

# Panel processing

Leitz Lexicon Edition 7

Version 3

12/2022



## Explanation of abbreviations

A	= dimension A	LH	= left hand rotation
$a_e$	= cutting thickness (radial)	M	= metric thread
$a_p$	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	$\text{min}^{-1}$	= 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	RH	= right hand rotation
DKN	= double keyway	RP	= radius of cutter
DP	= polycrystalline diamond	S	= shank dimension
DRI	= rotation	SB	= cutting width
FAB	= width of rebate	SET	= set
FAT	= depth of rebate	SLB	= slotting width
FAW	= bevel angle	SLL	= slotting length
FLD	= flange diameter	SLT	= slotting depth
$f_z$	= tooth feed	SP	= tool steel
$f_{z \text{ eff}}$	= effective tooth feed	ST	= Cobalt-basis cast alloys, e.g. Stellite®
GEW	= thread	STO	= shank tolerance
GL	= total length	SW	= cutting angle
GS	= Plunging edge	TD	= diameter of tool body
H	= height	TDI	= thickness of tool
HC	= tungsten carbide, coated	TG	= pitch
HD	= wood thickness (thickness of workpiece)	TK	= reference diameter
HL	= high-alloyed tool steel	UT	= cutting edges with irregular pitch
HS	= high-speed steel (HSS)	V	= number of spurs
HW	= tungsten carbide (TCT)	$v_c$	= cutting speed
ID	= ident number	$v_f$	= feed speed
IV	= insulation glazing	VE	= packing unit
KBZ	= abbreviation	VSB	= adjustment range
KLH	= clamping height	WSS	= workpiece material
KM	= edge breaker	Z	= number of teeth
KN	= single keyway	ZA	= number of fingers
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60	ZF	= tooth shape (cutting edge shape)
L	= length	ZL	= finger length
l	= clamping length		
LD	= left hand twist		
LEN	= Leitz standard profiles		

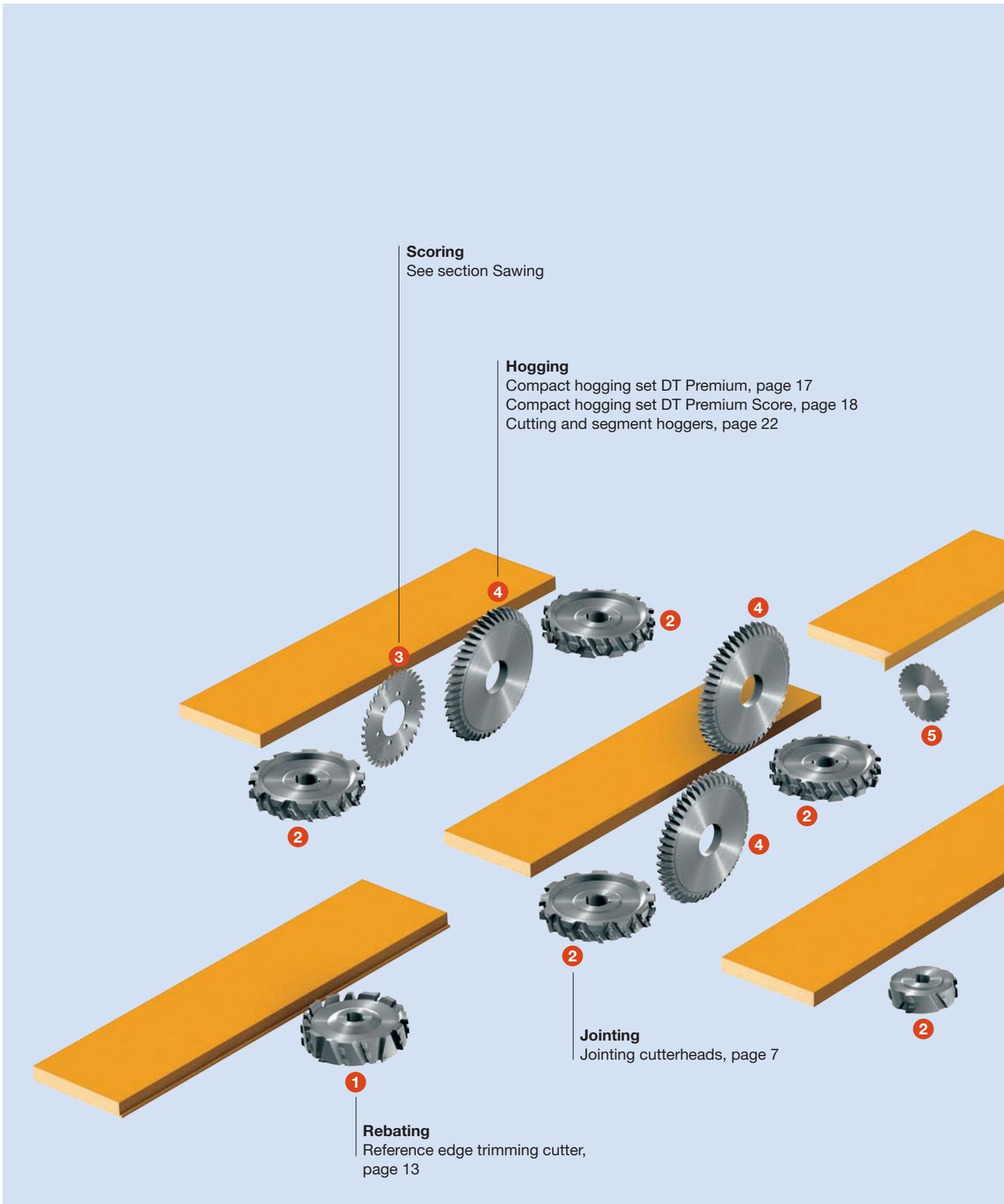
### Notes to the Lexicon concerning the diagrams and tables

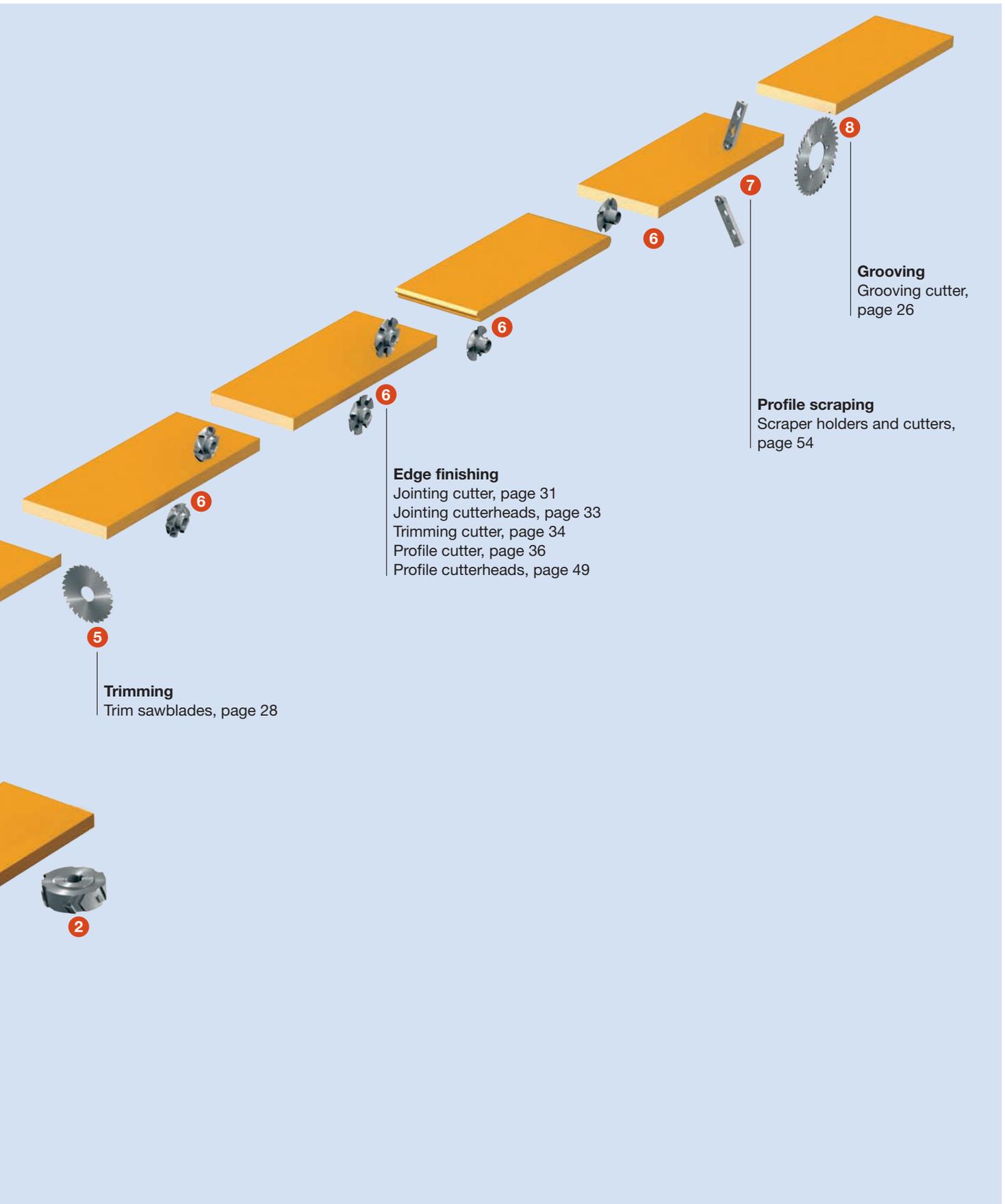
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



## 2. Panel processing

	2.1 Edge processing	2
	2.1.1 Edging processing machines	2
	2.1.2 Jointing cutters	4
	2.1.3 Compact hoggers - DP	15
	2.1.4 Cutting and segment hoggers	20
	2.1.5 Grooving cutters	25
	2.1.6 End trim sawblades	28
	2.1.7 Edge finishing tools	30
		
	2.2 Postforming processing	64
	2.2.1 Postforming processing machines	64
	2.2.2 Postforming tools	66
	2.3 Panel processing	69
	2.3.1 Segment hoggers for sizing	69
	Troubleshooting	72
	Signs of wear	73
	Enquiry/order form special tools – panel processing	75
	Alphabetical product index	77
	ID index	78





**Trimming**  
Trim sawblades, page 28

**Edge finishing**  
Jointing cutter, page 31  
Jointing cutterheads, page 33  
Trimming cutter, page 34  
Profile cutter, page 36  
Profile cutterheads, page 49

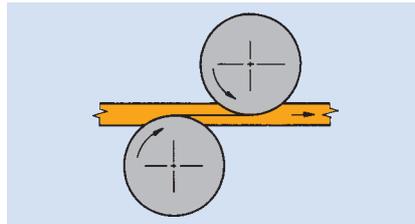
**Grooving**  
Grooving cutter,  
page 26

**Profile scraping**  
Scraper holders and cutters,  
page 54

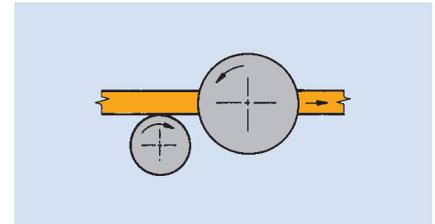
## 2.1 Edge processing

### 2.1.3 Compact hoggers - DP

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

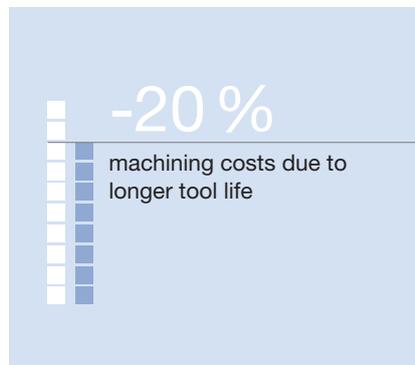


Double hogging: Both hogs cut with feed.



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

<b>Compact hogger DT Premium</b>	Manufacturers are facing major challenges due to their customers demanding changing quantities as well as requesting a wide variety of carrier and decorative materials to be used in panel production. The new DT Premium compact hogger is the solution for increasing productivity thanks to its long tool life – with perfect quality on the edge and cutting surface.
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<b>Productivity &amp; efficiency</b>	<p>Maximum economic efficiency through long tool life</p> <ul style="list-style-type: none"> <li>– Long tool life even under difficult operating conditions thanks to new tooth shape</li> <li>– Reduction of set-up costs due to long tool life</li> <li>– Efficient chip removal due to innovative gullet geometry and integrated chipbreaker</li> <li>– Cost efficient processing of various materials</li> <li>– Ideal also for batch size 1 due to adapted cutting geometries</li> <li>– Resharpenable up to 15 times through larger resharpening area</li> </ul>
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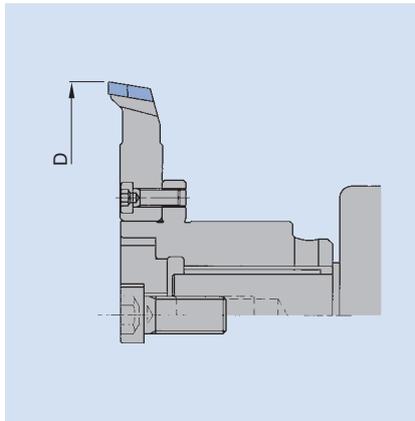
<b>Quality</b>	<p>Perfect edges and cutting surfaces</p> <ul style="list-style-type: none"> <li>– Excellent edge quality and smooth cutting surfaces through adapted cutting geometries</li> <li>– Clean workpiece finishes due to efficient chip removal with DFC®-Technology</li> <li>– Constant cutting width over the entire life cycle</li> </ul>
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<b>Sustainability</b>	<p>Longer tool life time, less dust and noise</p> <ul style="list-style-type: none"> <li>– Reduced noise due to special tool design</li> <li>– Reduction of noise and vibration through damping elements</li> <li>– Longer tool life time through larger resharpening area</li> </ul>
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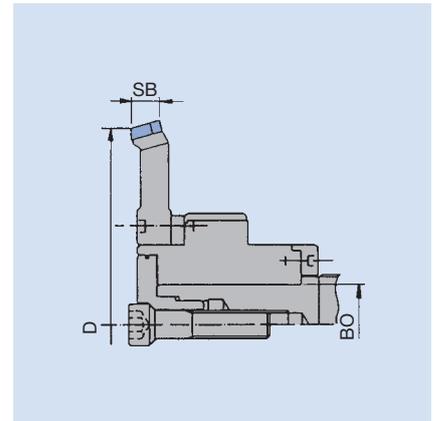
## 2.1 Edge processing

### 2.1.3 Compact hoggers - DP

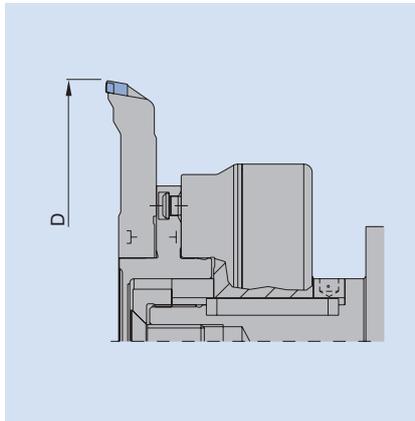
#### Designs



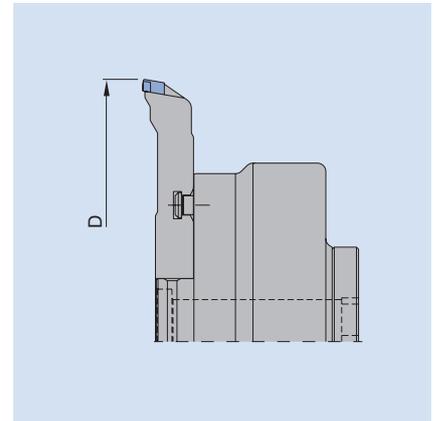
Tooth shape: top bevel decreasing.  
Hogger on standard flange.



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



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



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

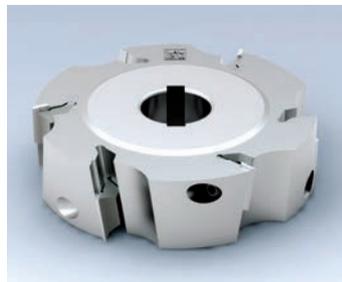
## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

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

#### Tool Designs



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

Diamond jointing cutter with alternate shear angle:

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

The tool can be used in RH and LH rotation.

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



2-part tools on synchronically adjustable sleeve:

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

#### Diamaster WhisperCut



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

Advantages at a glance:

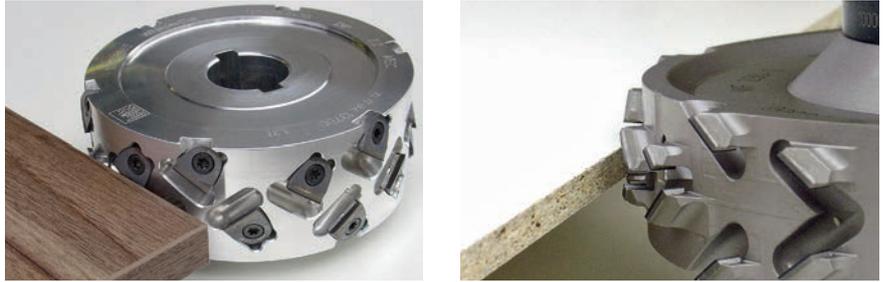
- Significant noise reduction of up to 5 dB(A) through optimized tool body shape and weight halving
- Trouble free chip ejection and excellent chip collection through DFC technology
- Individual use as per customer requirement: resharpenable or as changing knife system

## 2. Panel processing

### 2.1 Edge processing

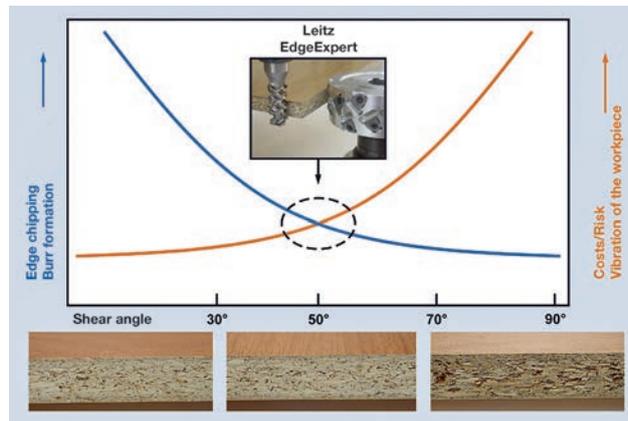
#### 2.1.2 Jointing cutters

##### Diamaster EdgeExpert



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

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

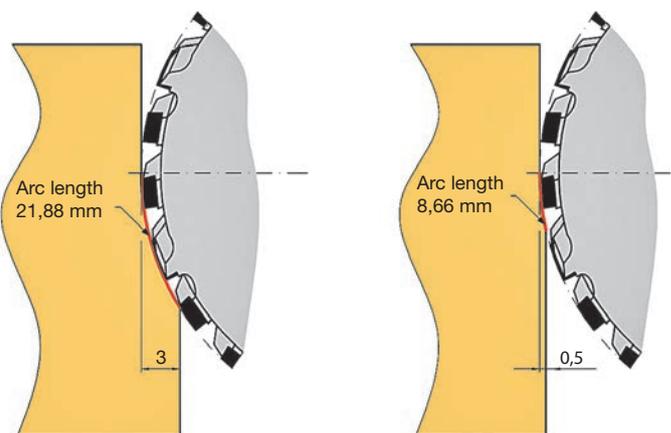


##### Dust collection

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

##### Chip removal

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



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

##### Noise emission

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

##### Service

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

##### Resharpener Diamaster WhisperCut



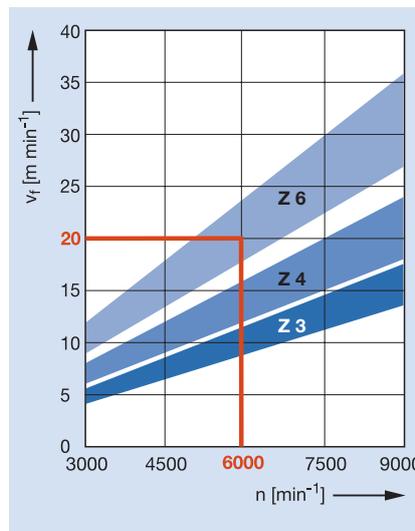
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times  
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

##### Diamaster WhisperCut – The jointing cutterhead with exchan- geable knives

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

##### Feed speed related to RPM and number of teeth Z

Material: Chipboard with melamine  
resin coating



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### WhisperCut jointing / milling cutter - cutterhead design

##### Application:

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

##### Machine:

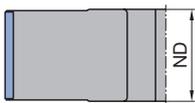
Edgebanding machines, copy shaping machines, double-end tenoners etc.

##### Workpiece material:

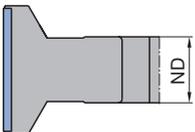
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

##### Technical information:

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



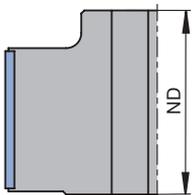
Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3



Position of boss (NAL) 4

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

WF 230 2 DP, WM 230 2 01

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Ayza Mizrak	70	54	30	20	DKN	2	2x5	10xD	AS	192320 ● 192321 ●
Ayza Mizrak	125	54	40	30	DKN	3	3x5	15xE	AS	192326 192327
Biesse	80	45	53	30	DKN	1	2x4	8xB	S	192127 ● 192127 ●
Biesse	80	65	53	30	DKN	2	2x6	12xB	S	192128 ● 192128 ●
Biesse	100	43	75	30	DKN	1	3x4	12xA	S	192088 ● 192088 ●
Biesse	100	65	75	30	DKN	1	3x6	18xA	S	192089 ● 192089 ●
Biesse	125	43	40	30	DKN	2	3x4	12xE	S	075627 ● 075627 ●
Biesse	125	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 ●
EBM	70	43	61	25	DKN	4	2x4	8xB	AS	192237 ● 192238 ●
EBM	70	63	81	25	DKN	4	2X6	12xB	AS	192239 ● 192240 ●
EBM	100	43	61	30	DKN	4	2x4	8xB	AS	192233 ● 192234 ●
EBM	100	63	81	30	DKN	4	2x6	12xB	AS	192235 ● 192236 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192278 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192277 ●
Felder	80	48.5	64	25	DKN	4	3x6	12xF	AS°	192281 ● 192282 ●
Felder	80	64	64	25	DKN	3	2x7	12xF	AS°	192300 ●
Felder	80	64	64	25	DKN	3	2x7	12xF	AS°	192299 ●
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192279 ●
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192280 ●
Fravol	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192247 ●
Fravol	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192248 ●
Fravol	60	84	61	25	DKN	3	2x8	14xC	AS°	192241 ●

● available ex stock

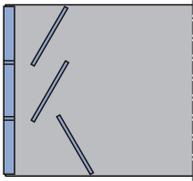
□ available at short notice

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

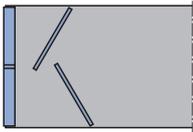
## 2. Panel processing

### 2.1 Edge processing

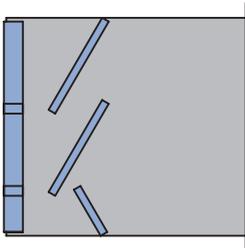
#### 2.1.2 Jointing cutters



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



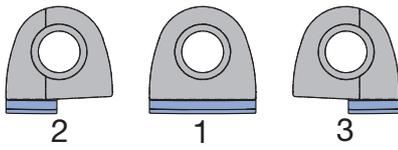
Type AS° = asymmetric tip arrangement with a narrow row of teeth below

Machine	D mm	SB mm	ND mm	BO mm		NAL	Z	Knife Type	Type	ID LH	ID RH
Fraval	60	84	61	25	DKN	3	2x8	14xC	AS°		192242 ●
								2xC2			
Fraval	100	65	56.5	30	DKN	3	2x6	12xA	AS	192243 ●	192244 ●
Fraval	100	84	56.5	30	DKN	3	2x8	14xA	AS°	192285 ●	
								14xA1			
Fraval	100	84	56.5	30	DKN	3	2x8	14xA	AS°		192286 ●
								14xA2			
Fraval	100	124	96	30	DKN	2	2x11	22xA	AS	192245	192246
Hebrock	70	43	61	25	DKN	4	2x4	8xB	AS	192237 ●	192238 ●
Hebrock	70	63	81	25	DKN	4	2X6	12xB	AS	192239 ●	192240 ●
Hebrock	100	43	61	30	DKN	4	2x4	8xB	AS	192233 ●	192234 ●
Hebrock	100	63	81	30	DKN	4	2x6	12xB	AS	192235 ●	192236 ●
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°		192221 ●
								2xD2			
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°	192222 ●	
								2xD1			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°		192223 ●
								2xD2			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°	192224 ●	
								2xD1			
Holz-Her	100	63	39.5	30	DKN	2	3x6	18xB	S	192147 ●	192148 ●
								1804			
Holz-Her	100	43	25	30	DKN	2	2x4	8xA	AS	192082 ●	192083 ●
								1891			
Holz-Her	100	65	25	30	DKN	2	2x6	12xA	AS	192084 ●	192085 ●
								1891			
Holz-Her	100	63	39.5	HSK	32R	2	3x6	18xB	S	192307 ●	192308 ●
								FG701			
Homag	100	43.6	40.6	25	DKN	3	2x4	8xA	AS	192211 ●	192212 ●
Homag	100	43.6	40.6	30	DKN	3	3x4	12xA	AS	090885 ●	090886 ●
Homag	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	090887 ●	090888 ●
Homag	100	85	85	30	DKN	3	3x8	24xA	AS	090889	090890
Homag	100	105	85	30	DKN	3	3x10	30xA	AS	090891	090892
Homag	125	42.6	54	30	DKN	3	3x4	12xA	AS	192287 ●	192288 ●
Homag	125	43	40	30	DKN	2	3x4	12xE	S	075627 ●	075627 ●
Homag	125	63	40	30	DKN	2	3x6	18xE	S	075626 ●	075626 ●
Homag	125	64.4	54	30	DKN	3	3x6	18xA	AS	192289	192290
IMA	125	32	34	30	DKN	2	3x4	12xD	AS	192092 ●	192093 ●
IMA	125	43	42	30	DKN	2	3x5	15xD	AS	192094 ●	192095 ●
IMA	125	63	42	30	DKN	3	3x7	21xD	AS	192096 ●	192097 ●
IMA Advan- tage	125	43	57	30	DKN	4	3x5	15xD	AS	192098 ●	192099 ●
IMA Advan- tage	125	65	57	30	DKN	4	3x7	21xD	AS	192100 ●	192101 ●
Mizrak Ma- chine	70	54	30	20	DKN	2	2x5	10xD	AS	192320 ●	192321 ●
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	192209 ●	
								3xB1			
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°		192210 ●
								3xB2			
Ott	85	65	45	30	DKN	2	3x6	18xB	AS	192227 ●	192228 ●
Ott	85	85	50	30	DKN	3	3x8	24xB	AS	192229 ●	192230 ●
SCM	100	51	60	30	DKN	3	2x6	8xB	AS°	192215 ●	192216 ●
								2xB1			
								2xB2			
SCM	100	51	60	30	DKN	3	3x6	12xB	AS°	192217 ●	192218 ●
								3xB1			
								3xB2			
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	192213 ●	
								2xB1			
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°		192214 ●
								2xB2			
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	192219 ●	
								3xB1			
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°		192220 ●
								3xB2			

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



Shape of WhisperCut spare knives  
SB 6.7 / 14 mm

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
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> ●
Turanlar Makine	70	54	30	20	DKN	2	2x5 10xD	AS	<b>192320</b> ●	<b>192321</b> ●
Turanlar Makine	70	54	30	20	DKN	2	3x5 15xD	AS	<b>192324</b>	<b>192325</b>
Turanlar Makine	125	54	30	30	DKN	3	3x5 15xE	AS	<b>192322</b> ●	<b>192323</b> ●
Törk Makine	100	65.2	40.6	30	DKN	3	3x6 18xA	AS	<b>090887</b> ●	<b>090888</b> ●

#### Spare knives:

BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	A	1	<b>091052</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A1	3	<b>091082</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A2	2	<b>091081</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	<b>091066</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	3	<b>091067</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B2	2	<b>091068</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	C	1	<b>091077</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C1	3	<b>091079</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C2	2	<b>091078</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	D	1	<b>091071</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D1	3	<b>091073</b> ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D2	2	<b>091072</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	E	1	<b>091074</b> ●
WhisperCut-knife SB14	14x14.2x4.3	DP	F	1	<b>091084</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> ●
Countersink screw, Torx® 20/59°	M5x11.5		<b>007899</b> ●
Spanner wrench	50x5	Holz-Her up to YOM 2016	<b>117538</b> ●



### WhisperCut jointing / milling cutter - cutterhead design

**Application:**

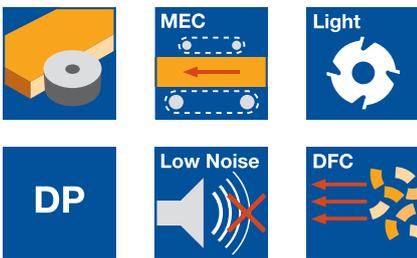
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

**Machine:**

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

**Workpiece material:**

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

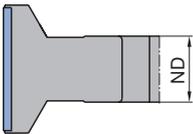


**Technical information:**

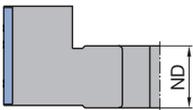
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for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

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

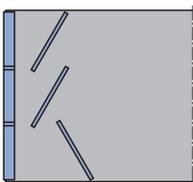
Machine	D	SB	ND	BO	NAL	$n_{max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$min^{-1}$			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
Biesse	125	63	40	30 DKN	2	13700	3x8	S	192250 ●	192250 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192251 ●	192252 ●
IMA	125	63	40	30 DKN	3	13700	3x8	AS	192301 ●	192302 ●



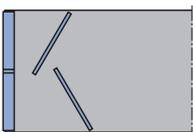
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



### WhisperCut jointing / milling cutter - cutterhead design

**Application:**

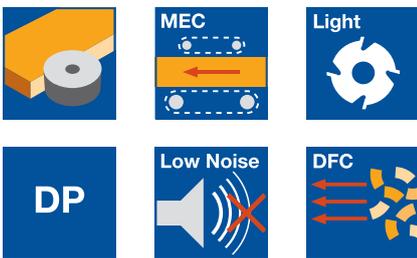
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

**Machine:**

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

**Workpiece material:**

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



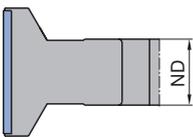
**Technical information:**

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 3.1 mm resharpening area.

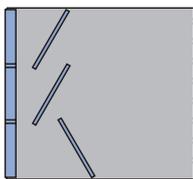
**Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body**

WM 230 2 02

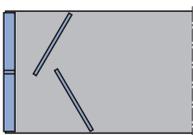
Machine	D	SB	ND	BO	NAL	$n_{max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$min^{-1}$			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192256 ●	192257 ●



Position of boss (NAL) 2



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:**

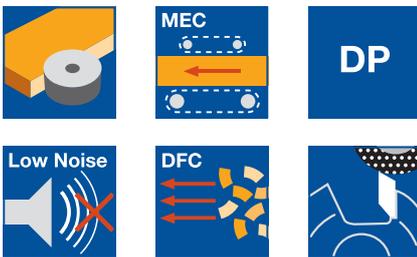
Edgebanding machines with zero joint technology.

**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.



**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>	NAL	Z	Type	ID	
								LH	RH
Homag	125	43	30	13,600	1	5x4	S	192133 □	192134 □
Homag	125	63	30	13,600	1	5x6	S	192135 □	192136 □
Homag	150	43	30	13,600	1	5x4	S	192205 □	192206 □
Homag	150	63	30	13,600	1	5x6	S	192207 □	192208 □

**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>	NAL	Z	Type	ID	
								LH	RH
IMA	125	43	30	13,700	1	4x6	AS	192259 □	192258 □
IMA	125	63	30	13,700	1	4x8	AS	192261 □	192260 □
IMA	150	43	30	13,700	1	4x6	AS	192263 □	192262 □
IMA	150	63	30	13,700	1	4x8	AS	192265 □	192264 □

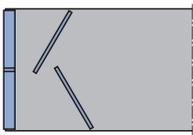
**Diamaster PRO mounted on hydro sleeve, IMA aggregate 08.379**

WM 230 2 01

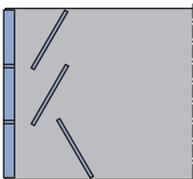
Machine	D mm	SB mm	BO mm	n <sub>max</sub> min <sup>-1</sup>	NAL	Z	ID	
							LH	RH
IMA	125	65	30	13,700	2	4x7	192313 ●	192312 ●
IMA	125	43.5	30	13,700	2	4x5	192315 ●	192314 ●

**Spare parts:**

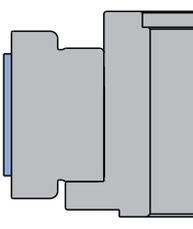
BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 30	066563 ●
Allen key	SW 5, L 150	005501 ●



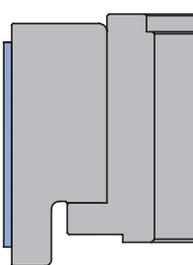
Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement



Position of boss (NAL) 1



Position of boss (NAL) 2

## 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:**

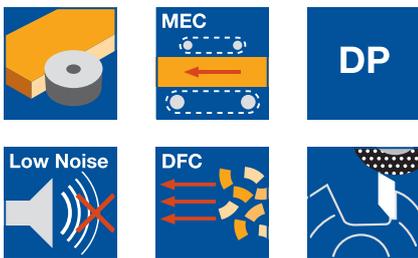
Edgebanding machines with zero joint technology.

**Workpiece material:**

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

**Technical information:**

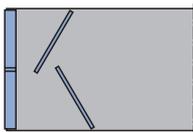
Increase of the processing quality through zero clearance HSK adaptor. Composite tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces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

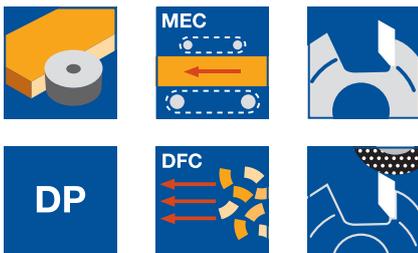
Chip and fibre boards (MDF etc.) uncoated, veneered, plastic and paper coated.

**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 PRO - 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:**

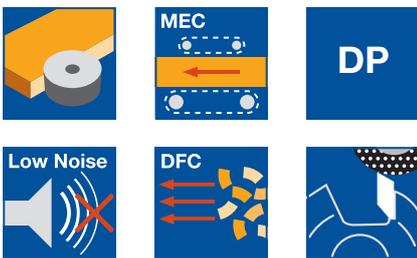
Edgebanding machines and double-end tenoners.

**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 resharpening area.



**Diamaster PRO - DFC, LowNoise**

WF 230 2 DP

Machine	D mm	SB mm	ND mm	BO mm	NAL	$n_{max}$ min <sup>-1</sup>	Z	Type	ID	ID
									LH	RH
Homag, IMA	180	32	42	35	DKN 1	9,500	4x3	AS	<b>090851</b>	<b>090852</b>
Homag, IMA	180	43	46	35	DKN 1	9,500	4x4	AS	<b>090841</b> ●	<b>090842</b> ●
Homag, IMA	180	63	46	35	DKN 3	9,500	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:**

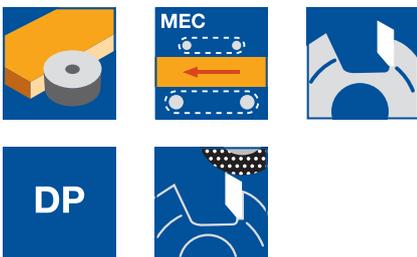
Edgebanding machines and double-end tenoners.

**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 resharpening area.



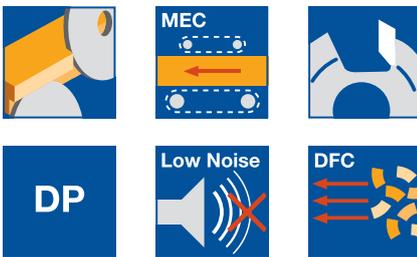
**Diamaster PLUS**

WF 230 2

Machine	D mm	SB mm	ND mm	BO mm	NAL	$n_{max}$ min <sup>-1</sup>	Z	Type	ID	ID
									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	6x5	AS	<b>192056</b>	<b>192057</b>
Homag, IMA	180	63	46	35	DKN 3	9500	6x7	AS	<b>192058</b>	<b>192059</b>
Homag, IMA	180	34	34	35	DKN 2	9500	8x4	AS	<b>192060</b>	<b>192061</b>
Homag, IMA	180	43	46	35	DKN 1	9500	8x5	AS	<b>192062</b>	<b>192063</b>
Homag, IMA	180	63	46	35	DKN 3	9500	8x7	AS	<b>192064</b>	<b>192065</b>

**Recommended feed rate for 6000 min<sup>-1</sup> for veneered or coated particle and fibre materials.**

- Z=4 25 m min<sup>-1</sup>
- Z=6 35 m min<sup>-1</sup>
- Z=8 45 m min<sup>-1</sup>
- Z=10 55 m min<sup>-1</sup>
- Z=12 65 m min<sup>-1</sup>
- Z=14 80 m min<sup>-1</sup>



### Diamaster DT Premium

#### Application:

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

#### Machine:

Double-end tenoners, edgebanding machines etc.

#### Workpiece material:

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

#### Technical information:

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

#### Diamaster DT Premium

HZ 210 2

D	SB	BO	ZF	Z	$v_f^*$	ID	ID
mm	mm	mm			m min <sup>-1</sup>	LH	RH
250	10	60	1	24	30	190382	190383
250	10	60	1	30	35	190386	190387
250	10	60	1	36	40	190390	190391
250	10	60	1	42	45	190394	190395
250	10	60	1	48	50	190398	190399
250	10	60	1	54	60	190402	190403
250	10	60	1	60	80	190406	190407
250	10	60	2	24	30	190384	190385
250	10	60	2	30	35	190388	190389
250	10	60	2	36	40	190392	190393
250	10	60	2	42	45	190396	190397
250	10	60	2	48	50	190400	190401
250	10	60	2	54	60	190404	190405
250	10	60	2	60	80	190408	190409
250	10	80	1	24	30	190410	190411
250	10	80	1	30	35	190414	190415
250	10	80	1	36	40	190418	190419
250	10	80	1	42	45	190422	190423
250	10	80	1	48	50	190426	190427
250	10	80	1	54	60	190430	190431
250	10	80	1	60	80	190434	190435
250	10	80	2	24	30	190412	190413
250	10	80	2	30	35	190416	190417
250	10	80	2	36	40	190420	190421
250	10	80	2	42	45	190424	190425
250	10	80	2	48	50	190428	190429
250	10	80	2	54	60	190432	190433
250	10	80	2	60	80	190436	190437

#### Order example:

Hogging set D-250 mm, Z 36, right  
Hogging set consisting of:  
DT Premium hogger D-250 ID **190391**  
Hydro clamping sleeve ID **061702**

#### Special information:

Including assembly, machine model

#### Tooth shape 1 (ZF 1):

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

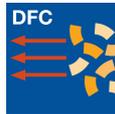
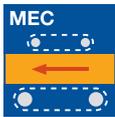
#### Tooth shape 2 (ZF 2):

For processing veneers, paper, honeycomb panels.

Further dimensions on request.

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

\* Recommended feed rate.



### Diamaster DT Premium Score

#### 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:

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

#### Diamaster DT Premium Score

HZ 210 2

D	SB	BO	ZF	Z	$v_f^*$	ID	ID
mm	mm	mm			m min <sup>-1</sup>	LH	RH
250	10	60	1	24	18	<b>190438</b>	<b>190439</b>
250	10	60	1	36	25	<b>190442</b>	<b>190443</b>
250	10	60	1	48	30	<b>190446</b>	<b>190447</b>
250	10	60	1	60	40	<b>190450</b>	<b>190451</b>
250	10	60	2	24	18	<b>190440</b>	<b>190441</b>
250	10	60	2	36	25	<b>190444</b>	<b>190445</b>
250	10	60	2	48	30	<b>190448</b>	<b>190449</b>
250	10	60	2	60	40	<b>190452</b>	<b>190453</b>
250	10	80	1	24	18	<b>190454</b>	<b>190455</b>
250	10	80	1	36	25	<b>190458</b>	<b>190459</b>
250	10	80	1	48	30	<b>190462</b>	<b>190463</b>
250	10	80	1	60	40	<b>190466</b>	<b>190467</b>
250	10	80	2	24	18	<b>190456</b>	<b>190457</b>
250	10	80	2	36	25	<b>190460</b>	<b>190461</b>
250	10	80	2	48	30	<b>190464</b>	<b>190465</b>
250	10	80	2	60	40	<b>190468</b>	<b>190469</b>

#### Order example:

Hogging set D-250 mm, Z 36, right

Hogging set consisting of:

DT Premium Score hogger D-250

ID **190443**

Hydro clamping sleeve ID **061702**

#### Special information:

Including assembly, machine model

#### Tooth shape 1 (ZF 1):

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

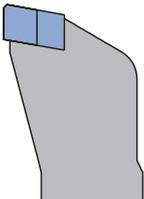
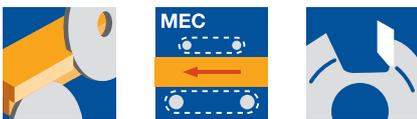
#### Tooth shape 2 (ZF 2):

For processing veneers, paper, honeycomb panels.

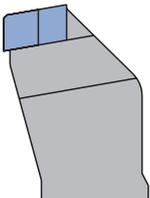
Further dimensions and version with veneer cutting edges (FUZ) on request.

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

\* Recommended feed rate.



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.

### 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.

#### 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 <sup>-1</sup>	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 <sup>-1</sup>	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.

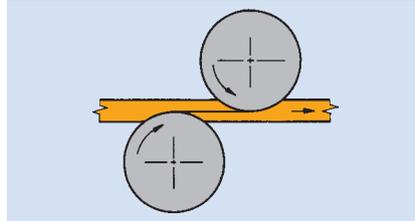
\* Recommended feed rate for coated chipboard materials and fibre materials.

## 2. Panel processing

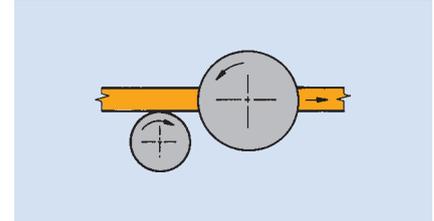
### 2.1 Edge processing 2.1.4 Cutting and segment hoggers

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

#### Application



Double hogging:  
Both hogs cut with feed.



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

#### Recommended tooth shape hogger sawblades

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

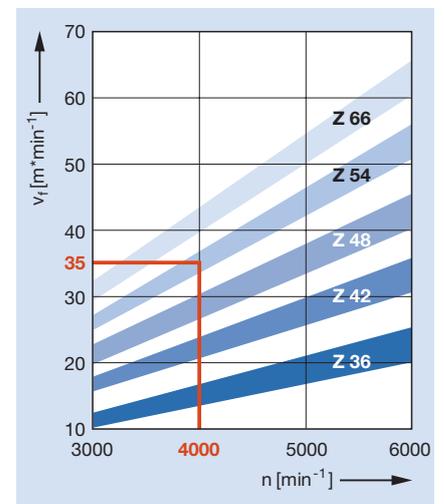
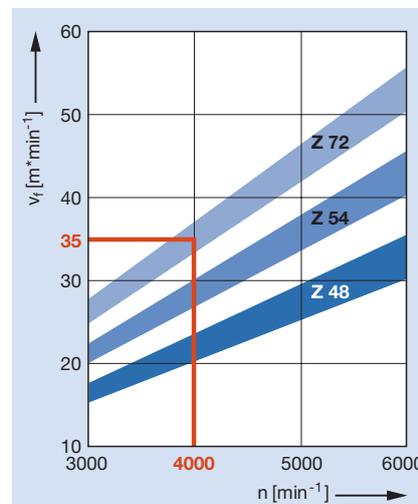
- suitable
- partly suitable

#### Cutting width and RPM

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

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

#### Segment hogger



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

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.4 Cutting and segment hoggers

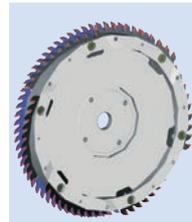
##### Segment hogger

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

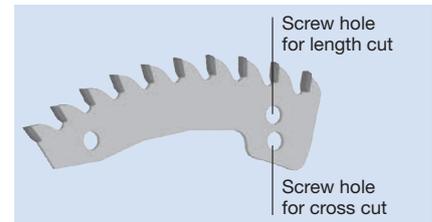
- Solid wood
- Wood derived materials without coating
- Wood derived materials with coating, with veneer, with paper etc.
- Composite materials



Cross cut



Length cut



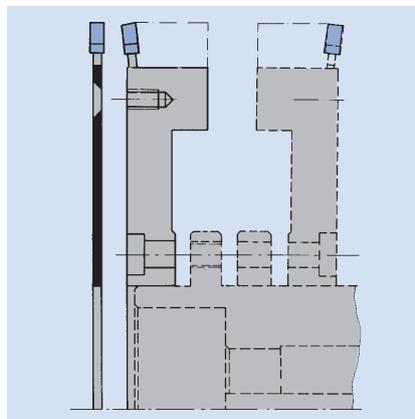
The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.

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

##### Saw hogger

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

##### Assembly design/examples



Segment hogger with extension hogger.



### Hoggers

#### Application:

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

#### Machine:

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

#### Workpiece material:

Solid wood and wood derived materials.

#### Technical information:

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



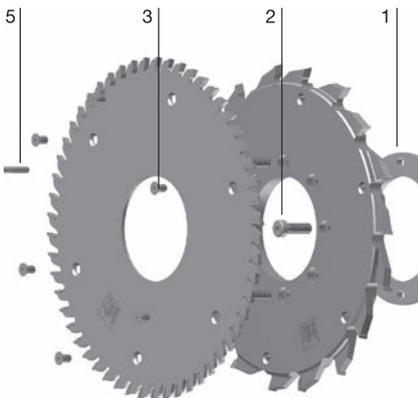
#### Basic hogger - steel tool body without flanged sleeve

WZ 210 2 01

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

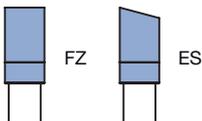
D mm	SB mm	BO mm	Z	QAL	ID LH	ID RH
251	12	80	18	HW	<b>062652</b> ●	<b>062653</b> ●
251	12	80	24	HW	<b>062654</b> ●	<b>062655</b> ●

#### 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> ●
260	4.4	80	72	FZ	HW	<b>061947</b> ●	<b>061948</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:

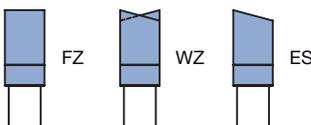
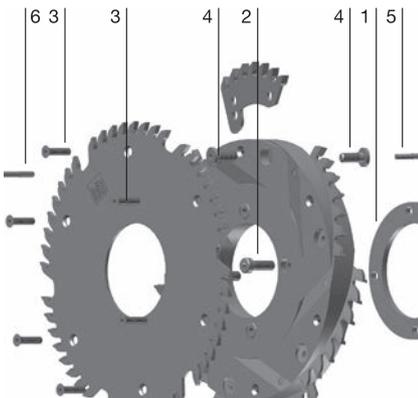
Double-end tenoners, finger joint machine with trimming aggregate, plug cutter.

#### 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

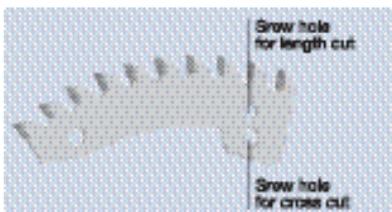
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

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> ●

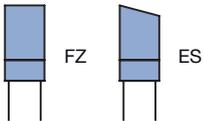
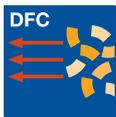


Spare segments for segment hogger

## 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:

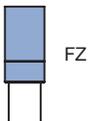
Tooth shape **ES** is optimised to cut across grain on softwood, hardwood, wood derived materials, veneered and paper coated and veneered composite materials.

#### 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.

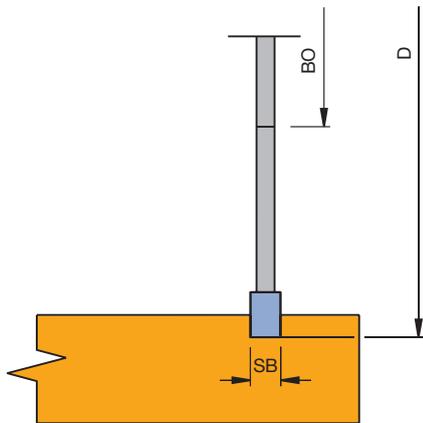
## 2. Panel processing

### 2.1 Edge processing

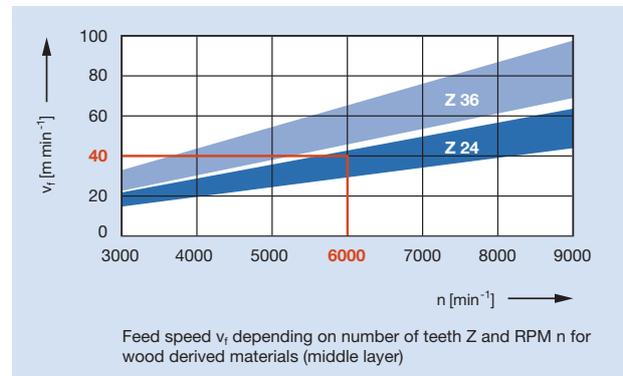
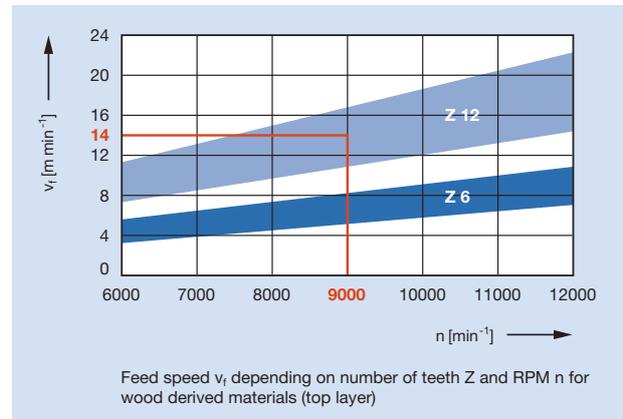
#### 2.1.5 Grooving cutters

##### Grooving with feed

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



Cutting rear panel grooves

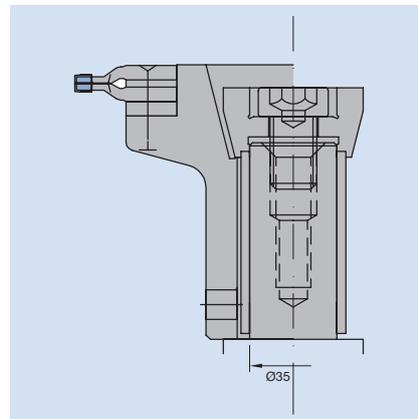


##### Grooving against feed

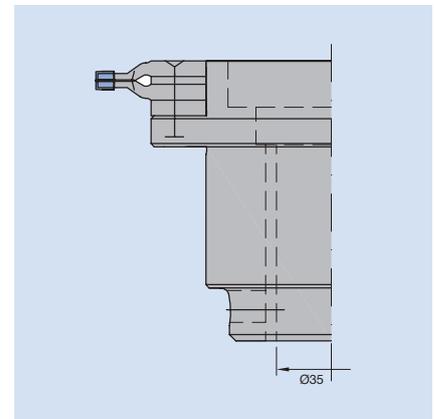
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

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

Tools for grooving against feed available on request.



Assembly example:  
Spindle 30 KN or DKN



Assembly example:  
Spindle 35 KN or DKN



#### Grooving cutter for mechanical feed

**Application:**

Grooving with feed (climb cut).

**Machine:**

Moulders and double-end tenoners.

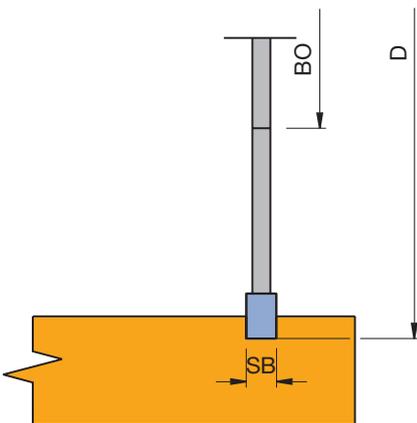
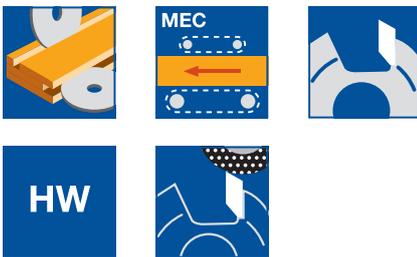
**Workpiece material:**

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

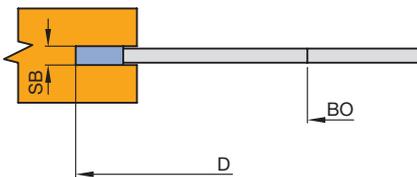
**Z 12, HW tipped**

WF 100 2 02

D	SB	TDI	BO	BO <sub>max</sub>	Z	n <sub>max</sub> min <sup>-1</sup>	ID
mm	mm	mm	mm	mm			
125	1,5	0,8	30	50	12	13,700	020145 ●
125	2,0	1,2	30	50	12	13,700	020147 ●
125	2,5	1,4	30	50	12	13,700	020149 ●
125	3,0	2,0	30	50	12	13,700	020150 ●
125	3,5	2,2	30	50	12	13,700	020151 ●
125	4,0	2,5	30	50	12	13,700	020152 ●
125	4,5	3,0	30	50	12	13,700	020153 ●
125	5,0	3,5	30	50	12	13,700	020191 ●
125	6,0	4,5	30	50	12	13,700	020192 ●
125	7,0	5,0	30	50	12	13,700	020193 ●
125	8,0	6,0	30	50	12	13,700	020194 ●
125	10,0	7,0	30	50	12	13,700	020196 ●
150	3,0	2,0	30	60	12	11,400	020154 ●
150	3,5	2,2	30	60	12	11,400	020155 ●
150	4,0	2,5	30	60	12	11,400	020156 ●
150	4,5	3,0	30	60	12	11,400	020157 ●
150	5,0	3,5	30	60	12	11,400	020158 ●
150	6,0	4,5	30	60	12	11,400	020159 ●
150	7,0	5,0	30	60	12	11,400	020160 ●
150	8,0	6,0	30	60	12	11,400	020161 ●
150	10,0	7,0	30	60	12	11,400	020163 ●



Cutting the back panel groove



Grooving the edge



#### Grooving cutter for mechanical feed

##### Application:

Grooving with feed (climb cut).

##### Machine:

Moulders and double-end tenoners.

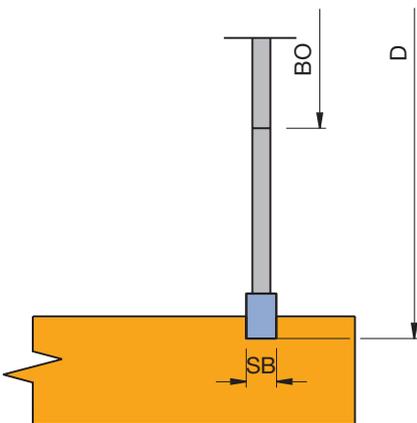
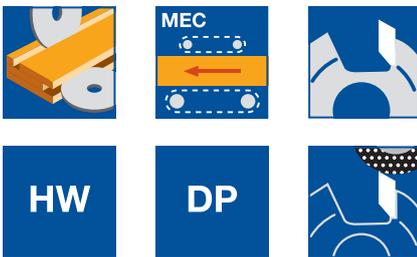
##### Workpiece material:

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

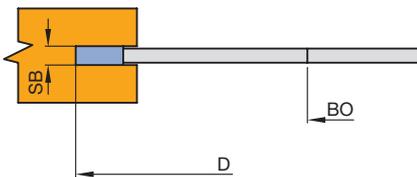
##### Z 18, HW tipped

WF 100 2 03

D	SB	TDI	BO	BO <sub>max</sub>	DKN	Z	ZF	QAL	n <sub>max</sub> min <sup>-1</sup>	ID
150	1.5	0.8	30	60		18	FZ	HW	11,400	020164 ●
150	2,0	1.2	30	60		18	FZ	HW	11,400	020166 ●
150	2.5	1.4	30	60		18	FZ	HW	11,400	020168 ●
150	3,0	2,0	30	60		18	FZ	HW	11,400	020169 ●
150	4,0	2.5	30	60		18	FZ	HW	11,400	020170 ●
150	5,0	3.5	30	60		18	FZ	HW	11,400	020171 ●
150	6,0	4.5	30	60		18	FZ	HW	11,400	020172 ●
150	8,0	6,0	30	60		18	FZ	HW	11,400	020173 ●
150	8.5	6,0	30	60		18	FZ	HW	11,400	020319 ●
150	10,0	7,0	30	60		18	FZ	HW	11,400	020174 ●
180	2,0	1.2	30	70		18	FZ	HW	9,500	020202 ●
180	2.5	1.4	30	70		18	FZ	HW	9,500	020203 ●
180	3,0	2,0	30	70		18	FZ	HW	9,500	020204 ●
180	3.5	2.2	30	70		18	FZ	HW	9,500	020205 ●
180	4,0	2.5	30	60		18	FZ	HW	9,500	020197 ●
180	5,0	3.5	30	60		18	FZ	HW	9,500	020198 ●
180	6,0	4.5	30	60		18	FZ	HW	9,500	020199 ●
180	8,0	6,0	30	60		18	FZ	HW	9,500	020200 ●
180	8.5	6,0	30	60		18	FZ	HW	9,500	020320 ●
180	10,0	7,0	30	60		18	FZ	HW	9,500	020201 ●
200	2,0	1.2	35	80	10x45	18	FZ	HW	8,500	020299 ●
200	2.5	1.4	35	80	10x45	18	FZ	HW	8,500	020301 ●
200	3,0	2,0	35	80	10x45	18	FZ	HW	8,500	020302 ●
200	4,0	2.5	35	80	10x45	18	FZ	HW	8,500	020303 ●
200	5,0	3.5	35	80	10x45	18	FZ	HW	8,500	020304 ●
200	6,0	4.5	35	80	10x45	18	FZ	HW	8,500	020305 ●
200	8,0	6,0	35	80	10x45	18	FZ	HW	8,500	020306 ●
200	8.5	6,0	30	80	10x45	18	FZ	HW	8,500	020321 ●
200	10,0	7,0	35	80	10x45	18	FZ	HW	8,500	020307 ●



Cutting the back panel groove



Grooving the edge

##### DP tipped

WF 100 2, WF 100 2 DP

D	SB	TDI	BO	BO <sub>max</sub>	NLA	Z	ZF	QAL	n <sub>max</sub> min <sup>-1</sup>	ID
150	4,0	2.5	30	60		18	FZ	DP	11,400	192304 ●
180	4,0	2.5	30	60		24	FZ	DP	9,500	192305 ●
180	8.5	6,5/8,5	80		4/9/100	35	WZ/WZ/	DP	9,500	190755 ●
					4/9/100		FZ			
200	4,0	2.5	30	80		24	FZ	DP	8,500	192306 ●

##### DP tipped, mounted on flanged sleeve ID 61681

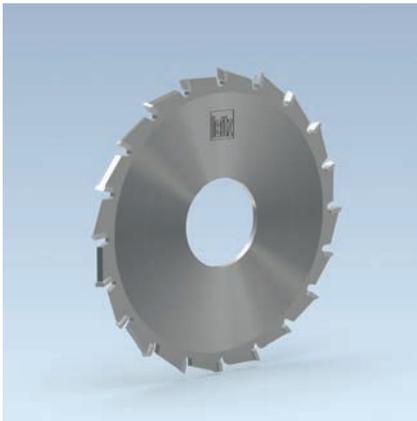
SF 500 2

D	SB	BO	DKN	Z	ZF	QAL	n <sub>max</sub> min <sup>-1</sup>	ID
180	8.5	35	10x43	35	WZ/WZ/FZ	DP	9,500	190756 □

● available ex stock

□ available at short notice

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



### Circular sawblade for end trim on edgeworking machines

#### Application:

For low noise edgeworking trim cuts.

#### Machine:

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

#### Workpiece material:

Veneered, melamine and plastic edging.

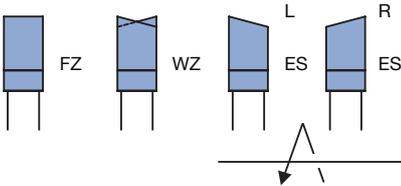
#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

#### Veneered and plastic edging:

Edging thickness  $\geq 2.0$  mm - crosscut saw ES pos.

Edging thickness  $< 2.0$  mm - crosscut saw ES neg.



#### Circular sawblade - LowNoise

SK 499 2, WK 101 2, WK 300 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 372 2

Machine	D mm	SB mm	BO mm	NLA mm	Z	ZF	ID	
							LH	RH
Biesse	115	3.2	52	3/7,1/64	30	ES pos.	<b>166420</b>	<b>166421</b>
Biesse	115	3.2	56	3/7,1/68	30	ES pos.	<b>166422</b>	<b>166423</b>
Biesse	130	3.6	30	4/7,4/46	24	ES pos.	<b>166424</b>	<b>166425</b>
Biesse	140	3.2	30		36	ES pos.	<b>166427</b>	<b>166426</b>
Brandt	100	2.6	32		30	ES neg.	<b>166400</b>	<b>166401</b>
Brandt	100	2.6	32		30	ES pos.	<b>166429</b>	<b>166430</b>
Brandt	110	2.4	32		40	ES pos.	<b>166432</b>	<b>166433</b>
Brandt	125	2.6	32		30	ES neg.	<b>166403</b>	<b>166404</b>
Brandt	150	2.8	20		36	ES pos.	<b>166434</b>	<b>166435</b>
Cehisa	100	3.0	32		30	ES pos.	<b>166436</b>	<b>166437</b>
Fravol	100	3.2	22		24	ES pos.	<b>166407</b>	<b>166406</b>
Fravol	100	2.6	30		30	ES pos.	<b>166476</b>	<b>166477</b>
Fravol	125	3.2	22		30	ES pos.	<b>166411</b>	<b>166410</b>
Holz-Her	110	3.6	22		16	ES pos.	<b>166439</b>	<b>166440</b>
Homag	80	3.2	34	8/4,2/44	30	ES pos.	<b>166443</b>	<b>166444</b>
Homag	92	3.0	32	2/3/52	20	ES pos.	<b>166471</b>	<b>166470</b>
* Homag	100	3.0	32		20	ES pos.	<b>166445</b>	<b>166446</b>
Homag	100	3.0	32	2/3,8/52	20	ES pos.	<b>166447</b>	<b>166448</b>
Homag	100	3.2	32		20	ES neg.	<b>166449</b>	<b>166450</b>
Homag	100	2.6	32		30	ES neg.	<b>166400</b>	<b>166401</b>
Homag	100	2.6	32		30	ES pos.	<b>166429</b>	<b>166430</b>
Homag	110	2.4	32		40	ES pos.	<b>166432</b>	<b>166433</b>
Homag	110	1.7	40	4/5,5/52	30	FZ/TR pos.	<b>166453</b>	<b>166453</b>
* Homag	120	3.2	40		30	ES pos.	<b>166454</b>	<b>166455</b>
Homag	125	2.6	32		30	ES neg.	<b>166403</b>	<b>166404</b>
Homag	150	2.8	20		36	ES pos.	<b>166434</b>	<b>166435</b>
Homag	150	3.5	30	4/5,6/52	40	ES pos.	<b>166458</b>	<b>166459</b>
IDM	90	3.0	30		20	FZ pos.	<b>166461</b>	<b>166461</b>
SCM	150	3.8	35	4/6,5/50	30	ES pos.	<b>166468</b>	<b>166469</b>
Törk Makine	140	3.2	30		36	ES pos.	<b>166417</b>	<b>166418</b>
Wiltsmeyer	100	3.2	32		20	ES neg.	<b>166449</b>	<b>166450</b>

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

**Workpiece material:**

Softwood, hardwood edging.

**Technical information:**

Tooth geometries and pitch designed for optimum cutting quality.

**Solid wood edging and multi-purpose application:**Edging thickness  $\geq$  2.0 mm - crosscut saw WZ pos.Edging thickness  $<$  2.0 mm - crosscut saw WZ neg.**Circular sawblade - LowNoise, WZ**

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

Machine	D	SB	BO	NLA	Z	ZF	ID	ID
	mm	mm	mm	mm			LH	RH
Biesse	100	3.2	30		20	WZ pos.	166478 ●	166478 ●
Biesse	160	3.2	20		48	WZ pos.	166428 ●	166428 ●
Brandt	100	2.6	32		30	WZ pos.	166431 ●	166431 ●
Brandt	125	2.4	32		24	WZ pos.	166402 ●	166402 ●
EBM	100	2.4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Felder	100	3.2	22		20	WZ pos.	166438 ●	166438 ●
Felder	110	3.2	30		20	WZ pos.	166475 ●	166475 ●
Hebrock	100	2.4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Holz-Her	110	3.6	22		20	WZ pos.	065663 ●	065663 ●
Holz-Her	120	3.2	22		20	WZ pos.	166474 ●	166474 ●
Holz-Her	140	3.2	22		36	WZ pos.	166441 ●	166441 ●
Holz-Her	160	3.2	20		48	WZ pos.	166428 ●	166428 ●
Holz-Her	160	3.2	30		24	WZ pos.	065664 ●	065664 ●
Homag	100	3.6	32		20	WZ pos.	166451 ●	166451 ●
Homag	100	2.6	32		30	WZ pos.	166431 ●	166431 ●
Homag	110	3.6	32		20	WZ pos.	166452 ●	166452 ●
Homag	120	3.6	40	8/5,6/52	24	WZ pos.	166419 ●	166419 ●
Homag	120	3.2	40	8/5,6/52	36	WZ pos.	166456 ●	166456 ●
Homag	120	3.6	40	8/5,6/52	36	WZ pos.	166457 ●	166457 ●
Homag	125	2.4	30	8/6,5/48	36	WZ pos.	058234 ●	058234 ●
Homag	125	2.4	32		24	WZ pos.	166402 ●	166402 ●
Homag	170	3.2	30	8/5,6/52	36	WZ pos.	166412 ●	166412 ●
Homag	180	3.2	30	4/5,6/52	54	WZ pos.	166460 ●	166460 ●
IMA	160	3.5	22		36	WZ neg.	166462 ●	166462 ●
IMA	160	3.2	22		48	WZ neg.	166414 ●	166414 ●
IMA	180	3.2	22		48	WZ pos.	166463 ●	166463 ●
IMA	180	3.2	22		48	WZ neg.	166464 ●	166464 ●
IMA	200	3.2	22		64	WZ pos.	166479 ●	166479 ●
IMA 08.415	180	3.5	22		42	WZ neg.	166415 ●	166415 ●
IMA 08.492	160	3,0	22		36	WZ pos.	166413 ●	166413 ●
Ott	140	3.2	16		36	WZ pos.	166466 ●	166466 ●
Raimann	100	3.6	32		20	WZ pos.	166451 ●	166451 ●
Raimann	120	3.2	32		20	WZ neg.	166467 ●	166467 ●
SCM	115	3.2	30		30	WZ pos.	166416 ●	166416 ●

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools

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



### Pre / finishing edge trimming cutter

**Application:**

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

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

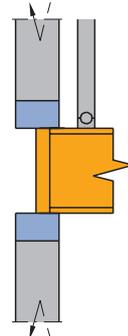
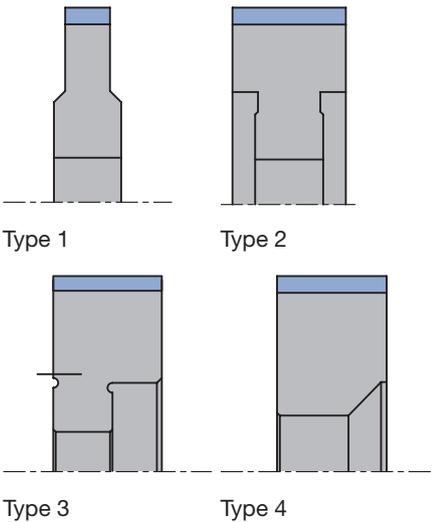
HW/DP tipped tools with cylindrical bore.

**Joining cutter**

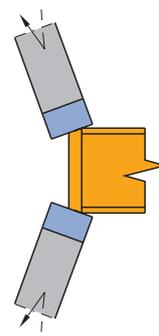
WF 200 2, WF 200 2 DP, WF 210 2 DP



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 ●



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:**

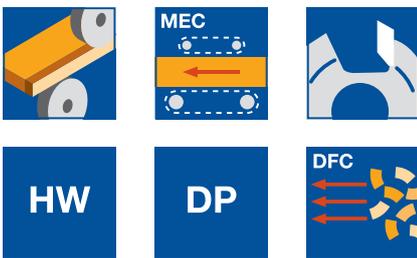
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

**Workpiece material:**

Plastic, softwood, hardwood and veneer 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.



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

WF 200 2 DP, WF 210 2

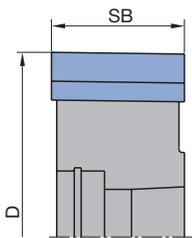
Machine	D	SB	BO	Z	QAL	$n_{max}$ min <sup>-1</sup>	ID	ID
	mm	mm	mm				LH	RH
Homag, IMA	70	25	HSK 25 R	4	HW	18000	<b>073092</b> ●	<b>073093</b> ●
Homag, IMA	70	8	HSK 25 R	4	DP	18000	<b>198472</b> ●	<b>198473</b> ●
Homag, IMA	70	8	HSK 25 R	6	DP	18000	<b>198474</b> ●	<b>198475</b> ●
Homag, IMA	70	8	HSK 25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

**Recommended number of teeth:**

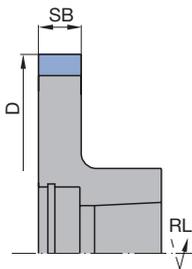
Feed rates of up to 35 m min<sup>-1</sup> Z 4

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-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

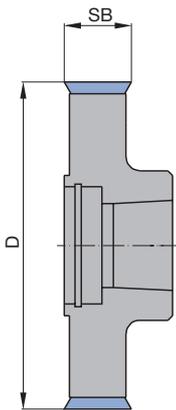
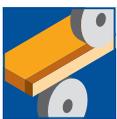
**Technical information:**

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

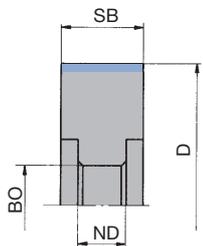
**Joining cutterhead**

WW 200 2, 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	<b>025130 ●</b>	<b>025130 ●</b>
Homag	1	70	14.3	HSK 25 R	4	12000	<b>073599 ●</b>	<b>073600 ●</b>
Homag	2	70	20	16 DKN	4	18000	<b>025079 ●</b>	<b>025079 ●</b>
Ott, Holz-Her	2	70	20	16	4	18000	<b>025078</b>	<b>025078</b>
Holz-Her 1962	2	80	40	30 KN	4	18000	<b>024415</b>	<b>024415</b>



Type 1: WW 200 2 25



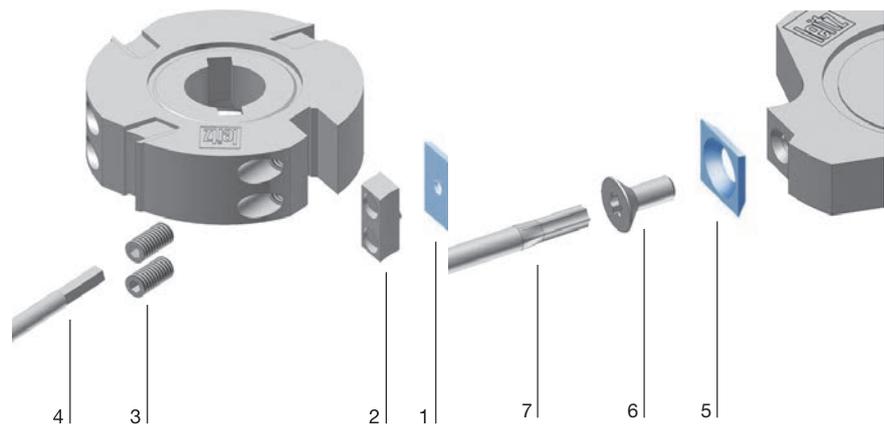
Type 2: WW 200 2 06

**Spare knives:**

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	20x12x1.5	HW-05F	10	<b>005083 ●</b>
1	Turnblade knife	40x12x1.5	HW-05F	10	<b>005085 ●</b>
5	Turnblade knife	14.3x14.3x2.5	HW	10	<b>005426 ●</b>

**Spare parts:**

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





### Bevel cutter

**Application:**

To bevel edgebandings.

**Machine:**

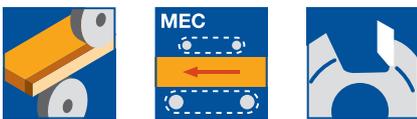
Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

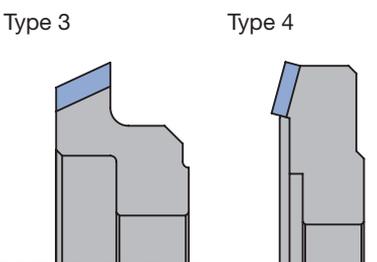
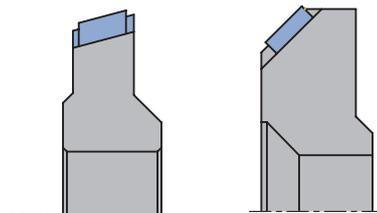
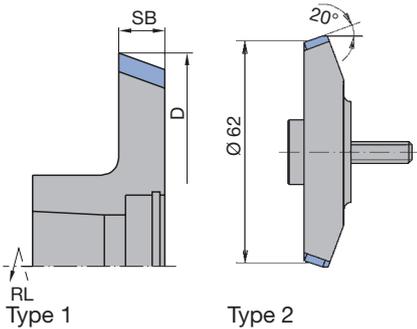
DP tipped tools with cylindrical bore, HSK 25 R or HSK 32 adaptor for FK aggregates.



**Various bevel angles - DP tipped**

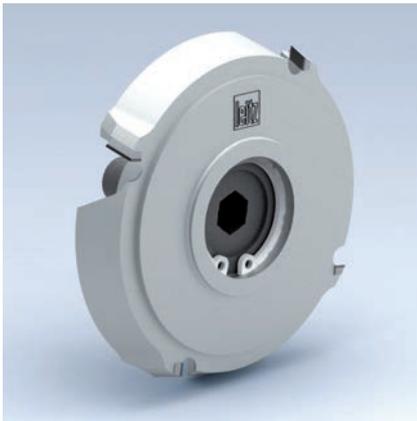
WF 300 2 DP, WF 350 2 DP

Machine	D mm	SB mm	BO mm	Type	Z	QAL	FAW °	ID	
								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



## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



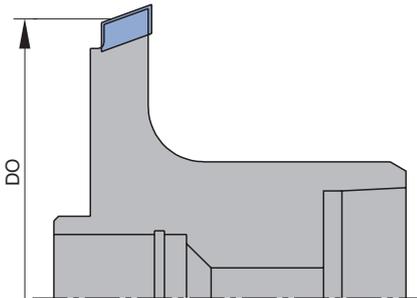
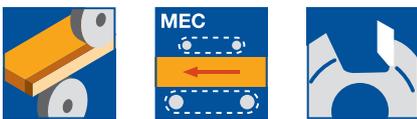
#### Bevel cutter *iQsystem*

**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:**  
Plastic, softwood, hardwood and veneer 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.



#### Various bevel angles *iQsystem* - 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>

Bevel cutter with HSK 32 adaptor for FK aggregates



### Profile cutter

#### Application:

To round edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

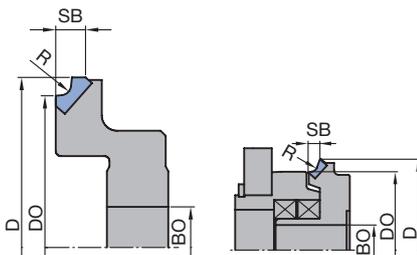
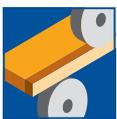
#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

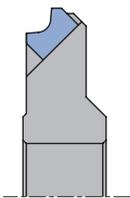
DP tipped tools with cylindrical bore or HSK 25 R adaptor.

$D_0$  = constant reference diameter.

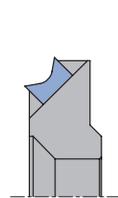


Type 1

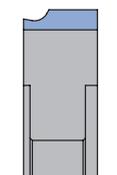
Type 2



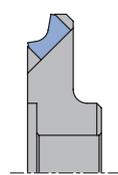
Type 3



Type 4



Type 5



Type 6

#### Various radii

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

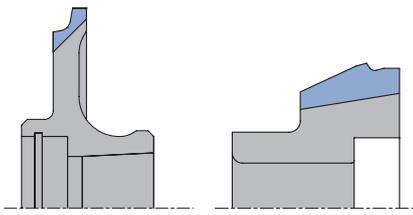
Machine	D	$D_0$	BO	Z	QAL	R	Type	$n_{max}$	ID	ID
	mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
Biesse	67	60	16 DKN	6	DP	1,0	1	18,000	091960 ●	091961 ●
Biesse	68	60	16 DKN	6	DP	2,0	1	18,000	091962 ●	091963 ●
Biesse	70	60	16 DKN	6	DP	3,0	1	18,000	091964 ●	091965 ●
Biesse	72	70	16 KN	6	DP	1,0	5	18,000	192518 ●	192519 ●
Biesse	73	70	16 KN	6	DP	2,0	5	18,000	192520 ●	192521 ●
Biesse	75	70	16 KN	6	DP	3,0	5	18,000	192522 ●	192523 ●
* Brandt	58	50	16 DKN	4	DP	1,0	2	12,000		091999 □
** Brandt	58	50	16 DKN	4	DP	1,5	2	18,000		192602 ●
* Brandt	58	50	16 DKN	4	DP	2,0	2	12,000		091966 ●
** Brandt	58	50	16 DKN	4	DP	2,0	2	18,000		192603 ●
Brandt	70	62	HSK 25 R	4	DP	1,0	7	18,000	192588 ●	192589 ●
Brandt	70	62	HSK 25 R	4	DP	1,3	7	18,000	192590 ●	192591 ●
Brandt	70	62	HSK 25 R	4	DP	1,5	7	18,000	192592 ●	192593 ●
Brandt	70	62	HSK 25 R	4	DP	2,0	7	18,000	192594 ●	192595 ●
Brandt	70	62	HSK 25 R	4	DP	3,0	7	18,000	192596 ●	192597 ●
EBM	32	24	14 DKN	2	DP	2,0	3	18,000	074526 ●	
EBM	56	49.7	16 DKN	2	DP	2,0	6	18,000	192669 ●	192670 ●
EBM	56	49.7	16 DKN	2	DP	2,5	6	18,000	192641 ●	192642 ●
Fravol	50	39.91	15 KN	4	DP	1-3	11	18,000		192665 ●
Fravol	50	40.1	15 KN	4	DP	1-3	10	18,000	192663 ●	192664 ●
Fravol	50	39.91	15 KN	6	HW	1-3	11	18,000		065594 ●
Fravol	73	71.15	20 DKN	4	DP	1-3	8	18,000	192645 ●	192646 ●
Fravol	76.8	74.71	20 DKN	4	DP	1-3	9	18,000	192647 ●	192648 ●
Hebrock	32	24	14 DKN	2	DP	2,0	3	18,000	074526 ●	
Hebrock	56	49.7	16 DKN	2	DP	2,0	6	18,000	192669 ●	192670 ●
Hebrock	56	49.7	16 DKN	2	DP	2,5	6	18,000	192641 ●	192642 ●
Holz-Her	57	50	16 DKN	2	DP	2,0	3	24,000	192536 ●	192537 ●
Holz-Her	57	50	16 DKN	2	DP	2,5	3	24,000	192538 ●	192539 ●
Holz-Her	57	50	16 DKN	2	DP	3,0	3	24,000	192540 ●	192541 ●
Holz-Her	56	50	20 DKN	2	DP	2,0	4	24,000	192506 ●	192507 ●
Holz-Her	56	50	20 DKN	2	DP	2,5	4	24,000	192508 ●	192509 ●
Holz-Her	57	50	20 DKN	2	DP	3,0	4	24,000	192510 ●	192511 ●

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

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

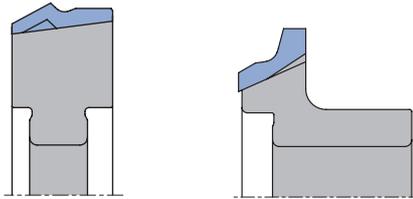
## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



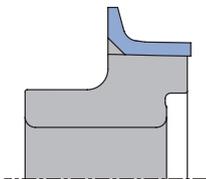
Type 7

Type 8



Type 9

Type 10



Type 11

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	Type	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Holz-Her 1832	58.7	50	16 DKN	3	DP	2,0	3	24,000	192512 ●	192513 ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	2.5	3	24,000	192514 ●	192515 ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	3,0	3	24,000	192516 ●	192517 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2,0	4	18,000	192500 ●	192501 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2.5	4	18,000	192502 ●	192503 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	3,0	4	18,000	192504 ●	192505 ●
* Homag	58	50	16 DKN	4	DP	1,0	2	12,000		091999 □
** Homag	58	50	16 DKN	4	DP	1.5	2	18,000		192602 ●
* Homag	58	50	16 DKN	4	DP	2,0	2	12,000		091966 ●
** Homag	58	50	16 DKN	4	DP	2,0	2	18,000		192603 ●
Homag	70	62	HSK 25 R	4	DP	1,0	7	18,000	192588 ●	192589 ●
Homag	70	62	HSK 25 R	4	DP	1.3	7	18,000	192590 ●	192591 ●
Homag	70	62	HSK 25 R	4	DP	1.5	7	18,000	192592 ●	192593 ●
Homag	70	62	HSK 25 R	4	DP	2,0	7	18,000	192594 ●	192595 ●
Homag	70	62	HSK 25 R	4	DP	3,0	7	18,000	192596 ●	192597 ●
Ott	69	61	16 DKN	3	DP	2,0	1	18,000	192649 ●	192650 ●
Ott	69	61	16 DKN	4	DP	2,0	1	18,000	192651 ●	192652 ●
Stefani	51.5	49.71	16 DKN	4	HW	1,0	8	18,000	192657 ●	192658 ●
Stefani	51.5	49.71	16 DKN	4	HW	1.5	8	18,000	192659 ●	192660 ●
Stefani	51.5	49.71	16 DKN	4	HW	2,0	8	18,000	192661 ●	192662 ●
Stefani	70	60	16 DKN	4	DP	1,0	6	18,000	192524 ●	192525 ●
Stefani	70	60	16 DKN	4	DP	2,0	6	18,000	192526 ●	192527 ●
Stefani	70	60	16 DKN	4	DP	3,0	6	18,000	192528 ●	192529 ●
Törk Makine	46	39	16	4	DP	2,0	3	18,000	192643 ●	192644 ●

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

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



### Profile cutter

**Application:**

To round (profile) edgebandings on FK aggregate.

**Machine:**

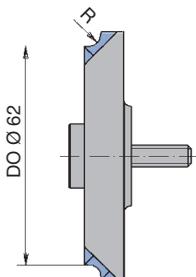
Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

DP tipped tools with HSK 32 adaptor for FK-aggregates. High concentricity.  
 $D_0$  = constant reference diameter.



Type 1

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

WF 501 2 DP

Machine	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	Type	n <sub>max</sub> min <sup>-1</sup>	ID	
								LH	RH
Homag	62	HSK 32	4	DP	1.0	1	18000	091500	091501
Homag	62	HSK 32	4	DP	1.5	1	18000	091502	091503
Homag	62	HSK 32	4	DP	2.0	1	18000	091504	091505
Homag	62	HSK 32	4	DP	2.5	1	18000	091506	091507
Homag	62	HSK 32	4	DP	3.0	1	18000	091508	091509
Homag	62	HSK 32	6	DP	1.0	1	18000	091672	091673
Homag	62	HSK 32	6	DP	1.5	1	18000	091674	091675
Homag	62	HSK 32	6	DP	2.0	1	18000	091650	091651
Homag	62	HSK 32	6	DP	2.5	1	18000	091676	091677
Homag	62	HSK 32	6	DP	3.0	1	18000	091652	091653



### Profile cutter

#### Application:

For a choice of radii or bevels on edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

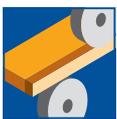
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

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°.

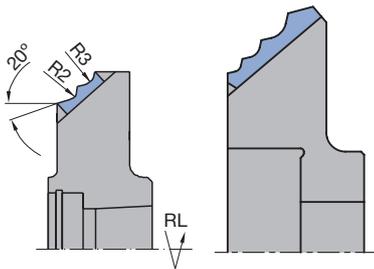
$D_0$  = constant reference diameter.



### Multi-profile cutter - Diamaster PRO

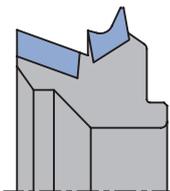
WF 501 2, WF 501 2 DP, WF 501 2 DP , WF 502 2 DP, WF 502 2 DP

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 ●
Holz-Her FR 701	71	68	16 DKN	6	4	3/2/1.3	45°	18000	192673 ●	192674 ●
Holz-Her FR 701	71	68	16 DKN	6	4	2/2/1.3	45°	18000	192675 ●	192676 ●
Holz-Her FR 701	71	68	16 DKN	6	4	2/1.3/1.3	45°	18000	192677 ●	192678 ●
Holz-Her FR 701	71	68	16 DKN	6	4	3/2/1.3	10°	18000	192679 ●	192680 ●
Holz-Her FR 701	71	68	16 DKN	6	4	1.3/1/0.8	45°	18000	192681 ●	192682 ●
Homag	74.33	65.7	HSK 25 R	4	4	1/2		18000	198506 ●	198507 ●
Homag	74.67	65.7	HSK 25 R	4	4	1.3/2		18000	198508 ●	198509 ●
Homag	85	65.2	HSK 25 R	1	4	2/3	20°	18000	091798 ●	091799 ●
Homag	74.33	62.99	16 DKN	5	4	1/2		18000	192683 ●	192684 ●
Homag	74.66	65.69	16 DKN	5	4	1.3/2		18000	192685 ●	192686 ●
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 ●

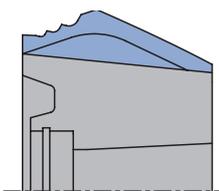


Type 1

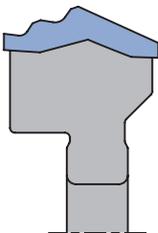
Type 2



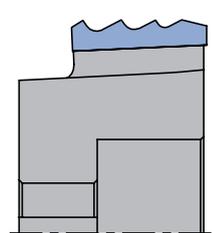
Type 3



Type 4



Type 5



Type 6

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



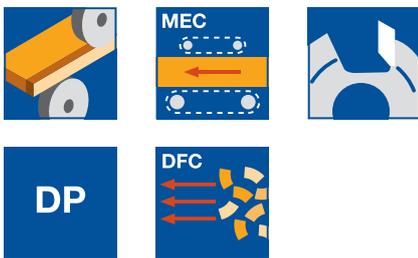
### Profile cutter *iQsystem*

**Application:**  
To round edgebandings.

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

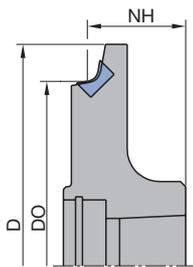
**Workpiece material:**  
Plastic, softwood, hardwood and veneer edgebander.

**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.

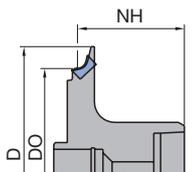


#### Various radii *iQsystem* - Diamaster PRO, HSK 25 R WF 501 2 DP

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	17.5	HSK 25 R	4	DP	1.0	18000	<b>198494</b> ●	<b>198484</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	4	DP	1.5	18000	<b>198495</b> ●	<b>198485</b> ●	
Homag, IMA 76	70	18.5	HSK 25 R	4	DP	2.0	18000	<b>198496</b> ●	<b>198486</b> ●	
Homag, IMA 78	70	19	HSK 25 R	4	DP	2.5	18000	<b>198497</b> ●	<b>198487</b> ●	
Homag, IMA 78	70	19.5	HSK 25 R	4	DP	3.0	18000	<b>198498</b> ●	<b>198488</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	6	DP	1.0	18000	<b>198499</b> ●	<b>198489</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	6	DP	1.5	18000	<b>198500</b> ●	<b>198490</b> ●	
Homag, IMA 76	70	18.5	HSK 25 R	6	DP	2.0	18000	<b>198501</b> ●	<b>198491</b> ●	
Homag, IMA 78	70	19	HSK 25 R	6	DP	2.5	18000	<b>198502</b> ●	<b>198492</b> ●	
Homag, IMA 78	70	19.5	HSK 25 R	6	DP	3.0	18000	<b>198503</b> ●	<b>198493</b> ●	



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.

#### 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	<b>198212</b> ●	<b>198213</b> ●
Homag	75	62	31.5	HSK 32	4	DP	1.5	18000	<b>198214</b> ●	<b>198215</b> ●
Homag	75	62	31.5	HSK 32	4	DP	2.0	18000	<b>198216</b> ●	<b>198217</b> ●
Homag	75	62	31.5	HSK 32	4	DP	2.5	18000	<b>198220</b> ●	<b>198221</b> ●
Homag	75	62	31.5	HSK 32	4	DP	3.0	18000	<b>198222</b> ●	<b>198223</b> ●
Homag	75	62	31.5	HSK 32	6	DP	1.0	18000	<b>198246</b> ●	<b>198247</b> ●
Homag	75	62	31.5	HSK 32	6	DP	1.5	18000	<b>198244</b> ●	<b>198245</b> ●
Homag	75	62	31.5	HSK 32	6	DP	2.0	18000	<b>198218</b> ●	<b>198219</b> ●
Homag	75	62	31.5	HSK 32	6	DP	2.5	18000	<b>198238</b> ●	<b>198239</b> ●
Homag	75	62	31.5	HSK 32	6	DP	3.0	18000	<b>198224</b> ●	<b>198225</b> ●

## 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:**

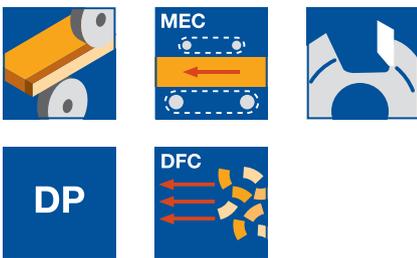
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

**Workpiece material:**

Plastic, softwood, hardwood and veneer 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.

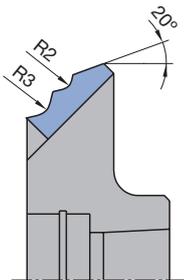


#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R

WF 501 2 DP

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID 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 ●

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



Multi-profile cutter i-System

## 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:**

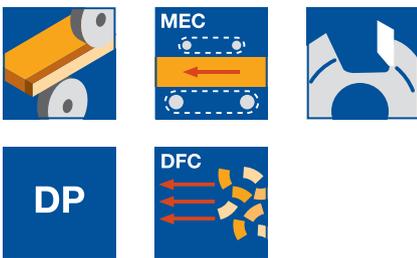
IMA edgebanding machine with KFA aggregates.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

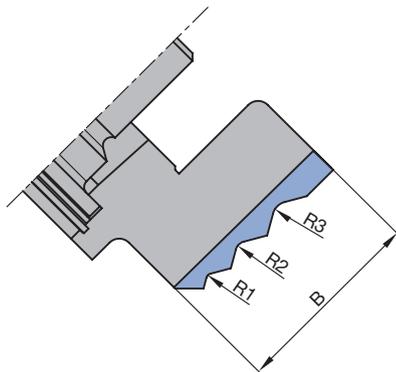
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Constant diameters. Low noise.



#### 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:**

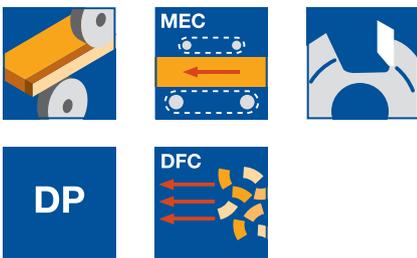
IMA edgebanding machines with MFA aggregates.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

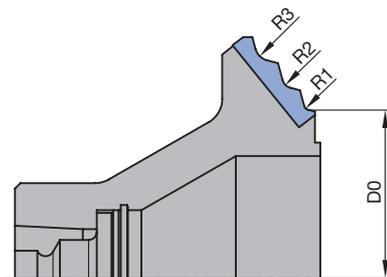
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Constant diameters. Low noise.



**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°	<b>091918 ●</b>	<b>091919 ●</b>
IMA	89	57	HSK 25 R	6	1/2/3	15°	<b>091920 ●</b>	<b>091921 ●</b>

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





### Profile cutter *IQ-system*

#### Application:

To round (profile trim) edgebandings on FK31 aggregates.

#### Machine:

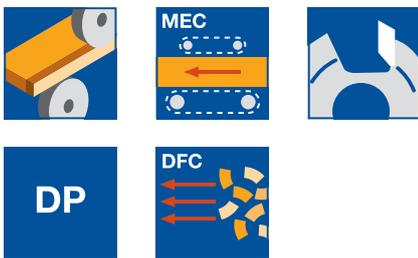
Homag edgebanding machines with profile FK31 trimming aggregate.

#### Workpiece material:

Plastic, softwood, hardwood and veneer 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. Maximum concentricity. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.



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

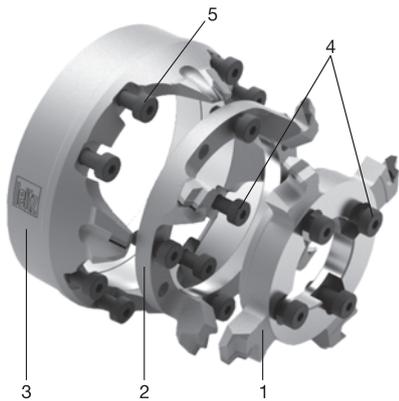
WF 501 2 DP

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		18,000	192568 ●	192569 ●
Homag	2	87	80.1	55	4	DP	1.5		18,000	192566 ●	192567 ●
Homag	2	87	80.1	55	4	DP	1.7		18,000	192582 ●	192583 ●
Homag	2	87	80.1	55	4	DP	2,0		18,000	192564 ●	192565 ●
Homag	2	87	80.1	55	4	DP	2.5		18,000	192562 ●	192563 ●
Homag	2	87	80.1	55	4	DP	3,0		18,000	192560 ●	192561 ●
Homag	2	87	80.1	55	4	DP		45°	18,000	192112 ●	192113 ●
Homag	2	87	80.1	55	4	DP		30°	18,000	192123	192124
Homag	2	87	80.1	55	4	DP		20°	18,000	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 ●
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:

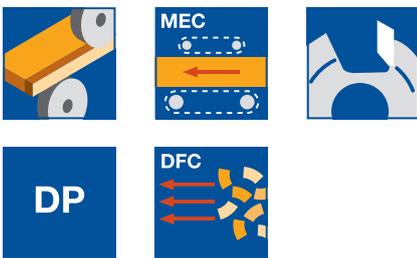
Homag edgebanding machines for cutting units types FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

2 part DP composite tool for setwise application. DFC design for efficient chip collection. MEC design for high running accuracy and smooth running.  $D_0$  = constant reference diameter, RPM  $n_{max} = 18000 \text{ min}^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service.



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

SF 542 2 15

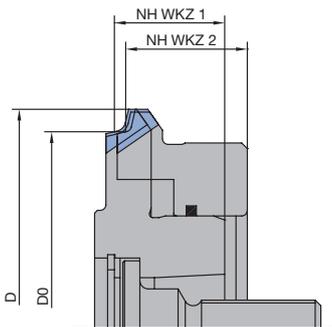
Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	19.5	HSK 25 R	4	DP	1.5/1.0		194300 ●	194301 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.0		194302 ●	194303 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.5		194304 ●	194305 ●
Homag	78	70	19.5	HSK 25 R	4	DP	3.0/2.0		194306 ●	194307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



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



### Profile cutter flexTrim3

#### Application:

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

#### Machine:

Homag edgebanding machines for cutting units type FF32 with flexTrim cutting head.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP composite tool for setwise application.

Maximum processing quality through high running accuracy and quiet running.

$D_0$  = constant reference diameter, RPM  $n_{max} = 12.000 \text{ min}^{-1}$ .

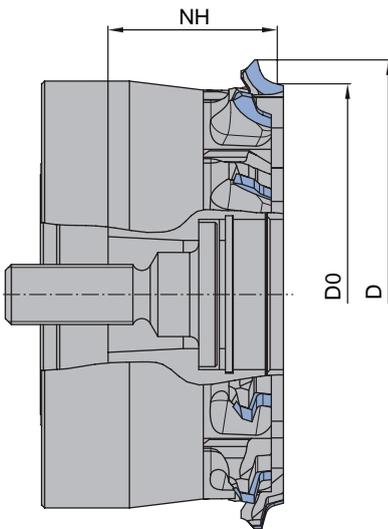
Replacement of tool components only by qualified personnel of the tool or machine manufacturer.

#### Multi-profile cutterset flexTrim3 - Diamaster PRO

SF 541 2 17

Machine	D	$D_0$	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	28	HSK 25 R	4	DP	2/1.5/1		194500 ●	194501 ●
Homag	78	70	28	HSK 25 R	4	DP	2/1.3/1		194502 ●	194503 ●
Homag	78	70	28	HSK 25 R	4	DP	2/1	45	194514 ●	194515 ●
Homag	78	70	28	HSK 25 R	4	DP	2/1.3	45	194518 ●	194519 ●

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





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

#### Application:

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

#### Machine:

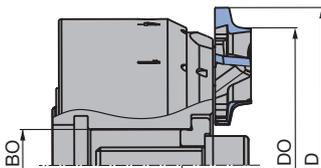
Holz-Her model Lumina and Accura 2015 and newer models. Application on revolver cutting unit Quattro Form (FF 701 Multi).

#### Workpiece material:

Plastic, softwood, hardwood and veneer 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,  $RPM\ n = 18000\ min^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service.



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

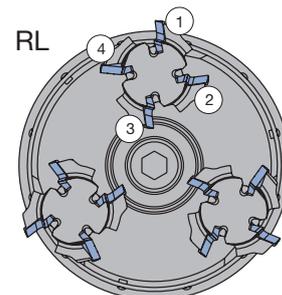
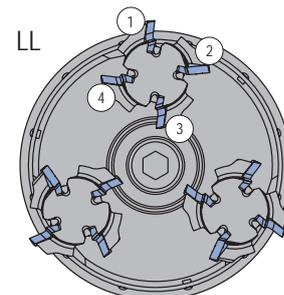
SF 540 2 10

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2	45	<b>194101 ●</b>	<b>194100 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	45	<b>194103 ●</b>	<b>194102 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	10	<b>194105 ●</b>	<b>194104 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3	45	<b>194107 ●</b>	<b>194106 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1.5/1	45	<b>194109 ●</b>	<b>194108 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	0.8/1/1.3	45	<b>194111 ●</b>	<b>194110 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	3/2/2	45	<b>194113 ●</b>	<b>194112 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1.3	45	<b>194115 ●</b>	<b>194114 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2/1.3	45	<b>194117 ●</b>	<b>194116 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1/2	45	<b>194119 ●</b>	<b>194118 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3/1.3	45	<b>194121 ●</b>	<b>194120 ●</b>
Holz-Her FF 701 Multi	70	61	16	3	2/3/2/3	45	<b>194123 ●</b>	<b>194122 ●</b>

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

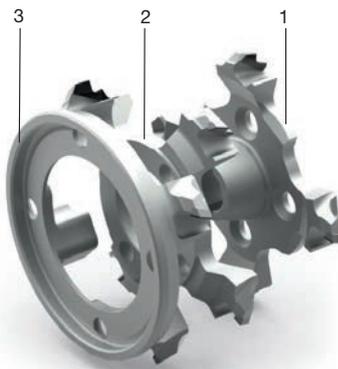
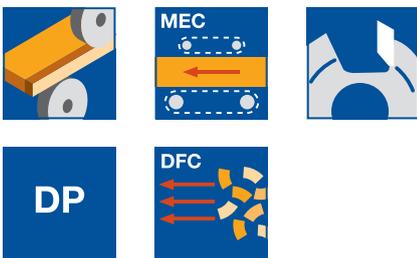
#### Spare parts:

BEZ	ID
Maintenance set Quattro Form	<b>008383 ●</b>



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194101	5059124
R3	R1.3	R2	F45°	194103	5059126
R3	R1.3	R2	F10°	194105	5059128
R2	R1.3	R1.3	F45°	194107	5059130
R2	R1.5	R1	F45°	194109	5059351
R0.8	R1	R1.3	F45°	194111	5059132
R3	R2	R2	F45°	194113	5059134
R2	R1.3	F45°	F45°	194115	5058922
R2	R1.3	R2	R1.3	194117	5061838
R2	R1	R2	F45°	194119	5062650
R2	R1.3	R1.3	R1.3	194121	
R2	R3	R2	R3	194123	5065378

①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194100	5059123
R3	R1.3	R2	F45°	194102	5059125
R3	R1.3	R2	F10°	194104	5059127
R2	R1.3	R1.3	F45°	194106	5059129
R2	R1.5	R1	F45°	194108	5059350
R0.8	R1	R1.3	F45°	194110	5059131
R3	R2	R2	F45°	194112	5059133
R2	R1.3	F45°	F45°	194114	5058919
R2	R1.3	R2	R1.3	194116	5061834
R2	R1	R2	F45°	194118	5062652
R2	R1.3	R1.3	R1.3	194120	
R2	R3	R2	R3	194122	5065379



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

### Profile cutter Multi-Edge

#### Application:

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

#### Machine:

Stefani.

#### Workpiece material:

Plastic, softwood, hardwood and veneer 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 smooth running.  $D_0$  = constant reference diameter,  $RPM \ n_{max} = 18000 \text{ min}^{-1}$ . Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.

#### 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.



### Profile cutterhead / bevel cutterhead

**Application:**

To round edgebandings.

**Machine:**

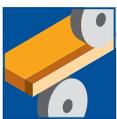
Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

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



**Various radii - Brandt**

WE 500 2

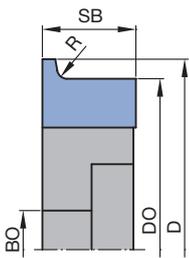
Machine	D	D <sub>0</sub>	SB	BO	Z	R	Type	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm		mm		min <sup>-1</sup>	LH	RH
Brandt	56	50	16	16 DKN	4	2	1	18000	<b>075006</b>	<b>075005</b>
Brandt	58	50	12	16 DKN	4	3	2	18000	<b>075004</b>	<b>075004</b>
Brandt	78	70	19	16 DKN	4	3	1	18000	<b>075003</b>	<b>075002</b>
Brandt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

**Spare knives:**

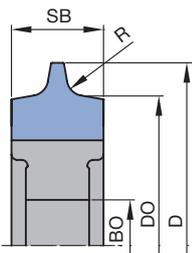
Part-no.	Type	BEZ	ABM	QAL	R	VE	ID	ID
			mm		mm	PCS	LH	RH
1	1	Exchange knife	16x13.4x2	HW	1.5	10	<b>075325</b>	<b>075324</b>
1	1	Exchange knife	16x13.4x2	HW	2.0	10	<b>075327</b>	<b>075326</b>
1	1	Exchange knife	16x13.4x2	HW	3.0	10	<b>075329</b>	<b>075328</b>
1	1	Exchange knife	19.6x15.2x2	HW	1.5	10	<b>075334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

**Spare parts:**

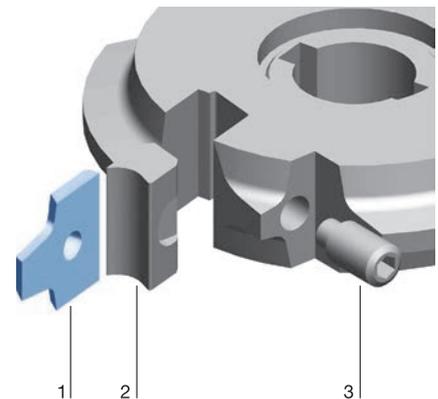
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge	10x11.5x7	<b>075400</b>
2	Clamping wedge	10x10.9x7	<b>075403</b>
2	Clamping wedge	13.5x11x7	<b>075404</b>
2	Clamping wedge	19	<b>075401</b>
2	Clamping wedge	19	<b>075402</b>
3	Allen screw	M6x12	<b>006035</b>
	Allen key	SW 3	<b>005444</b>
	Setting gauge for knives	1.0	<b>005350</b>



Type 1



Type 2





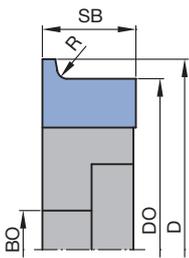
### Profile cutterhead / bevel cutterhead

**Application:**  
To round edgebandings.

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

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

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



Type 1

#### Various radii - Hebrock/EBM

WE 500 2

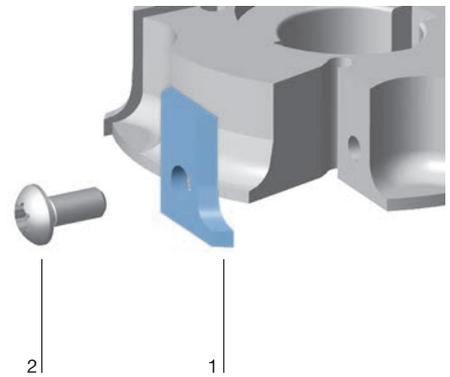
Machine	D	$D_0$	SB	BO	Z	R	Type	$n_{max}$	ID	ID
	mm	mm	mm	mm		mm		$min^{-1}$	LH	RH
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.0	1	18000	<b>074559</b>	<b>074560</b>
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.5	1	18000	<b>074557</b>	<b>074558</b>

#### 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:**

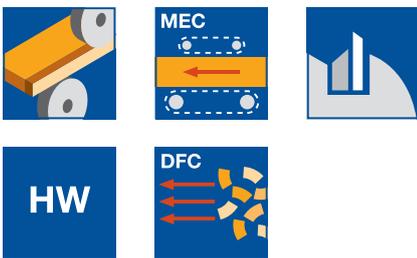
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

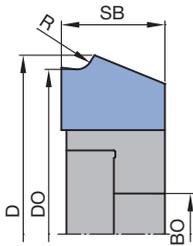
Cutterheads with HW knives and cylindrical bore with DKN.  $D_0$  = constant reference diameter. DFC design for highly efficient chip clearance of more than 97%.



**Various profiles - DFC, Brandt**

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	1.3	1	12000	075072	075073
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

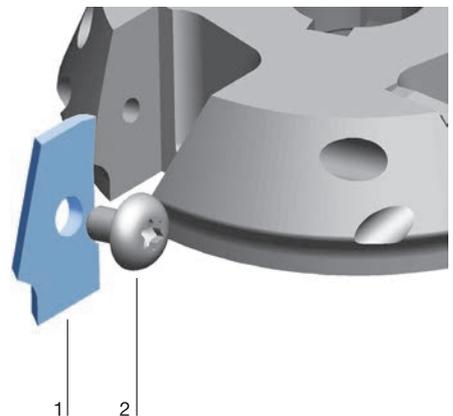


**Spare knives:**

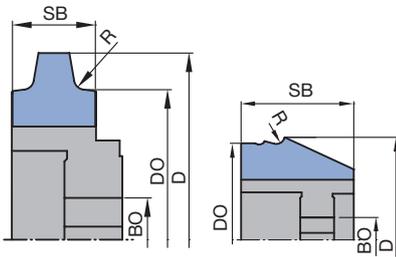
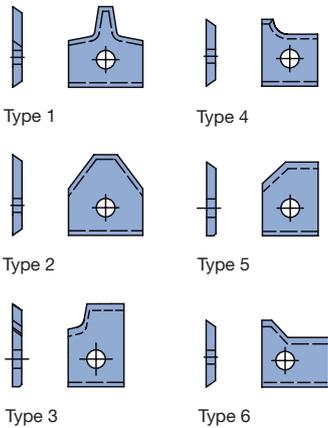
Part-no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	22.3x14x2	HW	1.0	10	10	075315	075314
1	1	Exchange knife	22.3x14x2	HW	1.2	10	10	075317	075316
1	1	Exchange knife	22.3x14x2	HW	1.3	10	10	075272	075271
1	1	Exchange knife	22.3x14x2	HW	1.5	10	10	075319	075318
1	1	Exchange knife	22.3x14x2	HW	2.0	10	10	075307	075306
1	1	Exchange knife	22.3x14x2	HW	2.5	10	10	075321	075320
1	1	Exchange knife	22.3x14x2	HW	3.0	10	10	075309	075308
1	1	Exchange knife	22.3x14x2	HW	15°	10	10	075311	075310
1	1	Exchange knife	22.3x14x2	HW	30°	10	10	075331	075332
1	1	Exchange knife	22.3x14x2	HW	45°	10	10	075313	075312

**Spare parts:**

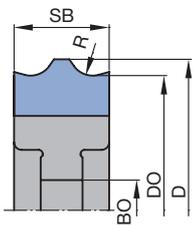
Part-no.	BEZ	ABM	ID
		mm	
2	Oval head screw Torx® 15	M4x6	006225
	Torx® key	Torx® 15	005466



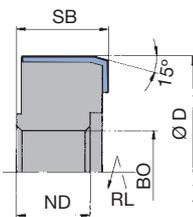
### Profile cutterhead / bevel cutterhead



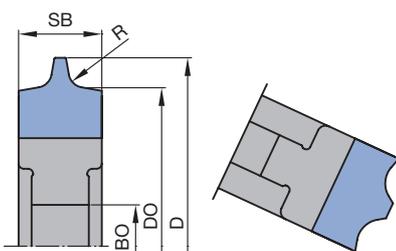
Type 1                      Type 2



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

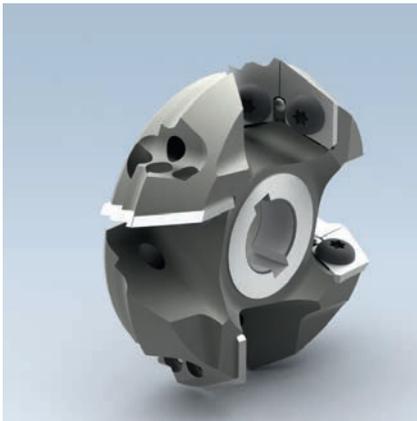
TM 435 0

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:**

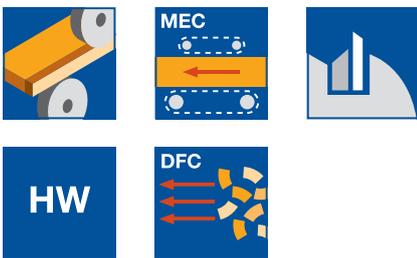
Single or double-sided edgebanding machines.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

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

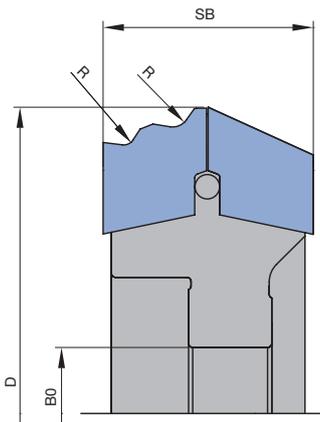


**Various profiles - DFC, Brandt**

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

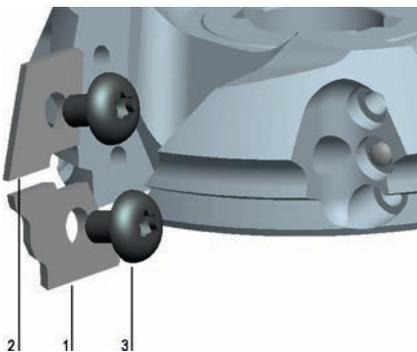
**Spare knives:**

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:**

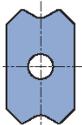
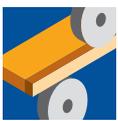
Single or double-sided edgebanding machines.

**Workpiece material:**

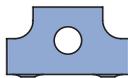
Plastic edgebandings.

**Technical information:**

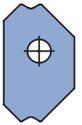
Bevel and radius scraper for scraper holder.



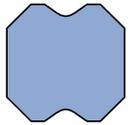
Type 1



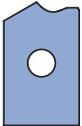
Type 6



Type 2



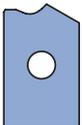
Type 7



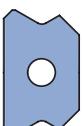
Type 3



Type 8



Type 4



Type 5

**Scrapers**

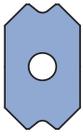
TM 435 0

Machine	R mm	FAW °	ABM mm	Type	QAL	BEM	VE PCS	ID
Biesse, Stefani		25°	12.7x12.7x3.18	7	HW		10	074552 ●
Biesse, Stefani	1.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074548 ●
Biesse, Stefani	1.5		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074549 ●
Biesse, Stefani	2.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074550 ●
Biesse, Stefani	3.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074551 ●
Fravol	1-3		12x20x2	4	HW		10	074639 ●
Fravol	1-3		12x20x2	3	HW		10	074640 ●
Holz-Her, Homag	1.0		12x20x2	1	HW	Profile relief 6°	10	074039 ●
Holz-Her, Homag	1.5		12x20x2	1	HW	Profile relief 6°	10	074074 ●
Holz-Her, Homag	2.0		12x20x2	1	HW	Profile relief 6°	10	074040 ●
Holz-Her, Homag	2.5		12x20x2	1	HW	Profile relief 6°	10	074075 ●
Holz-Her, Homag	3.0		12x20x2	1	HW	Profile relief 6°	10	074041 ●
Holz-Her, Homag	45°		12x20x2	1	HW		10	074037 ●
Homag, IMA	45°		12x20x2	2	HW	Profile relief 15°	10	073724 ●
Homag	1.0		12x20x2	2	HW	Profile relief 15°	10	073725 ●
Homag	1.5		12x20x2	2	HW	Profile relief 15°	10	073726 ●
Homag	2.0		12x20x2	2	HW	Profile relief 15°	10	073727 ●
Homag	2.5		12x20x2	2	HW	Profile relief 15°	10	073728 ●
Homag	3.0		12x20x2	2	HW	Profile relief 15°	10	073729 ●
Homag	3°		20x11.5x2	6	HW		10	073717 ●
Homag - BAZ								
Homag,	1.0		20x11.5x2	6	HW	Profile relief 6°	10	073713 ●
Homag - BAZ								
Homag,	1.5		20x11.5x2	6	HW	Profile relief 6°	10	073714 ●
Homag - BAZ								
Homag,	2.0		20x11.5x2	6	HW	Profile relief 6°	10	073715 ●
Homag - BAZ								
Homag,	3.0		20x11.5x2	6	HW	Profile relief 6°	10	073716 ●
Homag - BAZ								
IMA	1.0		12x20x2	5	HW	Profile relief 15°	10	074044 ●
IMA	1.5		12x20x2	5	HW	Profile relief 15°	10	074076 ●
IMA	2.0		12x20x2	5	HW	Profile relief 15°	10	074021 ●
IMA	2.5		12x20x2	5	HW	Profile relief 15°	10	074077 ●
IMA	3.0		12x20x2	5	HW	Profile relief 15°	10	074022 ●
Ott	1.0		12.29x13.49x3.3	8	HW		10	074643 ●
Ott	2.0		12.29x13.49x3.3	8	HW		10	074644 ●

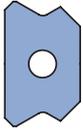
Additional scrapers available on request at short notice.

## 2. Panel processing

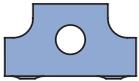
### 2.1 Edge processing 2.1.7 Edge finishing tools



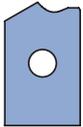
Type 1



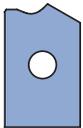
Type 2



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.

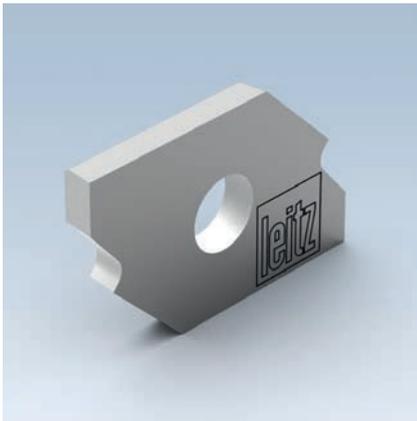
#### Radii scrapers with anti-stress-whitening bevel

TM 435 0

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

#### Spare parts:

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



### 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.

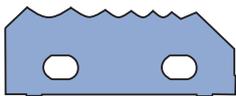
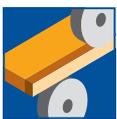
**Multi-profile scrapers**

TM 135 0

Machine	BEM	QAL	ID	
			LH	RH
Homag	R 1/1,5/2/3/5/grain 20°	HW	074049 ●	074050 ●
IMA	R 1,5/2/3	HW	074106 ●	074106 ●
IMA	R 1/2/3	HW	074107 ●	074107 ●
Stefani	R 1/2/3/Bevel	HW	074081 ●	074080 ●
Biesse	R 1/2/3/Bevel	HW	074082 ●	074082 ●

**Spare parts:**

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



Multi-profile scraper

**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 ●



### Profile scrapers

**Application:**

For scraping edgebandings with radii or bevels.

**Machine:**

Single or double-sided edgebanding machines.

**Workpiece material:**

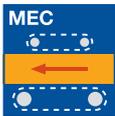
Plastic edgebandings.

**Technical information:**

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

**Multi-profile scraper - Brandt**

TM 135 0

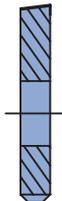
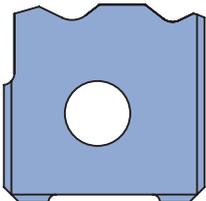


Machine	ABM mm	QAL	R mm	FAW °	VE PCS	ID	
						bottom	top
Brandt	13.5x13.38x2	HW	1/1.5		2	<b>075375 ●</b>	<b>075376 ●</b>
Brandt	13.5x13.38x2	HW	1/2		2	<b>075357 ●</b>	<b>075358 ●</b>
Brandt	13.5x13.38x2	HW	1/3		2	<b>075361 ●</b>	<b>075362 ●</b>
Brandt	13.5x13.38x2	HW	1.3/2		2	<b>075359 ●</b>	<b>075360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

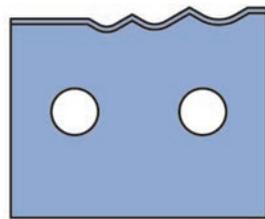
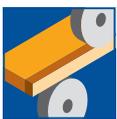
Further radii combinations and anti-stress-whitening knives available at short notice.

**Spare parts:**

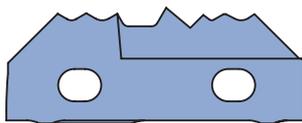
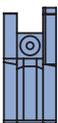
BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 ●</b>
Oval head screw Torx® 15	M4x6	<b>006225 ●</b>



Multi-profile scraper



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.

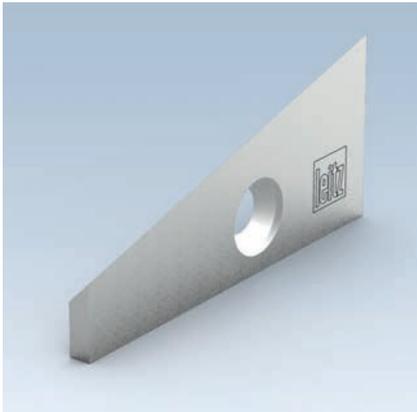
**Attention:** Only applicable on standard scraper aggregates with special profile scraper holders.

#### 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.

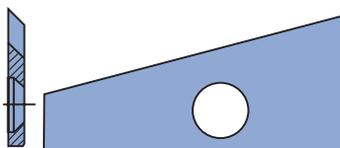
**Technical information:**

Different profile flat scrapers.

**Flat scraper knives**

TC 105 0, TM 135 0, TM 440 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, Homag, 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>
Holz-Her	HW:14x14x2	HW			<b>009546</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> ●



Flat scraper



### Profile cutterhead / bevel cutterhead for stationary machines

**Application:**

To round/bevel edgebandings.

**Machine:**

Homag BAZ.

**Workpiece material:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

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



**Various radii / bevels - Homag**

WE 500 2

D	D <sub>0</sub>	BO	NLA	Z	QAL	R	FAW	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
59	50	15	3/4.2/25	3	HW	1.0	°	1	18000	073001	073000
59	50	15	3/4.2/25	3	HW	1.5	°	1	18000	073003	073002
59	50	15	3/4.2/25	3	HW	2.0	°	1	18000	073005	073004
59	50	15	3/4.2/25	3	HW	3.0	°	1	18000	073009	073008
60	50	15	3/4.2/25	3	HW		15°	2	18000	073037	073036
60	50	15	3/4.2/25	3	HW		30°	2	18000	073039	073038
60	50	15	3/4.2/25	3	HW		45°	2	18000	073041	073040
62	50	15	3/4.2/25	3	HW		15°	3	18000	073101	073100

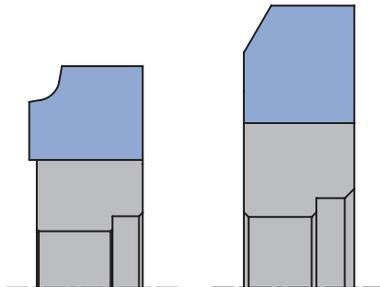
Type 3 for special thin edgebandings.

**Spare knives:**

Part-no.	SB	H	DIK	QAL	R	FAW	Type	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

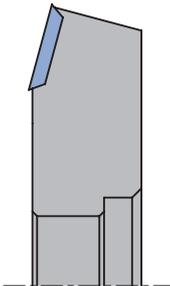
**Spare parts:**

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	005350

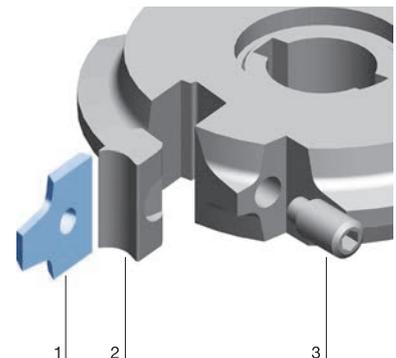


Type 1

Type 2



Type 3





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

**Application:**

To round/bevel edgebandings.

**Machine:**

Homag BAZ.

**Workpiece material:**

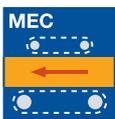
Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

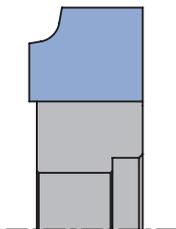
DP tipped tool with cylindrical bore.  $D_0$  = constant reference diameter.

**Radii cutter DP - Homag**

WF 501 2 DP



D	D <sub>0</sub>	BO	NLA	Z	QAL	R	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
57	50	15	3/4.2/25	3	DP	2.0	1	18000	073103 ●	073102 ●
57	50	15	3/4.2/25	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:**

Plastic, softwood, hardwood and veneer edgebander.

**Technical information:**

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

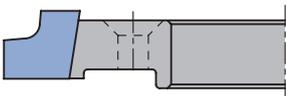
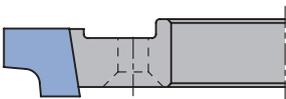
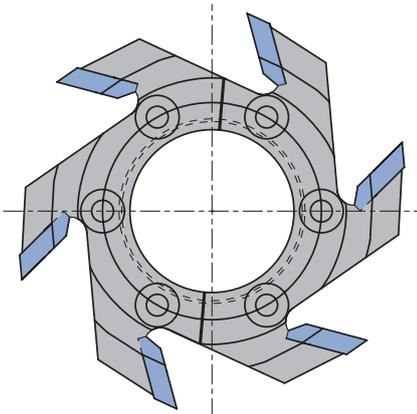


**Various radii / bevels - IMA**

WF 501 2

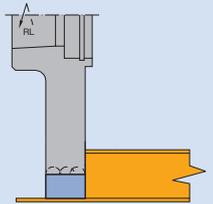
D	D <sub>0</sub>	SB	BO	NLA	Z	QAL	R	FAW	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
64.4	55	10.2	30	6/5/40	6	HW	1.5		1	18000	074062	074063
64.4	55	10.2	30	6/5/40	6	HW	2.0		1	18000	074064	074065
64.4	55	10.2	30	6/5/40	6	HW	3.0		1	18000	074066	074067
70	60	9	30	6/5/40	6	HW	1.5		1	18000	074056	074057
70	60	9	30	6/5/40	6	HW	2.0		1	18000	074058	074059
70	60	9	30	6/5/40	6	HW	3.0		1	18000	074060	074061
70	60	9	30	6/5/40	6	HW		15°	1	18000	074068	074069
70	60	9	30	6/5/40	6	HW		30°	1	18000	074070	074071
70	60	9	30	6/5/40	6	HW		45°	1	18000	074072	074073

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



**Rebating**  
Rebating cutter, page 67

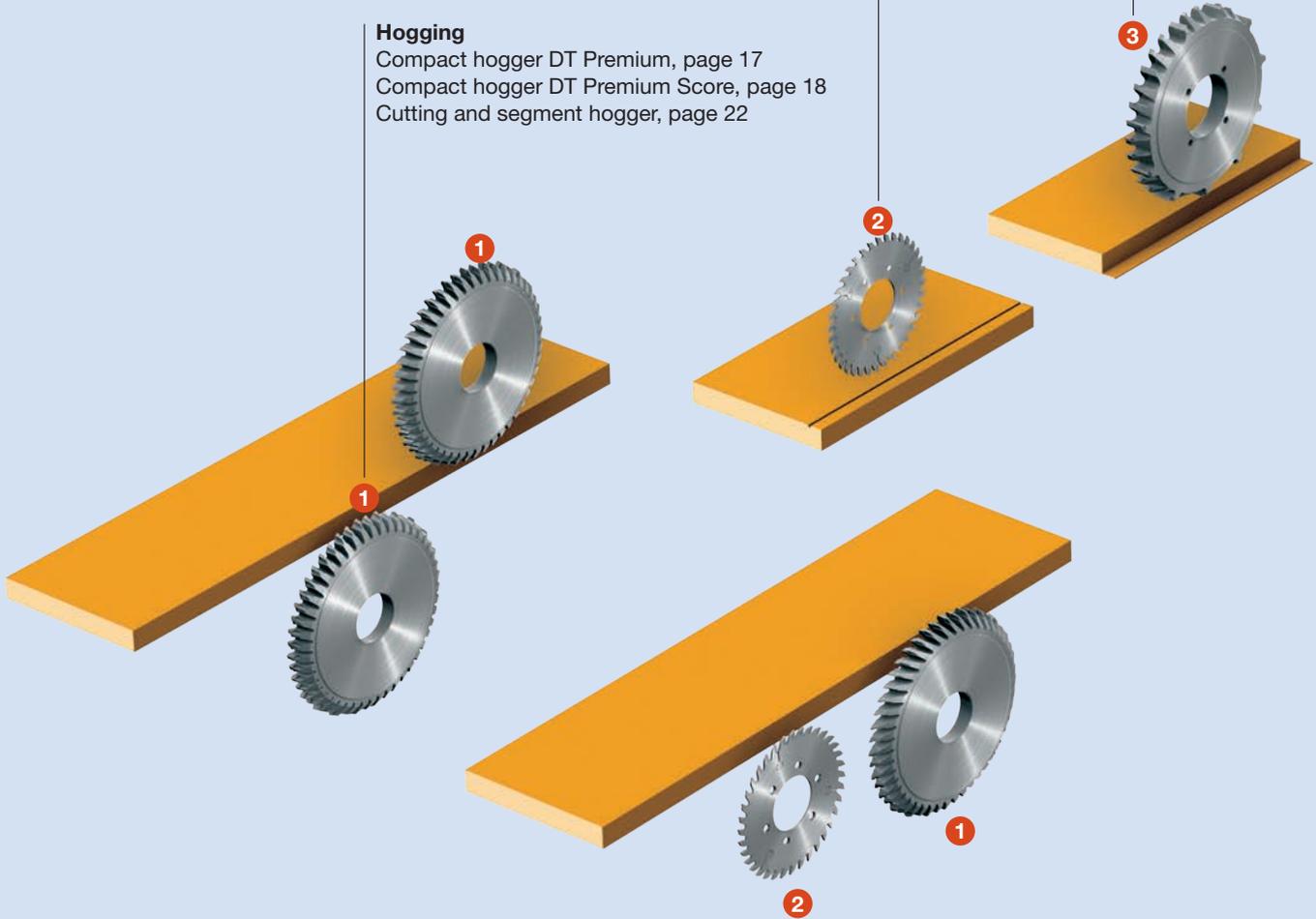
Milling off the wooden composite board to uncover the cover layer, application mostly with feed.

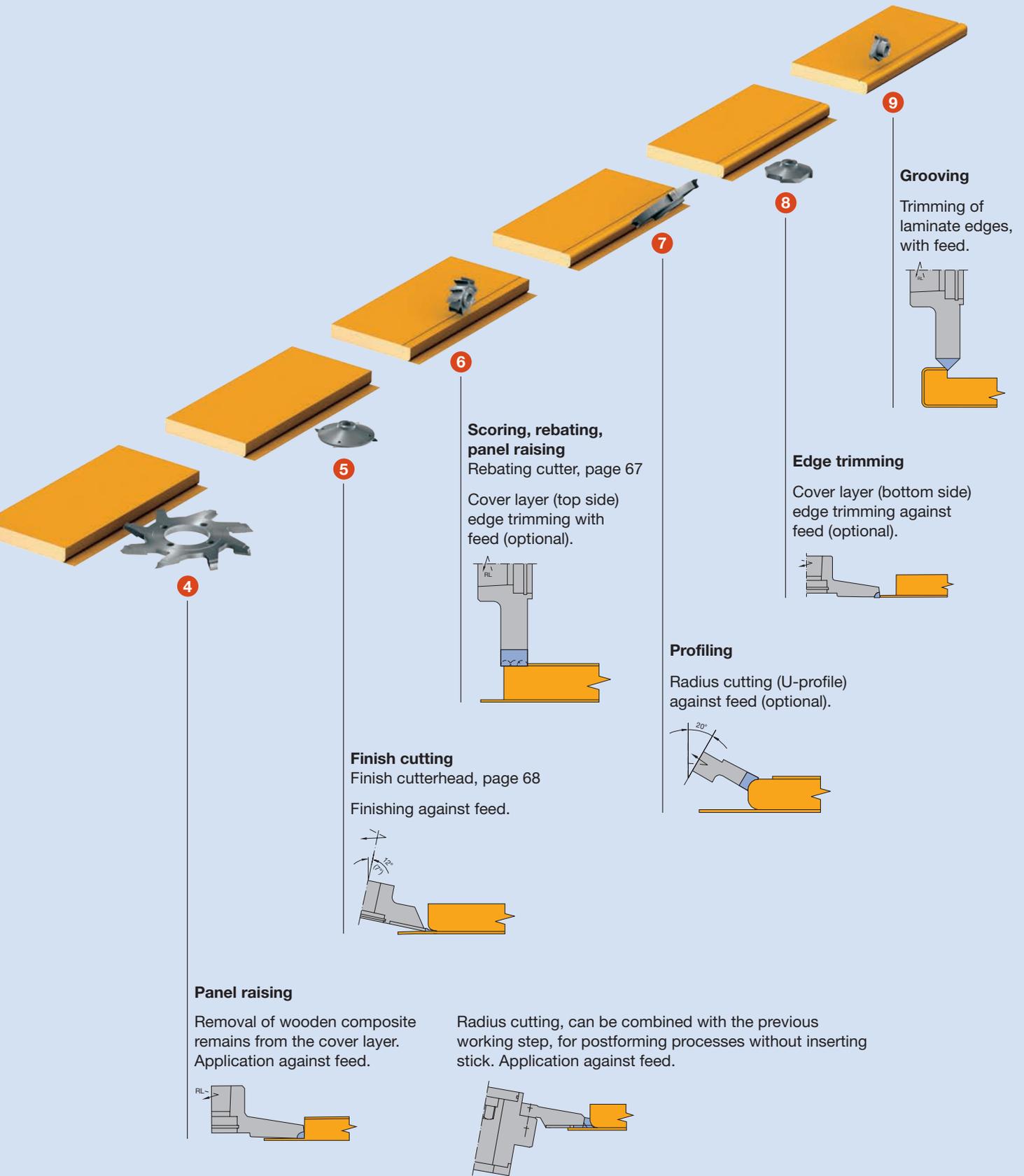


**Scoring**

**Hogging**

Compact hogger DT Premium, page 17  
Compact hogger DT Premium Score, page 18  
Cutting and segment hogger, page 22





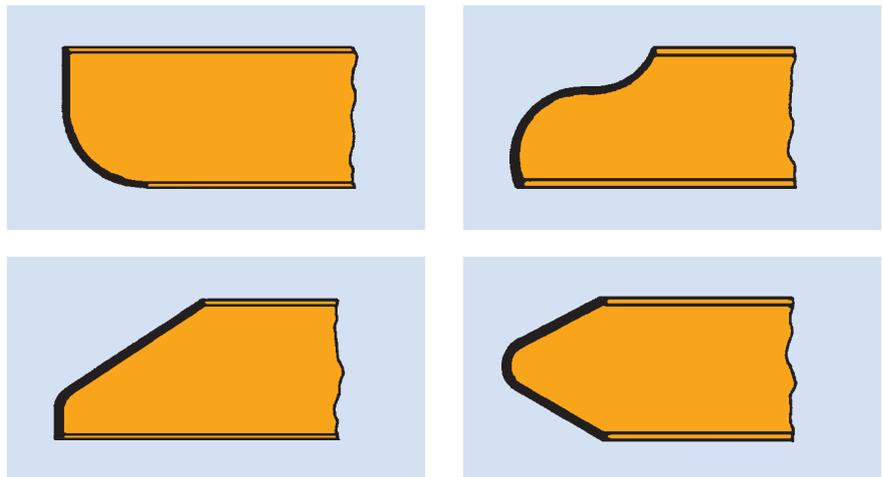
## 2. Panel processing

### 2.2 Postforming processing

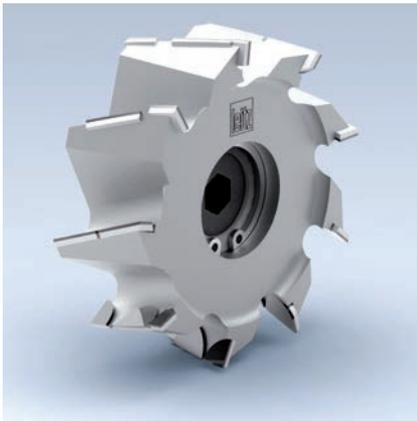
#### 2.2.2 Postforming tools

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

#### Profile examples



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



### 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.

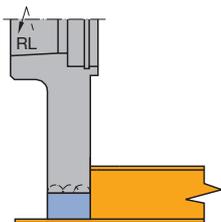
DP tools - 2.0 mm resharpening area.



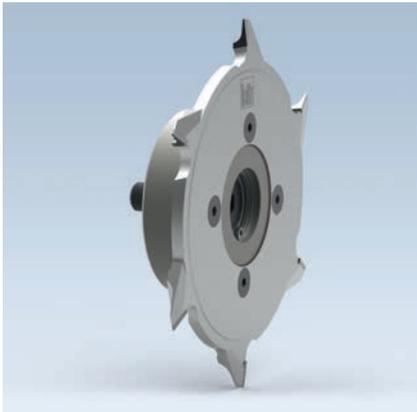
**Diamaster PRO**

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:**

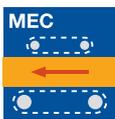
Postforming units.

**Workpiece material:**

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

**Technical information:**

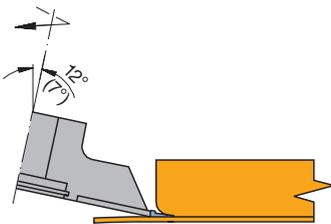
Cutterhead with DP tipped profile knives and HSK 25 R adaptor. Suitable for finish cutting of all radii up to R 14 mm.



**7° inclined spindle**

WF 556 2

Machine	D	SB	BO	Z	QAL	n <sub>max</sub>	Spindle angle	ID	ID
	mm	mm	mm			min <sup>-1</sup>	°	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:**

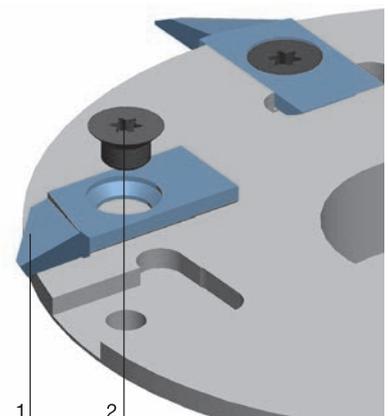
Spare knives for cutterhead with DP profile knives and cylindrical bore or HSK 25 R adaptor. Suitable for finish cutting radii up to R 14. Non-resharpenable knives 0.5 mm optimised for sensitive coatings, veneer postforming and maximum contour accuracy.

**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.



## 2. Panel processing

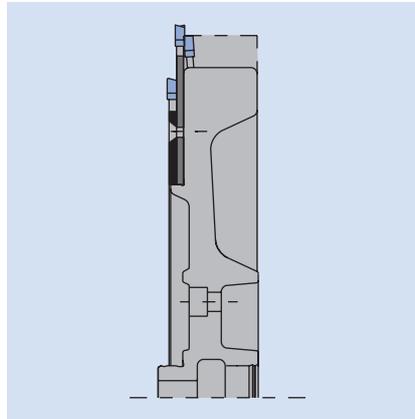
### 2.3 Panel processing

#### 2.3.1 Segment hoggers for sizing

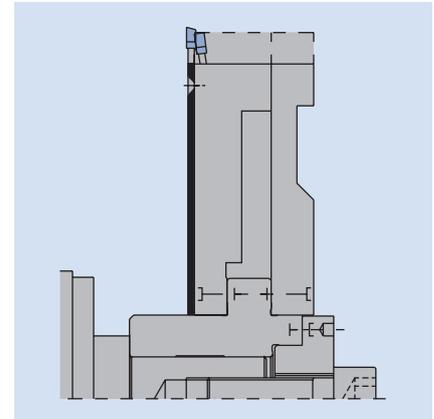
##### Segment hogger

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

##### Designs



Toolset for finish-production unit with sizing and finish cut



Toolset for sizing unit mounted on flanged sleeve



### Segment hogger for sizing unit

**Application:**

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

**Machine:**

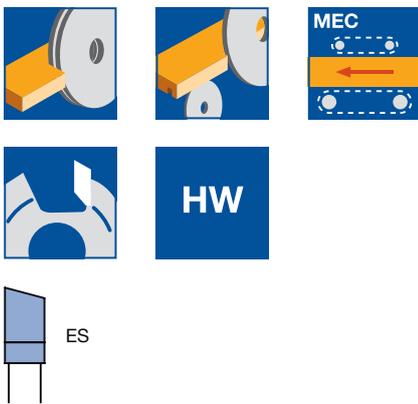
Sizing station in production lines.

**Workpiece material:**

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

**Technical information:**

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



**Hogger for sizing unit**

SZ 300 2, SZ 301 2

Machine	D	SB	BO	Z/ZF <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**

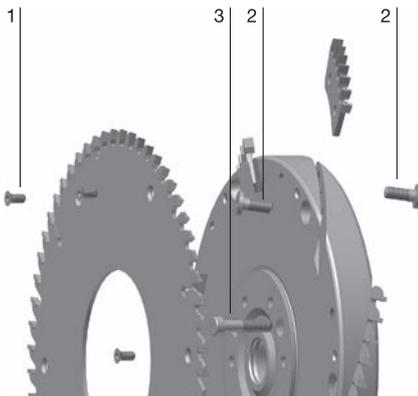
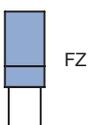
WZ 300 2

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:**

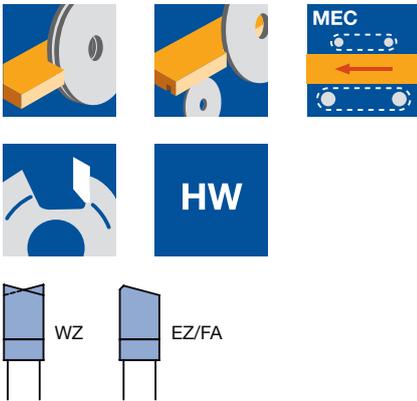
Sizing station in production lines.

**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> ●

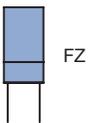
**Technical information:**

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**

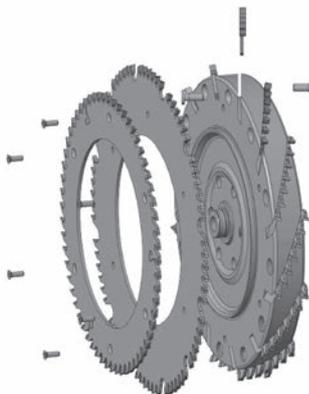
WZ 300 2

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> ●

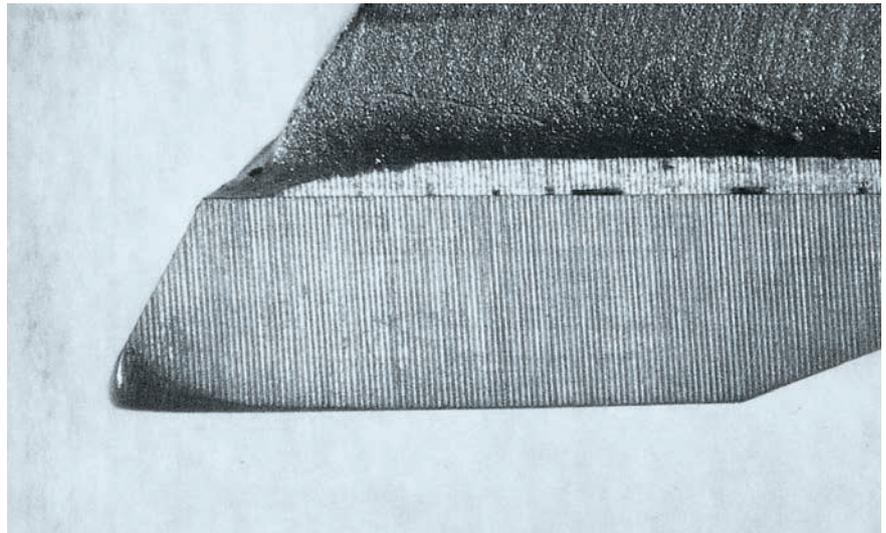


Problem	Possible cause	Action
<b>Break outs at the edge of the workpiece top edge</b>	- Incorrect height adjustment of hogging motor and tilt in feed direction	Correct setting Check position of tools in feed direction, adjust standard value of 0.1 mm to the panel edge
	- Too much axial play in spindle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

### Rounding of the cutting edge

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

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



Typical cutting edge wear when machining solid wood.

### Cutting edge destruction through improper use

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

#### Action:

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



Cutting edge destruction through improper use.

### Cutting edge destruction through overstress

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

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



Destruction of saw tooth through overstress.

## 2. Panel processing

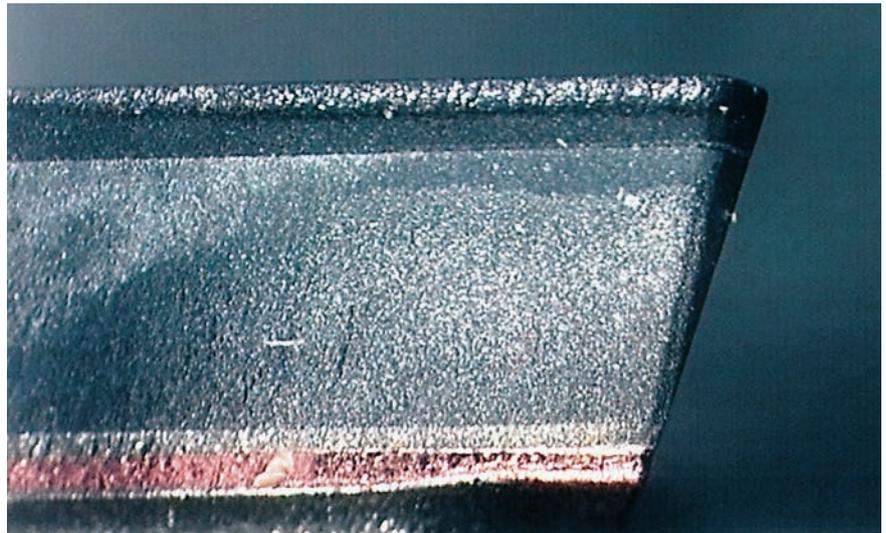
### Signs of wear on the DP cutting edges

#### Rounding of cutting edges

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

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

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

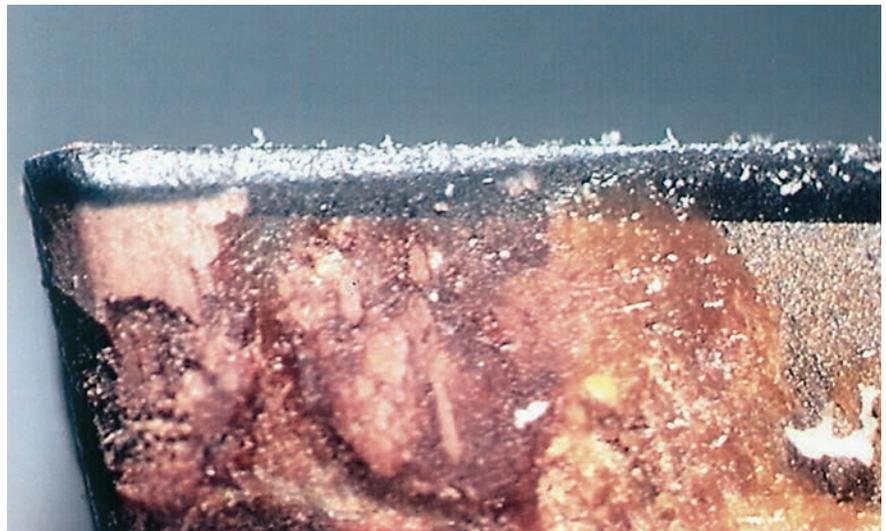


Wear to cutting edges after machining MDF.

#### Cutting edge rounding and resin build up

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

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

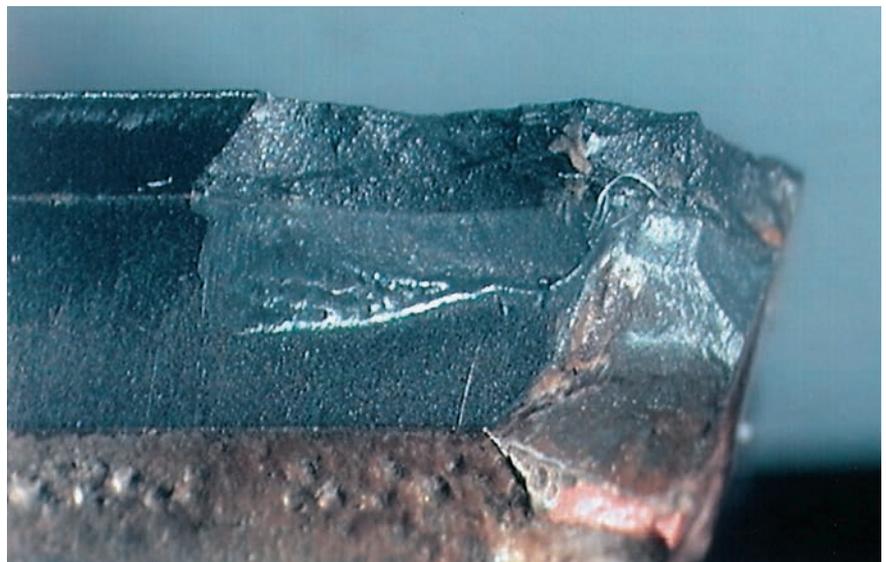


Wear to cutting edges and resin build-up after machining chipboard.

#### Cutting edge destruction

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

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



Cutting edge destruction from metallic particles.



# 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		

