3 mm tip height.

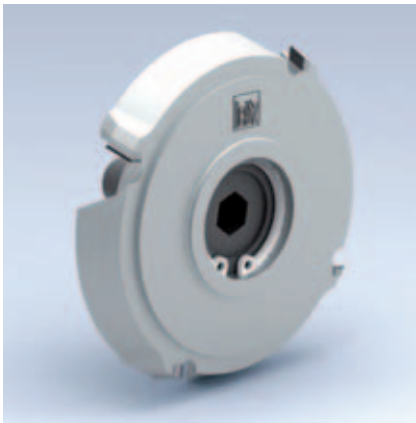


#### Various bevel angles - DP tipped

WF 300 2 DP, WF 350 2 DP

Machine	D	SB	BO	Type	Z	QAL	FAW	ID	ID
	mm	mm	mm				°	LH	RH
Biesse	67.2	9	16 DKN	5	6	DP	25°	091976	091975
Biesse	67.2	9	20 DKN	5	6	DP	25°	091970	091969
Biesse	68	9	16 DKN	5	6	DP	45°	091978	091977
Biesse	68	9	20 DKN	5	6	DP	45°	091972	091971
Biesse	80	10.5	16 DKN	6	4	DP	15°	091974	091973
Holz-Her 1825	52	6	16 DKN	3	2	DP	15°	091982	091981
Holz-Her 1832	53	8	16 DKN	3	3	DP	15°	091986	091985
Holz-Her 1832	56	5	16 DKN	3	3	DP	45°	091988	091987
Holz-Her 1833	72.5	8	20 DKN	4	4	DP	45°	091984	091983
Homag	62	5	HSK 32	2	4	DP	20°	091518	091519
Homag	62	5	HSK 32	2	6	DP	20°	091658	091659
Homag	62	5	HSK 32	2	6	DP	30°	091690	091691
Homag	62	5	HSK 32	2	6	DP	45°	091692	091693
Homag	75	8	HSK 25 R	1	4	DP	20°	091790	091791
IMA	75	8	HSK 25 R	1	4	DP	20°	091790	091791
Stefani	70	5	12 DKN	3	4	DP	20°	091980	091979





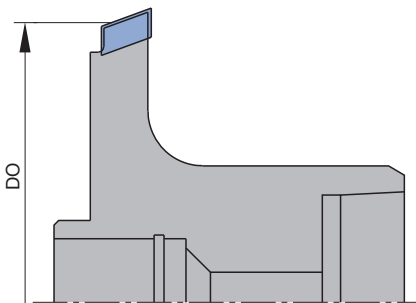
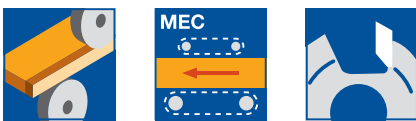
### Bevel cutter *iQ-system*

**Application:**  
To bevel edgebandings.

**Machine:**  
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

**Workpiece material:**  
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**  
DP tipped tools with HSK 25 R or HSK 32 adaptor for FK aggregates combined with special extraction hoods i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. Constant reference diameter.  
DP tools - 3 mm tip height.

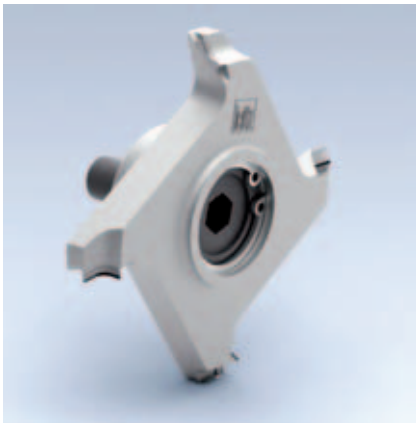


Bevel cutter with HSK 32 adaptor for FK aggregates

#### Various bevel angles *iQ-system* - Diamaster PRO

WF 350 2 DP

Machine	D <sub>0</sub> mm	SB mm	BO mm	Z	QAL	FAW °	NH mm	ID LH	ID RH
Homag	62	5	HSK 32	4	DP	20°	31.5	<b>198200</b> ●	<b>198201</b> ●
Homag	62	5	HSK 32	4	DP	45°	31.5	<b>198240</b> ●	<b>198241</b> ●
Homag	62	5	HSK 32	6	DP	20°	31.5	<b>198202</b> ●	<b>198203</b> ●
Homag	62	5	HSK 32	6	DP	45°	31.5	<b>198242</b> ●	<b>198243</b> ●
Homag	70	8	HSK 25 R	4	DP	20°	19.5	<b>198408</b> ●	<b>198409</b> ●
Homag	70	8	HSK 25 R	4	DP	45°	19.5	<b>198464</b> ●	<b>198465</b> ●
Homag	70	8	HSK 25 R	6	DP	20°	19.5	<b>198410</b> ●	<b>198411</b> ●
Homag	70	8	HSK 25 R	6	DP	45°	19.5	<b>198466</b> ●	<b>198467</b> ●
IMA	70	8	HSK 25 R	4	DP	20°	19.5	<b>198408</b> ●	<b>198409</b> ●
IMA	70	8	HSK 25 R	4	DP	45°	19.5	<b>198464</b> ●	<b>198465</b> ●
IMA	70	8	HSK 25 R	6	DP	20°	19.5	<b>198410</b> ●	<b>198411</b> ●
IMA	70	8	HSK 25 R	6	DP	45°	19.5	<b>198466</b> ●	<b>198467</b> ●



### Profile cutter

**Application:**

To round edgebandings.

**Machine:**

Single or double-sided edgebanding machines.

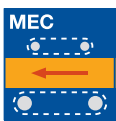
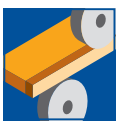
**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

DP tipped tools with cylindrical bore or HSK 25 R adaptor.  $D_0$  = constant reference diameter.

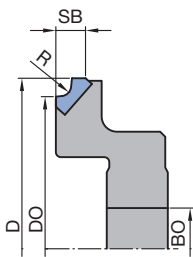
DP tools - 3 mm tip height.



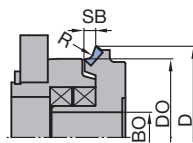
**Various radii**

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

Machine	D	$D_0$	BO	Z	QAL	R	Type	$n_{max}$	ID	ID
	mm	mm	mm			mm		$min^{-1}$	LH	RH
Biesse	67	60	16 DKN	6	DP	1.0	1	18000	091960 ●	091961 ●
Biesse	68	60	16 DKN	6	DP	2.0	1	18000	091962 ●	091963 ●
Biesse	70	60	16 DKN	6	DP	3.0	1	18000	091964 ●	091965 ●
Biesse	72	70	16 KN	6	DP	1.0	5	18000	192518 ●	192519 ●
Biesse	73	70	16 KN	6	DP	2.0	5	18000	192520 ●	192521 ●
Biesse	75	70	16 KN	6	DP	3.0	5	18000	192522 ●	192523 ●
** Brandt	58	50	16 DKN	4	DP	1.5	2	18000		192602 ●
* Brandt	58	50	16 DKN	4	DP	2.0	2	12000		091966 ●
** Brandt	58	50	16 DKN	4	DP	2.0	2	18000		192603 ●
Brandt	70	62	HSK 25 R	4	DP	1.0	7	18000	192588 ●	192589 ●
Brandt	70	62	HSK 25 R	4	DP	1.3	7	18000	192590 ●	192591 ●
Brandt	70	62	HSK 25 R	4	DP	1.5	7	18000	192592 ●	192593 ●
Brandt	70	62	HSK 25 R	4	DP	2.0	7	18000	192594 ●	192595 ●
Brandt	70	62	HSK 25 R	4	DP	3.0	7	18000	192596 ●	192597 ●



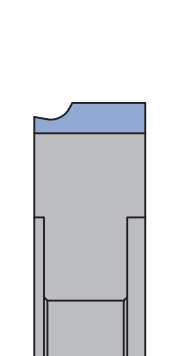
Type 1



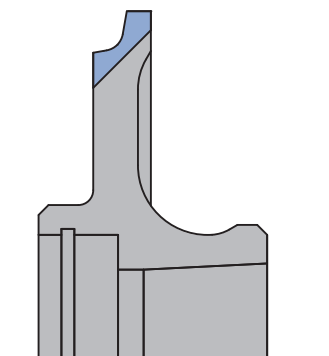
Type 2

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

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



Type 5

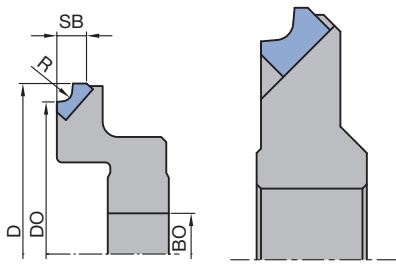


Type 7

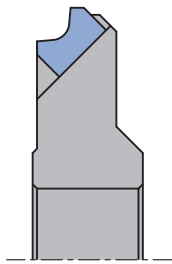
## 2. Panel processing

### 2.1 Edge processing

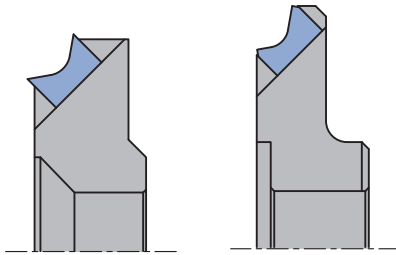
#### 2.1.7 Edge finishing tools



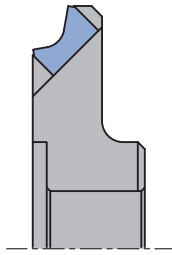
Type 1



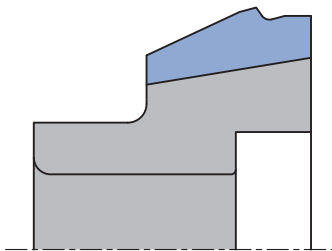
Type 3



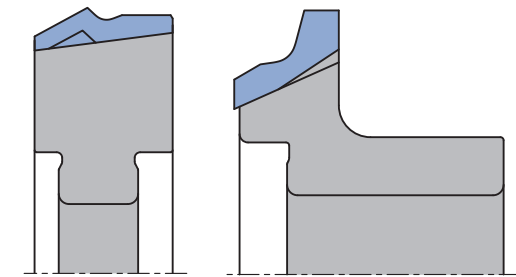
Type 4



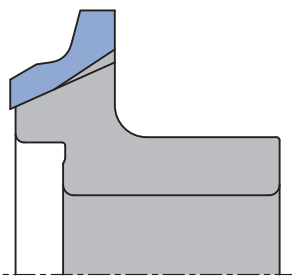
Type 6



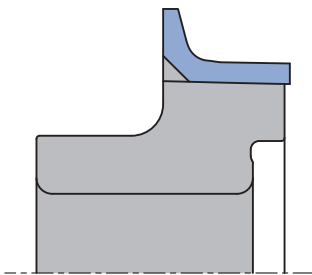
Type 8



Type 9



Type 10

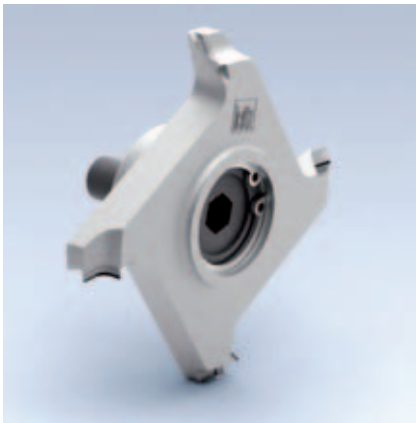


Type 11

#### Various radii

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

Machine	D	D <sub>0</sub>	BO	Z	QAL	R	Type	n <sub>max</sub>	ID	ID
	mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
Fravol	50	39.91	15 KN	4	DP	1-3	11	18000		<b>192665</b> ●
Fravol	50	40.1	15 KN	4	DP	1-3	10	18000	<b>192663</b> ●	<b>192664</b> ●
Fravol	50	39.91	15 KN	6	HW	1-3	11	18000		<b>065594</b> ●
Fravol	73	71.15	20 DKN	4	DP	1-3	8	18000	<b>192645</b> ●	<b>192646</b> ●
Fravol	76.8	74.71	20 DKN	4	DP	1-3	9	18000	<b>192647</b> ●	<b>192648</b> ●
Hebrock/EBM	32	24	14 DKN	2	DP	2.0	3	18000	<b>074526</b> ●	
Hebrock/EBM	56	49.7	16 DKN	2	DP	2.0	6	18000	<b>192669</b> ●	<b>192670</b> ●
Hebrock/EBM	56	49.7	16 DKN	2	DP	2.5	6	18000	<b>192641</b> ●	<b>192642</b> ●
Holz-Her 1825	57	50	16 DKN	2	DP	2.0	3	24000	<b>192536</b> ●	<b>192537</b> ●
Holz-Her 1825	57	50	16 DKN	2	DP	2.5	3	24000	<b>192538</b> ●	<b>192539</b> ●
Holz-Her 1825	57	50	16 DKN	2	DP	3.0	3	24000	<b>192540</b> ●	<b>192541</b> ●
Holz-Her 1827	56	50	20 DKN	2	DP	2.0	4	24000	<b>192506</b> ●	<b>192507</b> ●
Holz-Her 1827	56	50	20 DKN	2	DP	2.5	4	24000	<b>192508</b> ●	<b>192509</b> ●
Holz-Her 1827	57	50	20 DKN	2	DP	3.0	4	24000	<b>192510</b> ●	<b>192511</b> ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	2.0	3	24000	<b>192512</b> ●	<b>192513</b> ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	2.5	3	24000	<b>192514</b> ●	<b>192515</b> ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	3.0	3	24000	<b>192516</b> ●	<b>192517</b> ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2.0	4	18000	<b>192500</b> ●	<b>192501</b> ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2.5	4	18000	<b>192502</b> ●	<b>192503</b> ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	3.0	4	18000	<b>192504</b> ●	<b>192505</b> ●
Ott	69	61	16 DKN	3	DP	2.0	1	18000	<b>192649</b> ●	<b>192650</b> ●
Ott	69	61	16 DKN	4	DP	2.0	1	18000	<b>192651</b> ●	<b>192652</b> ●
Stefani	51.5	49.71	16 DKN	4	HW	1.0	8	18000	<b>192657</b> ●	<b>192658</b> ●
Stefani	51.5	49.71	16 DKN	4	HW	1.5	8	18000	<b>192659</b> ●	<b>192660</b> ●
Stefani	51.5	49.71	16 DKN	4	HW	2.0	8	18000	<b>192661</b> ●	<b>192662</b> ●
Stefani	70	60	16 DKN	4	DP	1.0	6	18000	<b>192524</b> ●	<b>192525</b> ●
Stefani	70	60	16 DKN	4	DP	2.0	6	18000	<b>192526</b> ●	<b>192527</b> ●
Stefani	70	60	16 DKN	4	DP	3.0	6	18000	<b>192528</b> ●	<b>192529</b> ●
Törk Makine	46	39	16	4	DP	2.0	3	18000	<b>192643</b> ●	<b>192644</b> ●



### Profile cutter

**Application:**

To round (profile) edgebandings on FK aggregate.

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

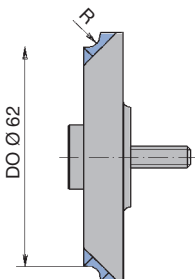
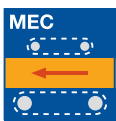
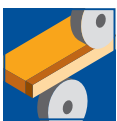
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

DP tipped tools with HSK 32 adaptor for FK-aggregates. High concentricity.

$D_0$  = constant reference diameter.

DP tools - 3 mm tip height.

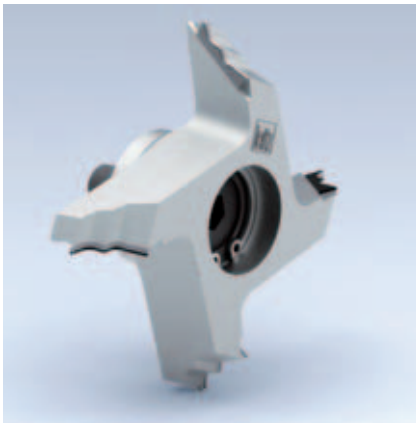


Type 1

**Various radii - Diamaster PRO, FK aggregate, HSK 32**

WF 501 2 DP

Machine	$D_0$ mm	BO mm	Z	QAL	R mm	Type	$n_{max}$ $min^{-1}$	ID LH	ID RH
Homag	62	HSK 32	4	DP	1.0	1	18000	<b>091500</b> <input type="checkbox"/>	<b>091501</b> <input type="checkbox"/>
Homag	62	HSK 32	4	DP	1.5	1	18000	<b>091502</b> <input type="checkbox"/>	<b>091503</b> <input type="checkbox"/>
Homag	62	HSK 32	4	DP	2.0	1	18000	<b>091504</b> <input type="checkbox"/>	<b>091505</b> <input type="checkbox"/>
Homag	62	HSK 32	4	DP	2.5	1	18000	<b>091506</b> <input type="checkbox"/>	<b>091507</b> <input type="checkbox"/>
Homag	62	HSK 32	4	DP	3.0	1	18000	<b>091508</b> <input type="checkbox"/>	<b>091509</b> <input type="checkbox"/>
Homag	62	HSK 32	6	DP	1.0	1	18000	<b>091672</b>	<b>091673</b>
Homag	62	HSK 32	6	DP	1.5	1	18000	<b>091674</b>	<b>091675</b>
Homag	62	HSK 32	6	DP	2.0	1	18000	<b>091650</b>	<b>091651</b>
Homag	62	HSK 32	6	DP	2.5	1	18000	<b>091676</b>	<b>091677</b>
Homag	62	HSK 32	6	DP	3.0	1	18000	<b>091652</b>	<b>091653</b>



#### Profile cutter

**Application:**

For a choice of radii or bevels on edgebandings.

**Machine:**

Single or double-sided edgebanding machines.

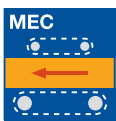
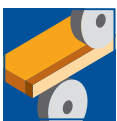
**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

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°.  $D_0$  = constant reference diameter.

DP tools - 0.5 mm resharpening area.

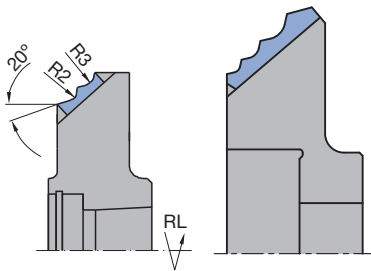


#### Multi-profile cutter - Diamaster PRO

WF 501 2, WF 501 2 DP

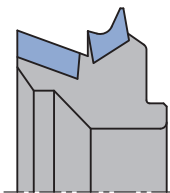
Machine	D mm	$D_0$ mm	BO mm	Type	Z	R mm	FAW °	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Biesse	75.4	60	16 DKN	2	6	1 / 2 / 3	25°	18000	091996 ●	091995 ●
Brandt	78	57.3	16 DKN	2	4	1.2 / 2 / 3	15°	18000	091967 ●	091968 ●
Holz-Her 1826	58	50	20 DKN	3	2	2		18000	192530 ●	192531 ●
Holz-Her 1826	58	50	20 DKN	3	2	2.5		18000	192532 ●	192533 ●
Holz-Her 1826	58	50	20 DKN	3	2	3		18000	192534 ●	192535 ●
Homag	85	65.2	HSK 25 R	1	4	2 / 3	20°	18000	091798 ●	091799 ●
IMA	85	65.2	HSK 25 R	1	4	2 / 3	20°	18000	091798 ●	091799 ●
Stefani	74.5	63.88	HSK 25 R	4	4	1 / 1.5 / 2	20°	18000	192655 ●	192656 ●
Stefani	74.5	63.88	HSK 25 R	1	4	1 / 1.5 / 2	20°	18000	192653 ●	192654 ●

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

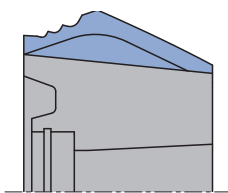


Type 1

Type 2



Type 3



Type 4

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



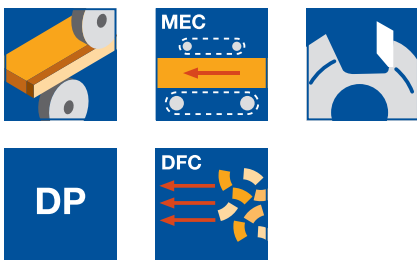
#### Profile cutter *iQsystem*

**Application:**  
To round edgebandings.

**Machine:**  
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

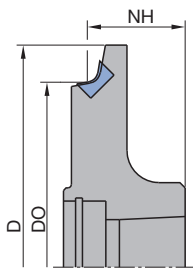
**Workpiece material:**  
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**  
DP tipped tools with HSK 25 R adaptor and special extraction hoods i-System for efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter. DP tools - 3 mm tip height.

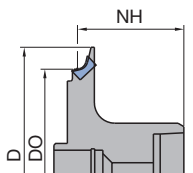


#### Various radii *iQsystem* - Diamaster PRO, HSK 25 R WF 501 2 DP

Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm			mm	min <sup>-1</sup>	LH	RH
Homag, IMA 76	70	70	17.5	HSK 25 R	4	DP	1.0	18000	198494 ●	198484 ●
Homag, IMA 76	70	70	17.5	HSK 25 R	4	DP	1.5	18000	198495 ●	198485 ●
Homag, IMA 76	70	70	18.5	HSK 25 R	4	DP	2.0	18000	198496 ●	198486 ●
Homag, IMA 78	70	70	19	HSK 25 R	4	DP	2.5	18000	198497 ●	198487 ●
Homag, IMA 78	70	70	19.5	HSK 25 R	4	DP	3.0	18000	198498 ●	198488 ●
Homag, IMA 76	70	70	17.5	HSK 25 R	6	DP	1.0	18000	198499 ●	198489 ●
Homag, IMA 76	70	70	17.5	HSK 25 R	6	DP	1.5	18000	198500 ●	198490 ●
Homag, IMA 76	70	70	18.5	HSK 25 R	6	DP	2.0	18000	198501 ●	198491 ●
Homag, IMA 78	70	70	19	HSK 25 R	6	DP	2.5	18000	198502 ●	198492 ●
Homag, IMA 78	70	70	19.5	HSK 25 R	6	DP	3.0	18000	198503 ●	198493 ●



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 R adaptor for FK aggregates

**Application:**  
To round (profile) edgebandings on FK aggregate.

**Technical information:**  
DP tipped tools with HSK 32 adaptor for FK aggregates with special extraction hoods i-System for highly efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter. DP tools - 3 mm tip height.

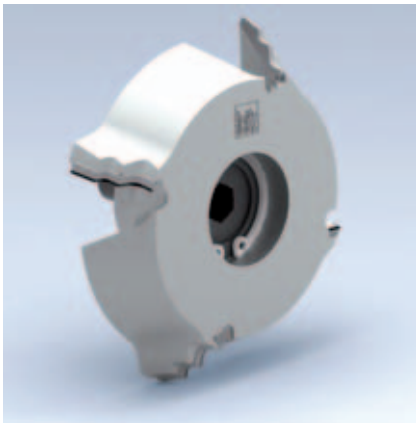
#### Various radii *iQsystem* - Diamaster PRO, FK aggregate, HSK 32 WF 501 2 DP

Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm			mm	min <sup>-1</sup>	LH	RH
Homag	75	62	31.5	HSK 32	4	DP	1.0	18000	198212 ●	198213 ●
Homag	75	62	31.5	HSK 32	4	DP	1.5	18000	198214 ●	198215 ●
Homag	75	62	31.5	HSK 32	4	DP	2.0	18000	198216 ●	198217 ●
Homag	75	62	31.5	HSK 32	4	DP	2.5	18000	198220 ●	198221 ●
Homag	75	62	31.5	HSK 32	4	DP	3.0	18000	198222 ●	198223 ●
Homag	75	62	31.5	HSK 32	6	DP	1.0	18000	198246 ●	198247 ●
Homag	75	62	31.5	HSK 32	6	DP	1.5	18000	198244 ●	198245 ●
Homag	75	62	31.5	HSK 32	6	DP	2.0	18000	198218 ●	198219 ●
Homag	75	62	31.5	HSK 32	6	DP	2.5	18000	198238 ●	198239 ●
Homag	75	62	31.5	HSK 32	6	DP	3.0	18000	198224 ●	198225 ●



## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



#### Profile cutter *iQsystem*

**Application:**

For a choice of radii or bevels on edgebandings.

**Machine:**

Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

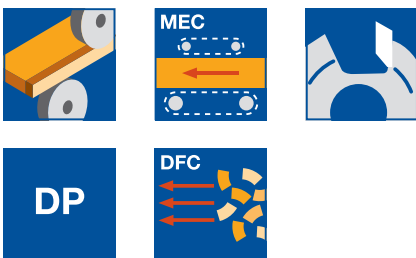
**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Profile combination of routing with e.g. radii of 2.0 and 3.0 mm and bevel 20°. High concentricity.

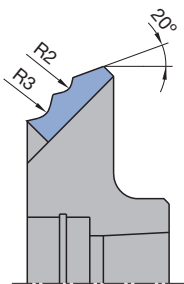
DP tools - 3 mm tip height.



#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R

WF 501 2 DP

Machine	D	D <sub>0</sub>	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm			mm	°	LH	RH
Homag, IMA	85	62	HSK 25 R	4	DP	2 / 3	20°	198444 ●	198445 ●
Homag, IMA	85	62	HSK 25 R	4	DP	1.5 / 2	20°	198504 ●	198505 ●
Homag, IMA	85	62	HSK 25 R	6	DP	2 / 3	20°	198456 ●	198457 ●



Multi-profile cutter i-System

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 cutter *iQsystem*

**Application:**

For a choice of radii and bevels on edgebandings. Corner rounding on leading and trailing edges and radius/bevel on top/bottom edges.

**Machine:**

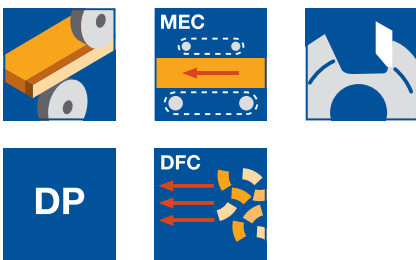
IMA edgebanding machine with KFA aggregates.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

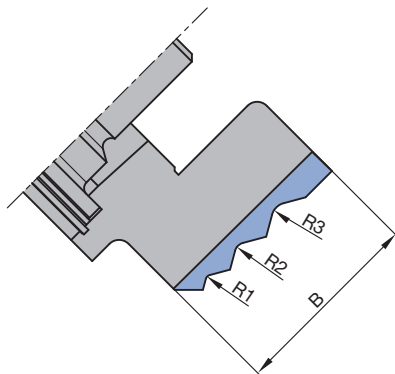
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. 3 mm tip height. Constant diameters. Low noise.



#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R, KFA aggregate WF 502 2 DP

Machine	D mm	B mm	BO mm	Z	R	FAW °	ID LH	ID RH
IMA Multiprofiler	75	30	HSK 25 R	6	1/2/3	15°	091916 ●	091917 ●
IMA Multiprofiler	75	30	HSK 25 R	6	1/1.5/2	20°	091922 ●	091923 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/2/3	15°	091912 ●	091913 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/1.5/2	20°	091924 ●	091925 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/2/3	45°	091926 ●	091927 ●

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 cutter *iQsystem*

**Application:**

For a choice of radii and bevels on edgebandings. Corner rounding on leading and trailing edges and radius/bevel on top/bottom edges.

**Machine:**

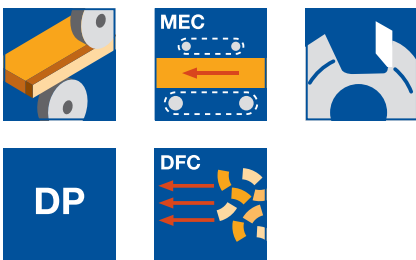
IMA edgebanding machines with MFA aggregates.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

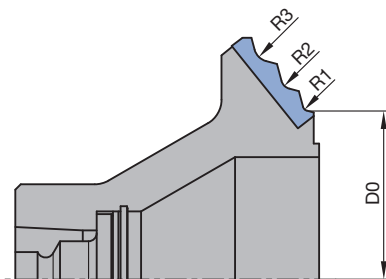
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. 3 mm tip height. Constant diameters. Low noise.



**Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R, MFA aggregates  
WF 502 2 DP**

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
IMA	89	62	HSK 25 R	6	1/2	15°	091918 ●	091919 ●
IMA	89	57	HSK 25 R	6	1/2/3	15°	091920 ●	091921 ●

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 cutter *IQsystem*

**Application:**

To round (profile trim) edgebandings on FK31 aggregates.

**Machine:**

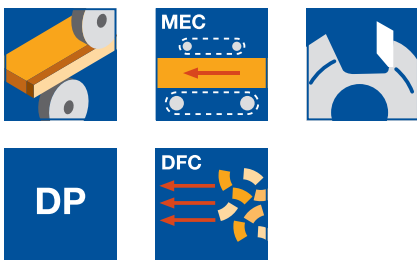
Homag edgebanding machines with profile FK31 trimming aggregate.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

DP tipped tools with bore for mounting as set on the tool adaptor. DFC design for highly efficient chip clearance of more than 97%.  $D_0$  = constant reference diameter. Low noise DP tool - 3 mm tip height. Maximum concentricity.



**Diamaster PRO, FK31 aggregate - Tool 1 fixed**

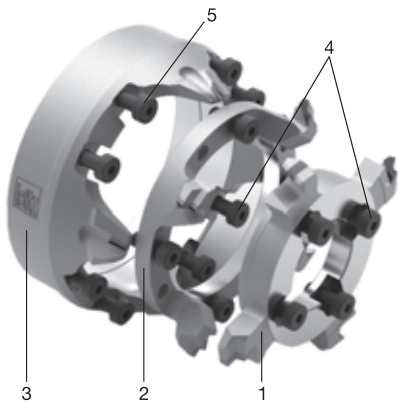
WF 501 2 DP

Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	1	88	80.1	46	4	DP	1.5	18000	192558 ●	192559 ●
Homag	1	88	80.1	46	4	DP	2.0	18000	192556 ●	192557 ●
Homag	1	88	80.1	46	4	DP	2.2	18000	192580 ●	192581 ●
Homag	1	88	80.1	46	4	DP	2.5	18000	192554 ●	192555 ●
Homag	1	88	80.1	46	4	DP	3.0	18000	192552 ●	192553 ●

**Diamaster PRO, FK31 aggregate - Tool 2 moveable**

WF 501 2 DP

Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	FAW °	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	2	87	80.1	55	4	DP	1.0		18000	192568 ●	192569 ●
Homag	2	87	80.1	55	4	DP	1.5		18000	192566 ●	192567 ●
Homag	2	87	80.1	55	4	DP	1.7		18000	192582 ●	192583 ●
Homag	2	87	80.1	55	4	DP	2.0		18000	192564 ●	192565 ●
Homag	2	87	80.1	55	4	DP	2.5		18000	192562 ●	192563 ●
Homag	2	87	80.1	55	4	DP	3.0		18000	192560 ●	192561 ●
Homag	2	87	80.1	55	4	DP		45°	18000	192112 ●	192113 ●
Homag	2	87	80.1	55	4	DP		30°	18000	192123 ●	192124 ●
Homag	2	87	80.1	55	4	DP		20°	18000	192114 ●	192115 ●



**Diamaster PRO, FK31 aggregate - Tool 3 moveable**

WF 300 2 DP, WF 501 2 DP

Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	FAW °	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	3	92	80.1	73	4	DP	1.0		18000	192574 ●	192575 ●
Homag	3	92	80.1	73	4	DP	1.5		18000	192572 ●	192573 ●
Homag	3	92	80.1	73	4	DP	1.7		18000	192584 ●	192585 ●
Homag	3	92	80.1	73	4	DP	2.0		18000	192570 ●	192571 ●
Homag	3	92	80.1	73	4	DP		15°	18000	091520 ●	091521 ●
FK 31 PowerTrim											
Homag	3	92	80.1	73	4	DP		20°	18000	192118 ●	192119 ●
Homag	3	92	80.1	73	4	DP		30°	18000	192125 ●	192126 ●
Homag	3	92	80.1	73	4	DP		45°	18000	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 ●
	Allen key	SW 3	005444 ●

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:

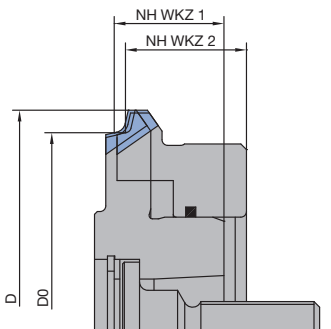
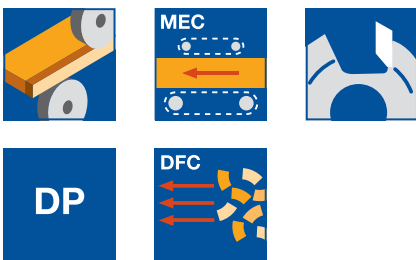
Homag edgebanding machines for cutting units types FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

#### Workpiece material:

Softwood, hardwood, veneer and plastic edgebander.

#### Technical information:

2 part DP composite tool for setwise application. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and quiet running.  $D_0$  = constant reference diameter, RPM  $n_{max} = 18,000 \text{ min}^{-1}$ .



#### Multi-profile cutterset flexTrim - Diamaster PRO

SF 542 2 15

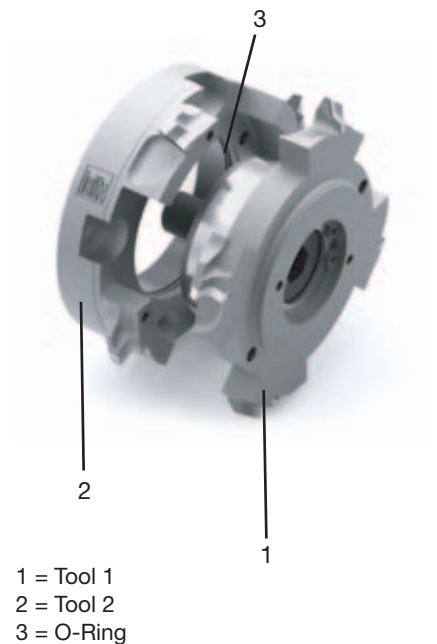
Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	19.5	HSK 25 R	4	DP	1.5/1.0		194300 ●	194301 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.0		194302 ●	194303 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.5		194304 ●	194305 ●
Homag	78	70	19.5	HSK 25 R	4	DP	3.0/2.0		194306 ●	194307 ●
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
3	2	O-Ring	mm 40x1.78 NBR70	118300 ●





### Profile cutter Quattro<sup>Form</sup>

#### Application:

For multi-profile cutting with radii and bevelling of edges.

#### Machine:

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

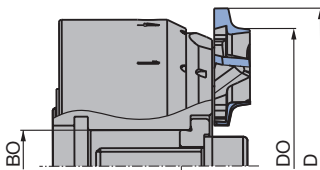
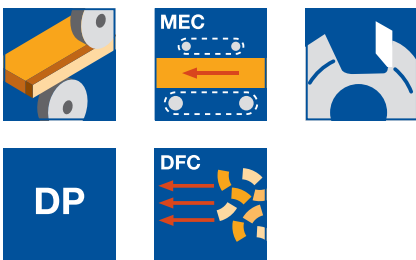
#### Workpiece material:

Softwood, hardwood, veneer and plastic edgebander.

#### Technical information:

DP composite tool with 4 profiles and mounting screw. Profiles automatically adjustable by the machine control. Patented system.

$D_0$  = constant reference diameter, RPM  $n = 18,000 \text{ min}^{-1}$ .

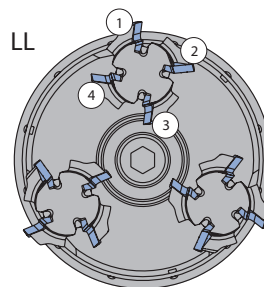


### Multi-profile cutter Quattro<sup>Form</sup> - Diamaster PRO

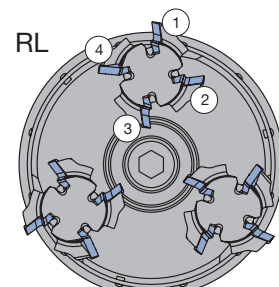
SF 540 2 10

Machine	D	$D_0$	BO	Z	R	FAW	ID	ID
	mm	mm	mm		mm	°	LH	RH
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2	45°	194001 ●	194000 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	45°	194003 ●	194002 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	10°	194005 ●	194004 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3	45°	194007 ●	194006 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.5/1	45°	194009 ●	194008 ●
Holz-Her FF 701 Multi	70	61	16	3	0.8/1/1.3	45°	194011 ●	194010 ●

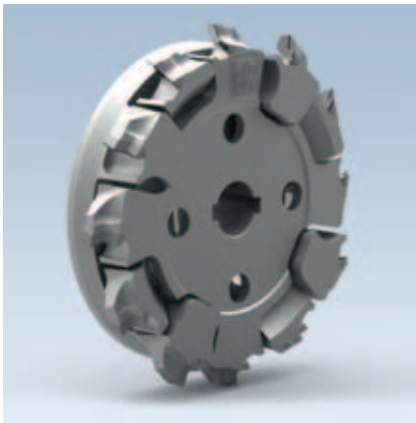
All tools and further profile variants are available in various dimensions from blanks at short notice. Profile radius maximum 3 mm.



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194001	5043200
R3	R1.3	R2	F45°	194003	5044921
R3	R1.3	R2	F10°	194005	5046609
R2	R1.3	R3	F45°	194007	5048079
R2	R1,5	R1	F45°	194009	
R0,8	R1	R1,3	F45°	194011	5050821



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194000	5043199
R3	R1.3	R2	F45°	194002	5044920
R3	R1.3	R2	F10°	194004	5046608
R2	R1.3	R3	F45°	194006	5048078
R2	R1,5	R1	F45°	194008	
R0,8	R1	R1,3	F45°	194010	5050822



### Profile cutter Multi-Edge

**Application:**

For multi-profile cutting with radii and bevelling of edges.

**Machine:**

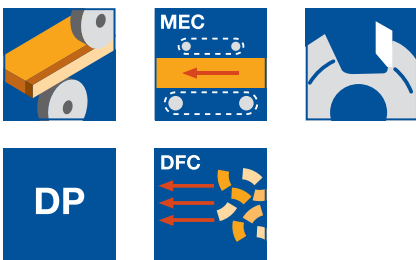
Stefani.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

DP composite tool with bore holes for setwise assembling on machine side adaptor. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and quiet running.  $D_0$  = constant reference diameter, RPM  $n_{max} = 18,000 \text{ min}^{-1}$ .



**Diamaster PRO - Tool 1 fixed**

WF 501 2 16

Machine	D	$D_0$	BO	Z	QAL	R	$n_{max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	10 DKN	4	DP	1.0	18000	<b>192606</b> ●	<b>192605</b> ●
Stefani	68	61.7	10 DKN	4	DP	1.3	18000	<b>192608</b> ●	<b>192607</b> ●
Stefani	68	61.7	10 DKN	4	DP	1.5	18000	<b>192610</b> ●	<b>192609</b> ●
Stefani	68	61.7	10 DKN	4	DP	2.0	18000	<b>192612</b> ●	<b>192611</b> ●
Stefani	68	61.7	10 DKN	4	DP	2.5	18000	<b>192614</b> ●	<b>192613</b> ●
Stefani	68	61.7	10 DKN	4	DP	3.0	18000	<b>192616</b> ●	<b>192615</b> ●

**Diamaster PRO - Tool 2 movable**

WF 501 2 16

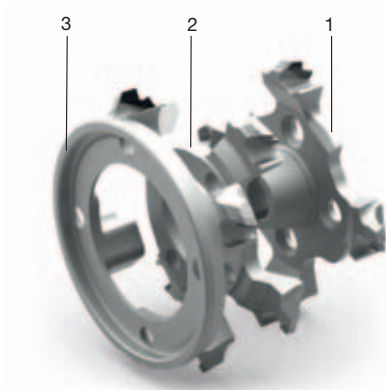
Machine	D	$D_0$	BO	Z	QAL	R	$n_{max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	23	4	DP	1.0	18000	<b>192618</b> ●	<b>192617</b> ●
Stefani	68	61.7	23	4	DP	1.3	18000	<b>192620</b> ●	<b>192619</b> ●
Stefani	68	61.7	23	4	DP	1.5	18000	<b>192622</b> ●	<b>192621</b> ●
Stefani	68	61.7	23	4	DP	2.0	18000	<b>192624</b> ●	<b>192623</b> ●
Stefani	68	61.7	23	4	DP	2.5	18000	<b>192626</b> ●	<b>192625</b> ●
Stefani	68	61.7	23	4	DP	3.0	18000	<b>192628</b> ●	<b>192627</b> ●

**Diamaster PRO - Tool 3 movable**

WF 501 2 16

Machine	D	$D_0$	BO	Z	QAL	R	$n_{max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	38	4	DP	1.0	18000	<b>192672</b> ●	<b>192671</b> ●
Stefani	68	61.7	38	4	DP	1.3	18000	<b>192632</b> ●	<b>192631</b> ●
Stefani	68	61.7	38	4	DP	1.5	18000	<b>192634</b> ●	<b>192633</b> ●
Stefani	68	61.7	38	4	DP	2.0	18000	<b>192636</b> ●	<b>192635</b> ●
Stefani	68	61.7	38	4	DP	2.5	18000	<b>192638</b> ●	<b>192637</b> ●
Stefani	68	61.7	38	4	DP	3.0	18000	<b>192640</b> ●	<b>192639</b> ●

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



- 1 = Tool 1
- 2 = Tool 2
- 3 = Tool 3



### Profile cutterhead / bevel cutterhead

**Application:**

To round edgebandings.

**Machine:**

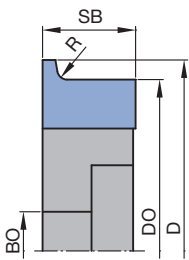
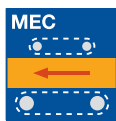
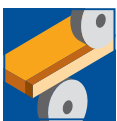
Single or double-sided edgebanding machines.

**Workpiece material:**

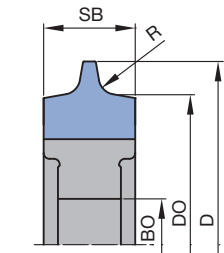
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

Cutterheads with HW knives and cylindrical bore with DKN. The same cutterhead tool body for R 1.5 to 3.0 mm.  $D_0$  = constant reference diameter.



Type 1



Type 2

**Various radii - Brandt**

WE 500 2

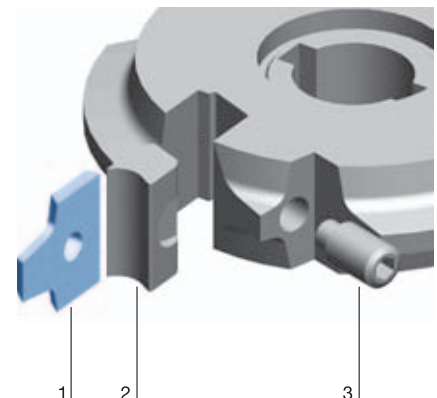
Machine	D	D <sub>0</sub>	SB	BO	Z	R	Type	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm		mm		min <sup>-1</sup>	LH	RH
Brandt	56	50	16	16 DKN	4	2	1	18000	075006	075005
Brandt	58	50	12	16 DKN	4	3	2	18000	075004	075004
Brandt	78	70	19	16 DKN	4	3	1	18000	075003	075002
Brandt	82	70	16	16 DKN	4	2	2	18000	075009	075009

**Spare knives:**

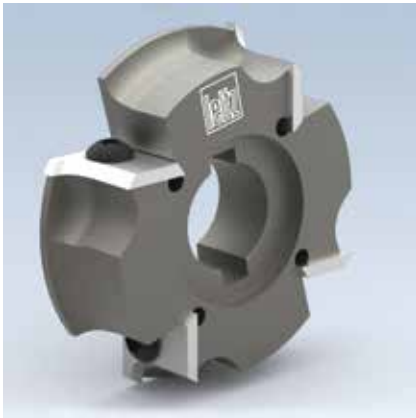
Part-no.	Type	BEZ	ABM	QAL	R	VE	ID	ID
			mm		mm	PCS	LH	RH
1	1	Exchange knife	16x13.4x2	HW	1.5	10	075325	075324
1	1	Exchange knife	16x13.4x2	HW	2.0	10	075327	075326
1	1	Exchange knife	16x13.4x2	HW	3.0	10	075329	075328
1	1	Exchange knife	19.6x15.2x2	HW	1.5	10	075334	075333
1	1	Exchange knife	19.6x15.2x2	HW	2.0	10	075336	075335
1	1	Exchange knife	19.6x15.2x2	HW	2.5	10	075338	075337
1	1	Exchange knife	19.6x15.2x2	HW	3.0	10	075303	075302
1	2	Exchange knife	12x13x2	HW	1.5	10	075339	075339
1	2	Exchange knife	12x13x2	HW	2.0	10	075330	075330
1	2	Exchange knife	12x13x2	HW	3.0	10	075304	075304
1	2	Exchange knife	16x17.5x2	HW	1.5	10	009539	009539
1	2	Exchange knife	16x17.5x2	HW	2.0	10	005132	005132
1	2	Exchange knife	16x17.5x2	HW	3.0	10	005133	005133

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge	10x11.5x7	075400
2	Clamping wedge	10x10.9x7	075403
2	Clamping wedge	13.5x11x7	075404
2	Clamping wedge	19	075401
2	Clamping wedge	19	075402
3	Allen screw	M6x12	006035
	Allen key	SW 3	005444
	Setting gauge for knives	1.0	005372







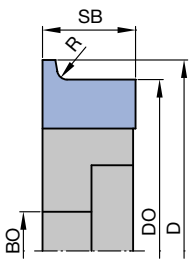
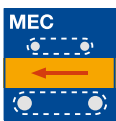
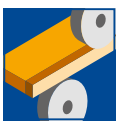
### Profile cutterhead / bevel cutterhead

**Application:**  
To round edgebandings.

**Machine:**  
Single or double-sided edgebanding machines.

**Workpiece material:**  
Softwood, hardwood, veneer and plastic 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.



Type 1

#### Various radii - Hebrock/EBM

WE 500 2

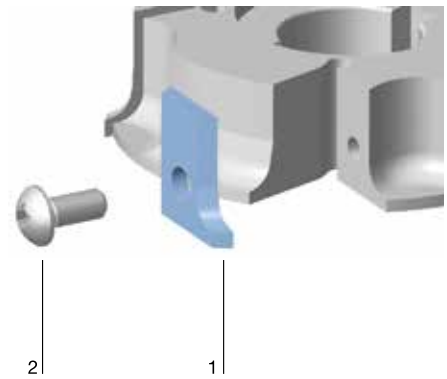
Machine	D	D <sub>0</sub>	SB	BO	Z	R	Type	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm		mm		min <sup>-1</sup>	LH	RH
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.0	1	18000	<b>074559</b>	<b>074560</b>
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.5	1	18000	<b>074557</b>	<b>074558</b>

#### Spare knives:

Part-no.	Type	BEZ	ABM	QAL	R	VE	ID	ID
			mm			PCS	LH	RH
1	1	Combi exchange knife	14.5x14.5x2	HW	2.0	10	<b>074632</b>	<b>074633</b>
1	1	Combi exchange knife	14.5x14.5x2	HW	2.5	10	<b>074630</b>	<b>074631</b>

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Screw	M3.5x8	<b>005723</b>





### Profile cutterhead / bevel cutterhead

#### Application:

To round and bevel edgebandings.

#### Machine:

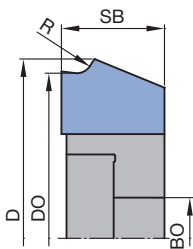
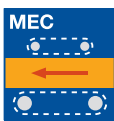
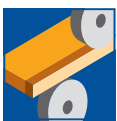
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

#### Workpiece material:

Softwood, hardwood, veneer and plastic 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

WE 500 2

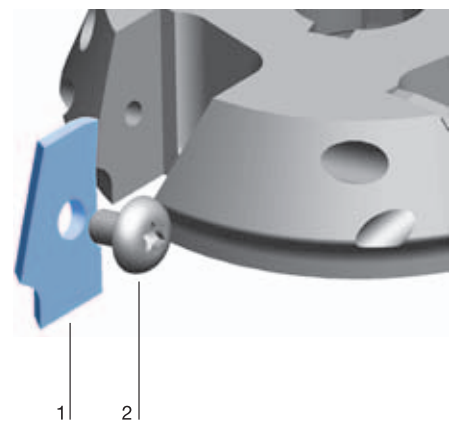
Machine	D	SB	BO	Z	R	FAW	Type	$n_{max}$	ID	ID
	mm	mm	mm		mm	°		$min^{-1}$	LH	RH
Brandt	70.23	20.28	16 DKN	4		15°	1	12000	075012	075013
Brandt	70.23	20.28	16 DKN	4		30°	1	12000	075014	075015
Brandt	69.98	20.28	16 DKN	4		45°	1	12000	075016	075017
Brandt	70.57	20.28	16 DKN	4	1.0		1	12000	075018	075019
Brandt	70.57	20.28	16 DKN	4	1.2		1	12000	075020	075021
Brandt	70.57	20.28	16 DKN	4	1.5		1	12000	075022	075023
Brandt	70.57	20.28	16 DKN	4	2.0		1	12000	075024	075025
Brandt	70.57	20.28	16 DKN	4	2.5		1	12000	075026	075027
Brandt	70.57	20.28	16 DKN	4	3.0		1	12000	075028	075029

#### Spare knives:

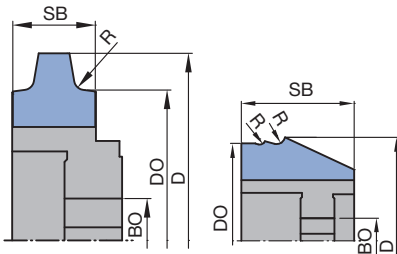
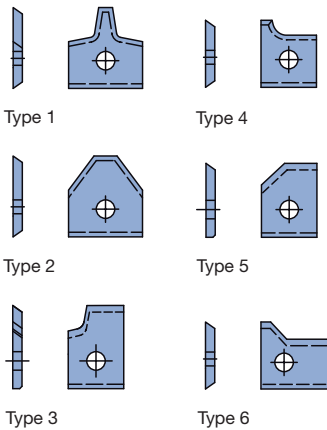
Part-no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	22.3x14x2	HW	1.0		10	075315	075314
1	1	Exchange knife	22.3x14x2	HW	1.5		10	075319	075318
1	1	Exchange knife	22.3x14x2	HW	2.0		10	075307	075306
1	1	Exchange knife	22.3x14x2	HW	2.5		10	075321	075320
1	1	Exchange knife	22.3x14x2	HW	3.0		10	075309	075308
1	1	Exchange knife	22.3x14x2	HW	1.2		10	075317	075316
1	1	Exchange knife	22.3x14x2	HW		15°	10	075311	075310
1	1	Exchange knife	22.3x14x2	HW		30°	10	075331	075332
1	1	Exchange knife	22.3x14x2	HW		45°	10	075313	075312

#### Spare parts:

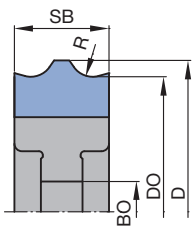
Part-no.	BEZ	ABM	ID
		mm	
2	Oval head screw Torx® 15	M4x6	006225
	Torx® key	Torx® 15	005466



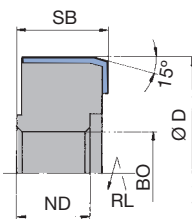
### Profile cutterhead / bevel cutterhead



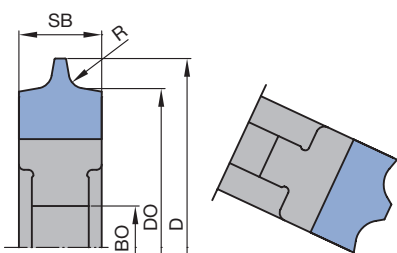
Type 1                      Type 2



Type 3



Type 4: WW 500 2 03



Type 1                      Type 2

#### Profile knives for edge finishing

TM 135 0

SB mm	H mm	DIK mm	QAL	Knife	R mm	FAW °	ID LH	ID RH
16	17.5	2	HW	1	2.0		005132 ●	005132 ●
16	17.5	2	HW	1	3.0		005133 ●	005133 ●
16	17.5	2	HW	1	4.0		005134 ●	005134 ●
16	17.5	2	HW	1	5.0		005135 ●	005135 ●
16	17.5	2	HW	2		45°		009525 ●
12	17	2	HW	3	2.0		073554 ●	073555 ●
12	18	2	HW	3	2.0		074033 ●	074034 ●
12	17	2	HW	3	3.0		073558 ●	073559 ●
12	18	2	HW	3	3.0		074035 ●	074036 ●
13	15	2	HW	3	2.0		073505 ●	073504 ●
13	15	2	HW	3	3.0		073509 ●	073508 ●
12	14.5	2	HW	4	2.0		075342 ●	075341 ●
14.5	14.5	2	HW	4	2.5		073543 ●	073544 ●
12	14.5	2	HW	4	3.0		075301 ●	075300 ●
12	16	2	HW	5		45°	073541 ●	073540 ●
14.5	14.5	2	HW	6		45°		073545 □

#### Profile knives for system Biesse

TM 135 0

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x17x2	HW	1.0	10	074600 □	074600 □
1	Exchange knife	16x17x2	HW	1.5	10	074601 □	074601 □
1	Exchange knife	16x17x2	HW	2.0	10	074602 ●	074602 ●
1	Exchange knife	16x17x2	HW	2.5	10	074603 □	074603 □
1	Exchange knife	16x17x2	HW	3.0	10	074604 □	074604 □
2	Exchange knife	40x17x2	HW	1.0	10	074610 □	074611 □
2	Exchange knife	40x17x2	HW	1.5	10	074612 □	074613 □
2	Exchange knife	40x17x2	HW	2.0	10	074614 □	074615 □
2	Exchange knife	40x17x2	HW	2.5	10	074616 □	074617 □
2	Exchange knife	40x17x2	HW	3.0	10	074618 □	074619 □
3	Exchange knife	20x16x2	HW	1.0	10	074620 □	074620 □
3	Exchange knife	20x16x2	HW	1.5	10	074621 □	074621 □
3	Exchange knife	20x16x2	HW	2.0	10	074622 ●	074622 ●
3	Exchange knife	20x16x2	HW	2.5	10	074623 □	074623 □
3	Exchange knife	20x16x2	HW	3.0	10	074624 □	074624 □

#### Profile knives for system Holz-Her

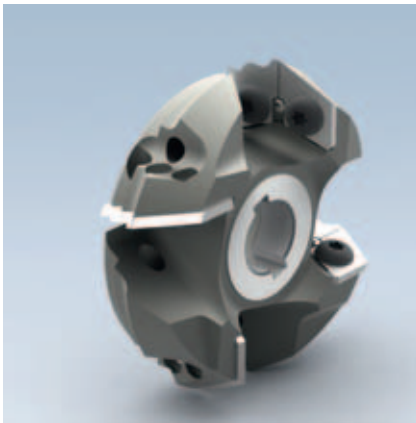
TM 435 0

BEZ	ABM mm	QAL	VE PCS	DRI	ID
Turnblade knife	30x12x1.5.PT1.3	HW	10	RH	005088 ●
Turnblade knife	30x12x1.5.PT1.3	HW	10	LH	005089 ●

#### Profile knives for system Ott

TM 135 0

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x16.5x2	HW	1.0	10	074540 □	074540 □
2	Exchange knife	16x17.5x2	HW	1.5	10	009539 ●	009539 ●
1	Exchange knife	16x17.5x2	HW	2.0	10	005132 ●	005132 ●
1	Exchange knife	16x18.5x2	HW	2.5	10	074543 □	074543 □
2	Exchange knife	16x17.5x2	HW	3.0	10	005133 ●	005133 ●
1	Exchange knife	16x19.5x2	HW	3.5	10	074545 □	074545 □
2	Exchange knife	25x15x2	HW	1.0	10	619194 □	619194 □
2	Exchange knife	25x15x2	HW	1.5	10	619195 □	619195 □
2	Exchange knife	25x15x2	HW	2.0	10	619196 ●	619196 ●
2	Exchange knife	25x15x2	HW	2.5	10	619197 □	619197 □
2	Exchange knife	25x15x2	HW	3.0	10	619198 □	619198 □
2	Exchange knife	25x15x2	HW	3.5	10	619202 □	619202 □



### Multi-profile cutterhead / bevel cutterhead

**Application:**

For a choice of radii or bevels on edgebandings.

**Machine:**

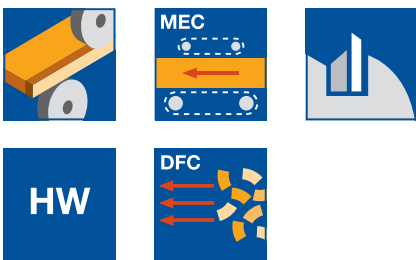
Single or double-sided edgebanding machines.

**Workpiece material:**

Softwood, hardwood, veneer and plastic 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.

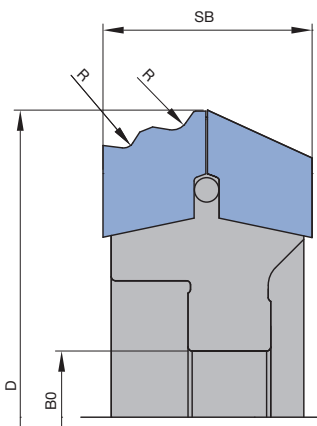


**Various profiles - DFC, Brandt**

WE 500 2

Machine	D	SB	BO	Z	R	FAW	Type	$n_{max}$	ID	ID
	mm	mm	mm		mm	°		$min^{-1}$	LH	RH
Brandt	74.24	25.28	16 DKN	4+4	1/1.5		1	12000	075040	075041
Brandt	74.24	25.28	16 DKN	4+4	1/2		1	12000	075032	075033
Brandt	74.24	25.28	16 DKN	4+4	1/3		1	12000	075036	075037
Brandt	74.24	25.28	16 DKN	4+4	1.3/2		1	12000	075034	075035
Brandt	74.24	25.28	16 DKN	4+4	1.3/3		1	12000	075048	075049
Brandt	74.24	25.28	16 DKN	4+4	1.5/2		1	12000	075042	075043
Brandt	74.24	25.28	16 DKN	4+4	1.5/3		1	12000	075044	075045
Brandt	74.24	25.28	16 DKN	4+4	2/3		1	12000	075038	075039
Brandt	74.24	25.28	16 DKN	4+4	1	15°	1	12000	075046	075047
Brandt	74.24	25.28	16 DKN	4+4	2	30°	1	12000	075050	075051

Further radii combinations available at short notice.

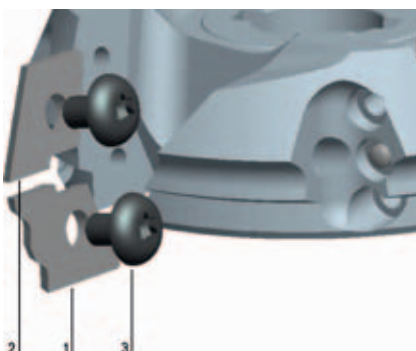


Type 1

**Spare knives:**

Part-no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	17.9x14.2x2	HW	1/1.5		10	075365	075366
1	1	Exchange knife	17.9x14.2x2	HW	1/2		10	075347	075348
1	1	Exchange knife	17.9x14.2x2	HW	1/3		10	075351	075352
1	1	Exchange knife	17.9x14.2x2	HW	1.3/2		10	075349	075350
1	1	Exchange knife	17.9x14.2x2	HW	1.3/3		10	075373	075374
1	1	Exchange knife	17.9x14.2x2	HW	1.5/2		10	075367	075368
1	1	Exchange knife	17.9x14.2x2	HW	1.5/3		10	075369	075370
1	1	Exchange knife	17.9x14.2x2	HW	2/3		10	075353	075354
1	1	Exchange knife	17.9x14.2x2	HW	1	15°	10	075371	075372
1	1	Exchange knife	17.9x14.2x2	HW	2	30°	10	075201	075202
2	1	Exchange knife	18.1x13.5x2	HW			10	075355	075356

Further radii combinations available at short notice.



**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
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:

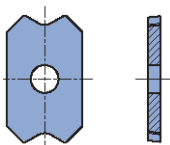
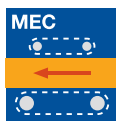
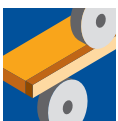
Plastic edgebandings.

#### Technical information:

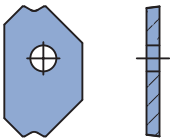
Bevel and radius scraper turnblade knives for scraper holder.

#### Turnblade knives - scrapers

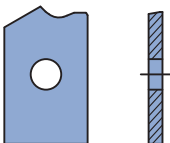
TM 435 0



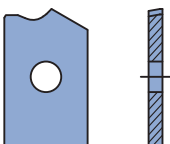
Turnblade scraper Type 1



Turnblade scraper Type 2



Turnblade scraper Type 3



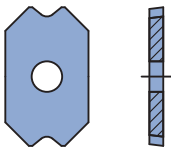
Turnblade scraper Type 4

Machine	R mm	FAW °	ABM mm	Type	QAL	BEM	VE PCS	ID
Holz-Her, Homag, IMA		45°	12x20x2	1	HW		10	<b>074037 ●</b>
Holz-Her, Homag	1.0		12x20x2	1	HW	Profile relief 6°	10	<b>074039 ●</b>
Holz-Her, Homag	1.5		12x20x2	1	HW	Profile relief 6°	10	<b>074074 ●</b>
Holz-Her, Homag	2.0		12x20x2	1	HW	Profile relief 6°	10	<b>074040 ●</b>
Holz-Her, Homag	2.5		12x20x2	1	HW	Profile relief 6°	10	<b>074075 ●</b>
Holz-Her, Homag	3.0		12x20x2	1	HW	Profile relief 6°	10	<b>074041 ●</b>
IMA	1.0		12x20x2	1	HW	Profile relief 15°	10	<b>074044 ●</b>
IMA	1.5		12x20x2	1	HW	Profile relief 15°	10	<b>074076 ●</b>
IMA	2.0		12x20x2	1	HW	Profile relief 15°	10	<b>074021 ●</b>
IMA	2.5		12x20x2	1	HW	Profile relief 15°	10	<b>074077 ●</b>
IMA	3.0		12x20x2	1	HW	Profile relief 15°	10	<b>074022 ●</b>
Homag, Homag - BAZ	1.0		20x11.5x2	1	HW	Profile relief 6°	10	<b>073713 ●</b>
Homag, Homag - BAZ	1.5		20x11.5x2	1	HW	Profile relief 6°	10	<b>073714 ●</b>
Homag, Homag - BAZ	2.0		20x11.5x2	1	HW	Profile relief 6°	10	<b>073715 ●</b>
Homag, Homag - BAZ	3.0		20x11.5x2	1	HW	Profile relief 6°	10	<b>073716 ●</b>
Homag, Homag - BAZ		3°	20x11.5x2	1	HW		10	<b>073717 ●</b>
Biesse, Stefani	1.0		12.7x12.7x3.18	1	HW	Profile relief 10°	10	<b>074548 ●</b>
Biesse, Stefani	1.5		12.7x12.7x3.18	1	HW	Profile relief 10°	10	<b>074549 ●</b>
Biesse, Stefani	2.0		12.7x12.7x3.18	1	HW	Profile relief 10°	10	<b>074550 ●</b>
Biesse, Stefani	3.0		12.7x12.7x3.18	1	HW	Profile relief 10°	10	<b>074551 ●</b>
Biesse, Stefani		25°	12.7x12.7x3.18	1	HW		10	<b>074552 ●</b>
Homag		45°	12x20x2	2	HW	Profile relief 15°	10	<b>073724 ●</b>
Homag	1.0		12x20x2	2	HW	Profile relief 15°	10	<b>073725 ●</b>
Homag	1.5		12x20x2	2	HW	Profile relief 15°	10	<b>073726 ●</b>
Homag	2.0		12x20x2	2	HW	Profile relief 15°	10	<b>073727 ●</b>
Homag	2.5		12x20x2	2	HW	Profile relief 15°	10	<b>073728 ●</b>
Homag	3.0		12x20x2	2	HW	Profile relief 15°	10	<b>073729 ●</b>
Fravol	1-3		12x20x2	4	HW		10	<b>074639 ●</b>
Fravol	1-3		12x20x2	3	HW		10	<b>074640 ●</b>

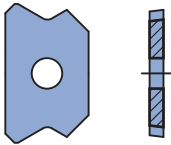
Additional scrapers available on request at short notice.

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



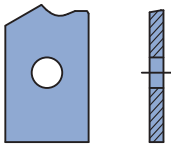
Type 1



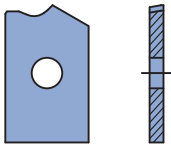
Type 2



Type 3



Type 4



Type 5

#### Technical information:

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

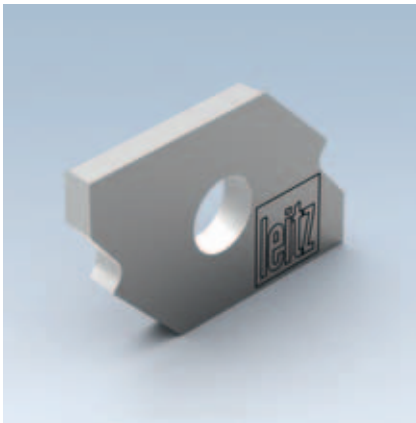
#### Radii scrapers with anti-stress-whitening bevel

TM 435 0

Machine	R mm	FAW °	ABM mm	QAL	BEM	Type ID	
Brandt, Hebrock/EBM, Holz-Her, Homag, IMA		45°	12x20x2	HW		1	074103 ●
Brandt, Hebrock/EBM, Holz-Her, Homag	1.0		12x20x2	HW	Profile relief 6°	1	074095 ●
Brandt, Hebrock/EBM, Holz-Her, Homag	1.3		12x20x2	HW	Profile relief 6°	1	074096 ●
Brandt, Hebrock/EBM, Holz-Her, Homag	1.5		12x20x2	HW	Profile relief 6°	1	074097 ●
Brandt, Hebrock/EBM, Holz-Her, Homag	2.0		12x20x2	HW	Profile relief 6°	1	074098 ●
Brandt, Hebrock/EBM, Holz-Her, Homag	2.5		12x20x2	HW	Profile relief 6°	1	074099 □
Brandt, Hebrock/EBM, Holz-Her, Homag	3.0		12x20x2	HW	Profile relief 6°	1	074100 ●
IMA	1.0		12x20x2	HW	Profile relief 15°	2	074090 ●
IMA	1.3		12x20x2	HW	Profile relief 15°	2	074101 □
IMA	1.5		12x20x2	HW	Profile relief 15°	2	074091 ●
IMA	2.0		12x20x2	HW	Profile relief 15°	2	074092 ●
IMA	2.5		12x20x2	HW	Profile relief 15°	2	074093 □
IMA	3.0		12x20x2	HW	Profile relief 15°	2	074094 ●
Homag, Homag - BAZ	1.0		20x11.5x2	HW	Profile relief 6°	3	073719 ●
Homag, Homag - BAZ	1.5		20x11.5x2	HW	Profile relief 6°	3	073720 ●
Homag, Homag - BAZ	2.0		20x11.5x2	HW	Profile relief 6°	3	073721 ●
Homag, Homag - BAZ	3.0		20x11.5x2	HW	Profile relief 6°	3	073723 ●
Fraval	1-3		12x20x2	HW		5	074636 ●
Fraval	1-3		12x20x2	HW		4	074637 ●
Fraval	1-3		15.44x20x2	HW		5	074641 ●
Fraval	1-3		15.44x20x2	HW		4	074642 ●

#### Spare parts:

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



### Profile scrapers

**Application:**

For scraping edgebandings with radii or bevels.

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

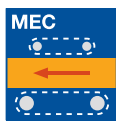
Plastic edgebandings.

**Technical information:**

Various bevel and radii scraper turnblades for mounting in scraper holders.

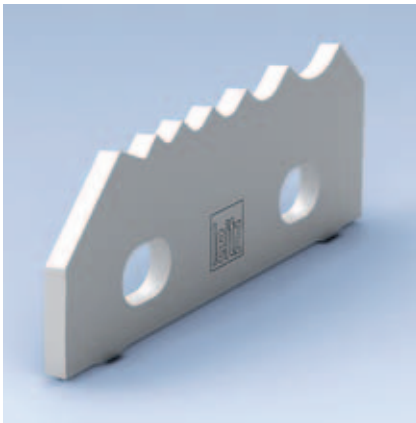
**Profile scrapers - Holz-Her, aggregate ZK701**

TM 435 0



Machine	R mm	FAW °	ABM mm	QAL	VE PCS	ID bottom	ID top
Holz-Her	1.0		12x19x2	HW	10	<b>074561</b> ●	<b>074562</b> ●
Holz-Her	1.3		12x19x2	HW	10	<b>074563</b> ●	<b>074564</b> ●
Holz-Her	1.5		12x19x2	HW	10	<b>074565</b> ●	<b>074566</b> ●
Holz-Her	2.0		12x19x2	HW	10	<b>074567</b> ●	<b>074568</b> ●
Holz-Her	2.5		12x19x2	HW	10	<b>074569</b> ●	<b>074570</b> ●
Holz-Her	3.0		12x19x2	HW	10	<b>074571</b> ●	<b>074572</b> ●
Holz-Her		45°	12x19x2	HW	10	<b>074573</b> ●	<b>074574</b> ●
Holz-Her		10°	12x19x2	HW	10	<b>074575</b> ●	<b>074576</b> ●

Additional scrapers available on request at short notice.



### Profile scrapers

**Application:**

For scraping edgebandings with radii or bevels.

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic edgebandings.

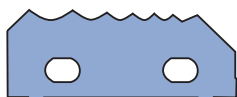
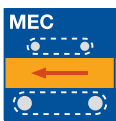
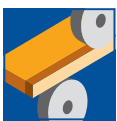
**Technical information:**

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

**Multi-profile scrapers**

TM 135 0

Machine	BEM	QAL	ID	
			LH	RH
Homag	R 0.45/1/1.5/2/3/5	HW	074049 ●	074050 ●
IMA	R 1/2/3	HW	074079 ●	074078 ●
Stefani	R 1/2/3/Bevel	HW	074081 ●	074080 ●
Biesse	R 1/2/3/Bevel	HW	074083 ●	074082 ●



**Spare parts:**

BEZ	ABM	ID
	mm	
Torx® key	Torx® 15	005466 ●
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	BEM	QAL	ID	
			LH	RH
Homag	R 1/1,5/2/2,5/3/20°	HW	073104 ●	073105 ●

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

**Spare parts:**

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

Multi-profile scraper





### Profile scrapers

**Application:**

For scraping edgebandings with radii or bevels.

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

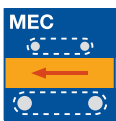
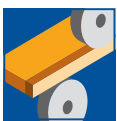
Plastic edgebandings.

**Technical information:**

Various bevels and radii. Scraper turnblade knives to carry in scraper holder.

**Multi-profile scraper - Brandt**

TM 135 0

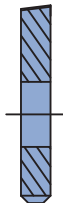
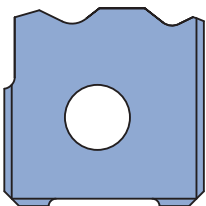


Machine	ABM mm	QAL	R mm	FAW °	VE PCS	ID bottom	ID top
Brandt	13.5x13.38x2	HW	1/1.5		2	<b>075375</b> ●	<b>075376</b> ●
Brandt	13.5x13.38x2	HW	1/2		2	<b>075357</b> ●	<b>075358</b> ●
Brandt	13.5x13.38x2	HW	1/3		2	<b>075361</b> ●	<b>075362</b> ●
Brandt	13.5x13.38x2	HW	1.3/2		2	<b>075359</b> ●	<b>075360</b> ●
Brandt	13.5x13.38x2	HW	1.3/3		2	<b>075379</b> ●	<b>075380</b> ●
Brandt	13.5x13.38x2	HW	1.5/2		2	<b>075377</b> ●	<b>075378</b> ●
Brandt	13.5x13.38x2	HW	2/3		2	<b>075363</b> ●	<b>075364</b> ●
Brandt	13.5x13.38x2	HW	2	30°	2	<b>075397</b>	<b>075398</b>

Further radii combinations and anti-stress-whitening knives available at short notice.

**Spare parts:**

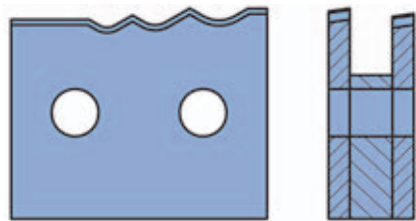
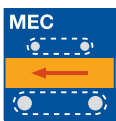
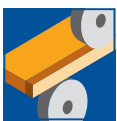
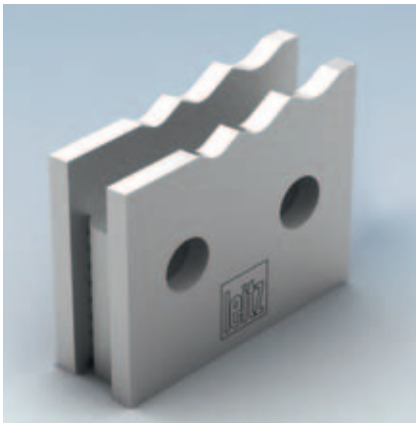
BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466</b> ●
Oval head screw Torx® 15	M4x6	<b>006225</b> ●



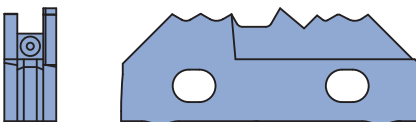
Multi-profile scraper

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



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



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

#### 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 edgebandings 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.

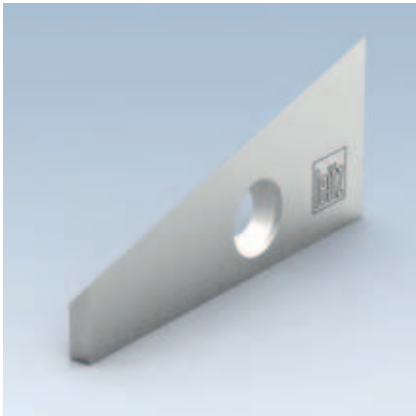
**Attention:** Only applicable on standard scraper aggregates with special profile scraper holders.

##### Duo multi-profile scraper

TM 135 0, TM 435 0

Machine	BEM	Type	QAL	ID	ID
				LH	RH
Homag	R 1.3/2.0 (Duo)	2	HW	073730	073731
	R 0.6/1.5/5°				
IMA	R 1.3/1.5/2/45°	1	HW	074084 ●	074085 ●
IMA	R 1/2/3/45°	1	HW	074088 ●	074089 ●

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.

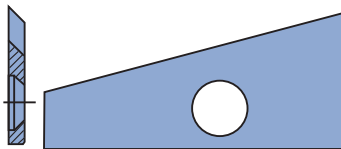
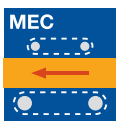
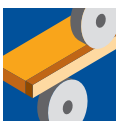
**Technical information:**

Different profile flat scrapers.

**Flat scraper knives**

TC 105 0, TM 135 0

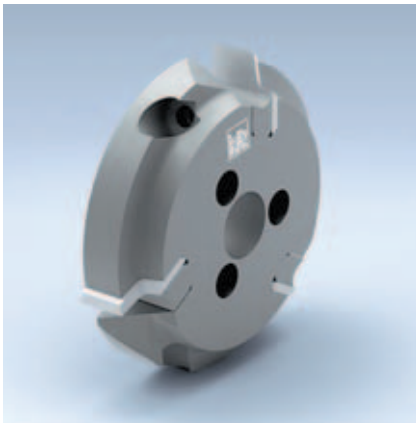
Machine	ABM mm	QAL	FAW °	ID LH	ID RH
Biesse	16x16x4.7	HW			<b>074556 ●</b>
Biesse	22.9x22.9x2.5	HW			<b>074555 ●</b>
Brandt, Ott	15x14.3x2.5	HW	6°	<b>074500 ●</b>	<b>074501 ●</b>
Fravol	20x12x1.5	HW			<b>074638 ●</b>
Hebrock/EBM	36x30x3	HW		<b>074634</b>	<b>074635</b>
Homag	32x55x4.5	HW	15°	<b>074047 ●</b>	<b>074048 ●</b>
IMA	14.3x14.3x2.5	HW			<b>074305 ●</b>
IMA	55x25x3	HW	15°	<b>074023 ●</b>	<b>074024 ●</b>
IMA BAZ	11x14.3x2.5	HW			<b>074306 ●</b>



**Spare parts:**

BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 ●</b>
Oval head screw Torx® 15	M4x6	<b>006225 ●</b>

Flat scraper



### Profile cutterhead / bevel cutterhead for stationary machines

**Application:**

To round/bevel edgebandings.

**Machine:**

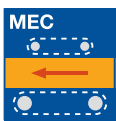
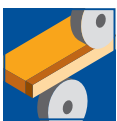
Homag BAZ.

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

Cutterheads with HW knives for edge trimming cutter aggregate. The same cutterhead tool body suitable for R 1.0 to 3.0 mm. D<sub>0</sub> = constant reference diameter.



**Various radii / bevels - Homag**

WE 500 2

D	D <sub>0</sub>	BO	Z	QAL	R	FAW	Type	n <sub>max</sub>	ID	ID
mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
59	50	15	3	HW	1.0		1	18000	073001	073000
59	50	15	3	HW	1.5		1	18000	073003	073002
59	50	15	3	HW	2.0		1	18000	073005	073004
59	50	15	3	HW	3.0		1	18000	073009	073008
60	50	15	3	HW		15°	2	18000	073037	073036
60	50	15	3	HW		30°	2	18000	073039	073038
60	50	15	3	HW		45°	2	18000	073041	073040
62	50	15	3	HW		15°	3	18000	073101	073100

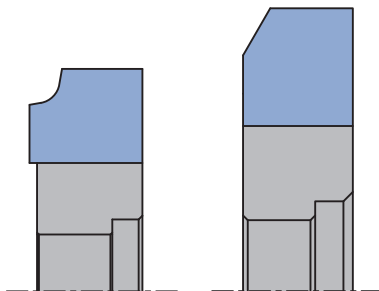
Type 3 for special thin edgebandings.

**Spare knives:**

Part-no.	SB	H	DIK	QAL	R	FAW	Type	ID	ID
	mm	mm	mm		mm	°		LH	RH
1	13	15	2	HW	1.0		1	073501	073500
1	13	15	2	HW	1.5		1	073503	073502
1	13	15	2	HW	2.0		1	073505	073504
1	13	15	2	HW	3.0		1	073509	073508
1	12	16	2	HW		15°	2	073537	073536
1	12	16	2	HW		30°	2	073539	073538
1	12	16	2	HW		45°	2	073541	073540
1	14	14	2	HW-F			3	005099	005099

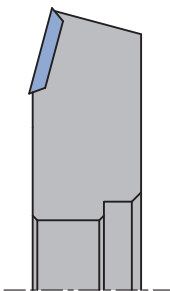
**Spare parts:**

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
	Allen key	SW 3	005444
	Torx® key	Torx® 20	006091
	Setting gauge for knives	1.0	005372

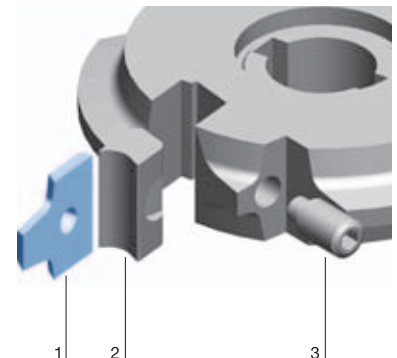


Type 1

Type 2



Type 3





#### Profile cutter / bevel cutter for stationary machines.

**Application:**

To round/bevel edgebandings.

**Machine:**

Homag BAZ.

**Workpiece material:**

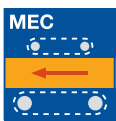
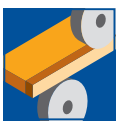
Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

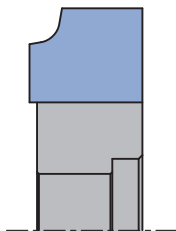
DP tipped tool with cylindrical bore.  $D_0$  = constant reference diameter.

**Radii cutter DP - Homag**

WF 501 2 DP



D mm	$D_0$ mm	BO mm	Z	QAL	R mm	Type	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
57	50	15	3	DP	2.0	1	18000	073103 ●	073102 ●
57	50	15	3	DP	3.0	1	18000	091522 ●	091523 ●



Type 1



#### Profile cutter / bevel cutter for stationary machines.

**Application:**

To round/bevel edgebandings.

**Machine:**

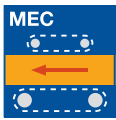
IMA (BIMA).

**Workpiece material:**

Softwood, hardwood, veneer and plastic edgebander.

**Technical information:**

HW tipped profile/bevel cutter, 1 or 2 part design. DP tipped tools available at short notice.

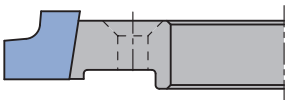
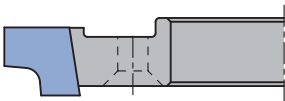
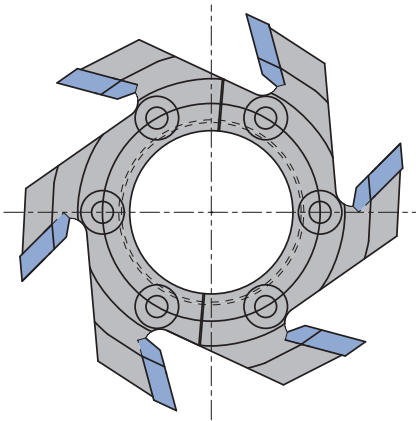


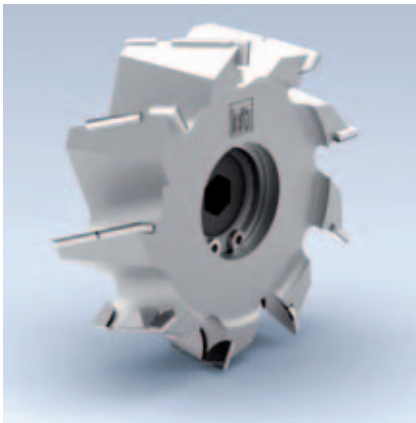
**Various radii / bevels - IMA**

WF 501 2

D	D <sub>0</sub>	SB	BO	Z	QAL	R	FAW	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
64.4	55	10.2	30	6	HW	1.5		1	18000	<b>074062</b> <input type="checkbox"/>	<b>074063</b> <input type="checkbox"/>
64.4	55	10.2	30	6	HW	2.0		1	18000	<b>074064</b> <input type="checkbox"/>	<b>074065</b> <input type="checkbox"/>
64.4	55	10.2	30	6	HW	3.0		1	18000	<b>074066</b> <input type="checkbox"/>	<b>074067</b> <input type="checkbox"/>
70	60	9	30	6	HW	1.5		1	18000	<b>074056</b> <input type="checkbox"/>	<b>074057</b> <input type="checkbox"/>
70	60	9	30	6	HW	2.0		1	18000	<b>074058</b> <input type="checkbox"/>	<b>074059</b> <input type="checkbox"/>
70	60	9	30	6	HW	3.0		1	18000	<b>074060</b> <input type="checkbox"/>	<b>074061</b> <input type="checkbox"/>
70	60	9	30	6	HW		15°	1	18000	<b>074068</b> <input type="checkbox"/>	<b>074069</b> <input type="checkbox"/>
70	60	9	30	6	HW		30°	1	18000	<b>074070</b> <input type="checkbox"/>	<b>074071</b> <input type="checkbox"/>
70	60	9	30	6	HW		45°	1	18000	<b>074072</b> <input type="checkbox"/>	<b>074073</b> <input type="checkbox"/>

All cutters are available at short notice in 2 part design.





### Rebating cutter

**Application:**

To rebate the core to uncover and trim the edge of the top layer.

**Machine:**

Postforming machines.

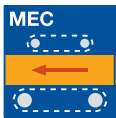
**Workpiece material:**

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

**Technical information:**

DP tipped tools with HSK 25 R adaptor. High number of teeth removes the need for pre-scoring.

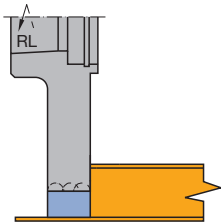
DP tools - 2.0 mm resharpening area.



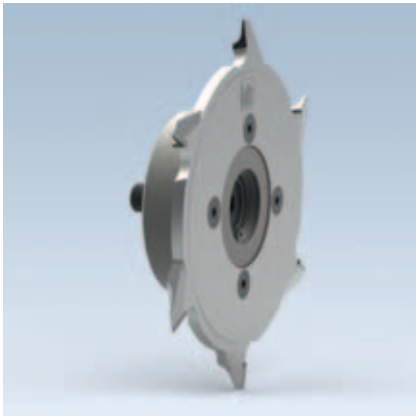
**Diamaster PRO**

WF 499 2

Machine	D	SB	BO	Z	$n_{max}$	ID	ID
	mm	mm	mm		$min^{-1}$	LH	RH
Homag, IMA	70	25	HSK 25 R	9+3	18000	<b>091796</b>	<b>091797</b>



Rebating cutter with HSK 25 R bore:  
Machining the laminate layer with  
horizontal motor



### Finishing cutterhead

**Application:**

For finish cutting of radii on postforming profiles.

**Machine:**

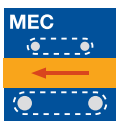
Postforming units.

**Workpiece material:**

HPL, CPL or veneer coated chip and fibre boards (chipboard, MDF etc.).

**Technical information:**

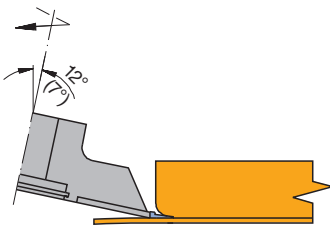
Cutterhead with DP tipped profile knives and HSK 25 R adaptor. Suitable for finish cutting of all radii up to R 14 mm.



**7° inclined spindle**

WF 556 2

Machine	D	SB	BO	Z	QAL	$n_{max}$	Spindle angle	ID	ID
	mm	mm	mm			$min^{-1}$	°	LH	RH
Homag, IMA	125	5.1	HSK 25 R	6	DP	12000	7	<b>192666</b>	<b>192667</b>



Finish cutting of all radii up to R 14 mm with spindle angle 7°

**Technical information:**

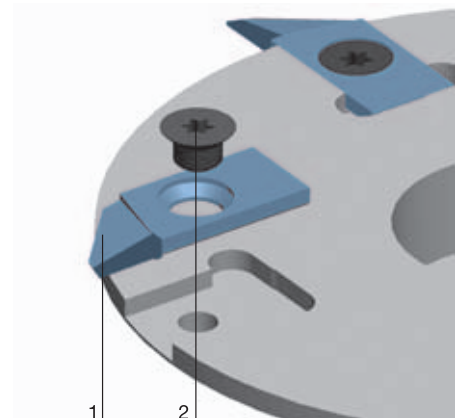
Spare knives for cutterhead with DP profile knives and cylindrical bore or HSK 25 R adaptor. Suitable for finish cutting radii up to R 14. Non-resharpenable knives 0.5 mm optimised for sensitive coatings, veneer postforming and maximum contour accuracy.

**Spare knives for finishing cutterheads**

TM 160 0

BEZ	ABM	QAL	ID	ID
	mm		LH	RH
Knife	12x31x2.5x0.5. SB2.5	DP	<b>008208</b> ●	<b>008204</b> ●

Spare knives for 7° and 12° inclined spindles.







### Segment hogger for sizing unit

#### Application:

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

#### Machine:

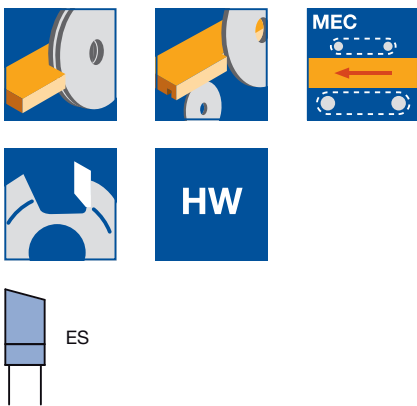
Sizing station in production lines.

#### 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 <sub>Sawblade</sub>	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	BEM	ID
		mm		
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 ●

#### Technical information:

Steel (D 300 mm) and aluminium (D 350 mm) with segments.

#### Basic hogger

WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
300	28	30	6x7	FZ	HW	064440	064441
350	36.5	80	6x10	FZ	HW	064442	064443

#### Extension hogger

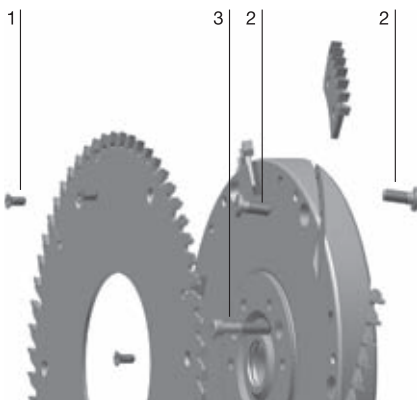
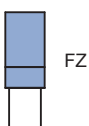
WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
300	28	30	6x7	FZ	HW	064444	064445
350	20.2	80	6x10	FZ	HW	064446 ●	064447

#### Segments (6 per hogger)

TM 170 0

ABM	Z	ZF	QAL	ID	ID
mm				LH	RH
D 300/340	7	FZ	HW	064970 ●	064971 ●
D 350	10	FZ	HW	064962 ●	064963 ●





### Segment hogger for splitting unit

**Application:**

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

**Machine:**

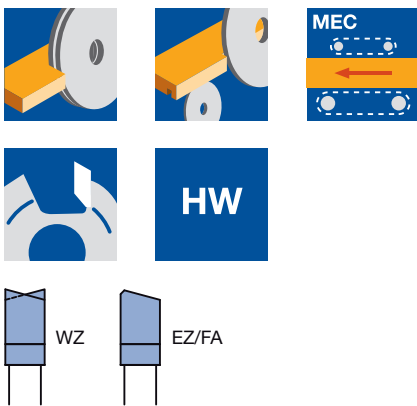
Sizing station in production lines.

**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 <sub>Sawblade</sub>	QAL	ID LH	ID RH
Siempel- kamp	350	42.1	30	60 ES/FA 72 WZ	HW	<b>064704</b>	<b>064705</b>

**Spare parts:**

Part-no.	BEZ	ABM mm	BEM	ID
1	Countersink screw, Torx® 20	M6x16	Torx® 20	<b>006086</b> ●
2	Cylindrical screw with ISK	M8x35	for D = 305/350	<b>005874</b> ●

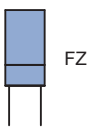
**Technical information:**

D 300 mm finish cut and D 350 mm trimming sawblade.

**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	<b>061848</b> ●	<b>061849</b> ●
350	4.4	200	72	WZ	HW	<b>061850</b> ●	<b>061850</b> ●



**Basic hogger with segments**

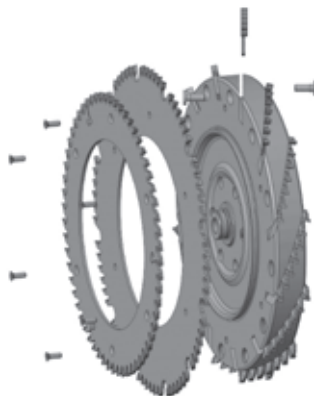
WZ 300 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
340	34.5	30	12x7	FZ	HW	<b>064448</b>	<b>064449</b>

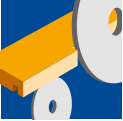











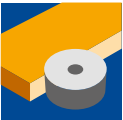

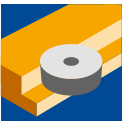





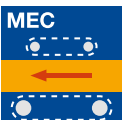
**Segments (12 per hogger)**

TM 170 0

ABM mm	Z	ZF	QAL	ID LH	ID RH
D 300/340	7	FZ	HW	<b>064970</b> ●	<b>064971</b> ●



## 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		

