Panel processing

Leitz Lexicon Edition 7 | Version 3 | 06/2023

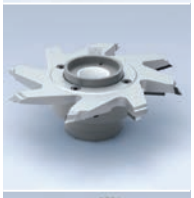
Explanation of abbreviations

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

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



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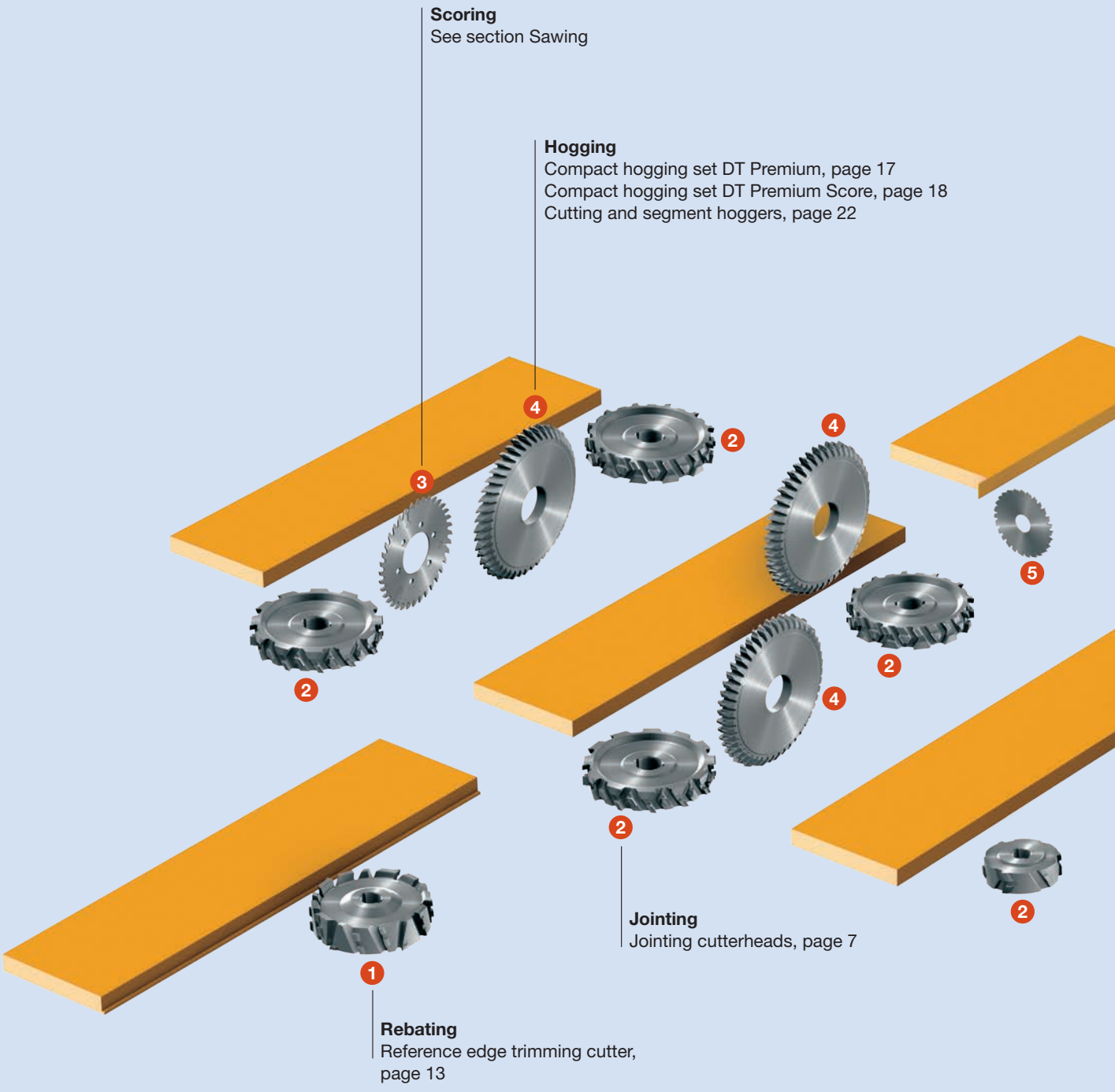
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Hogging
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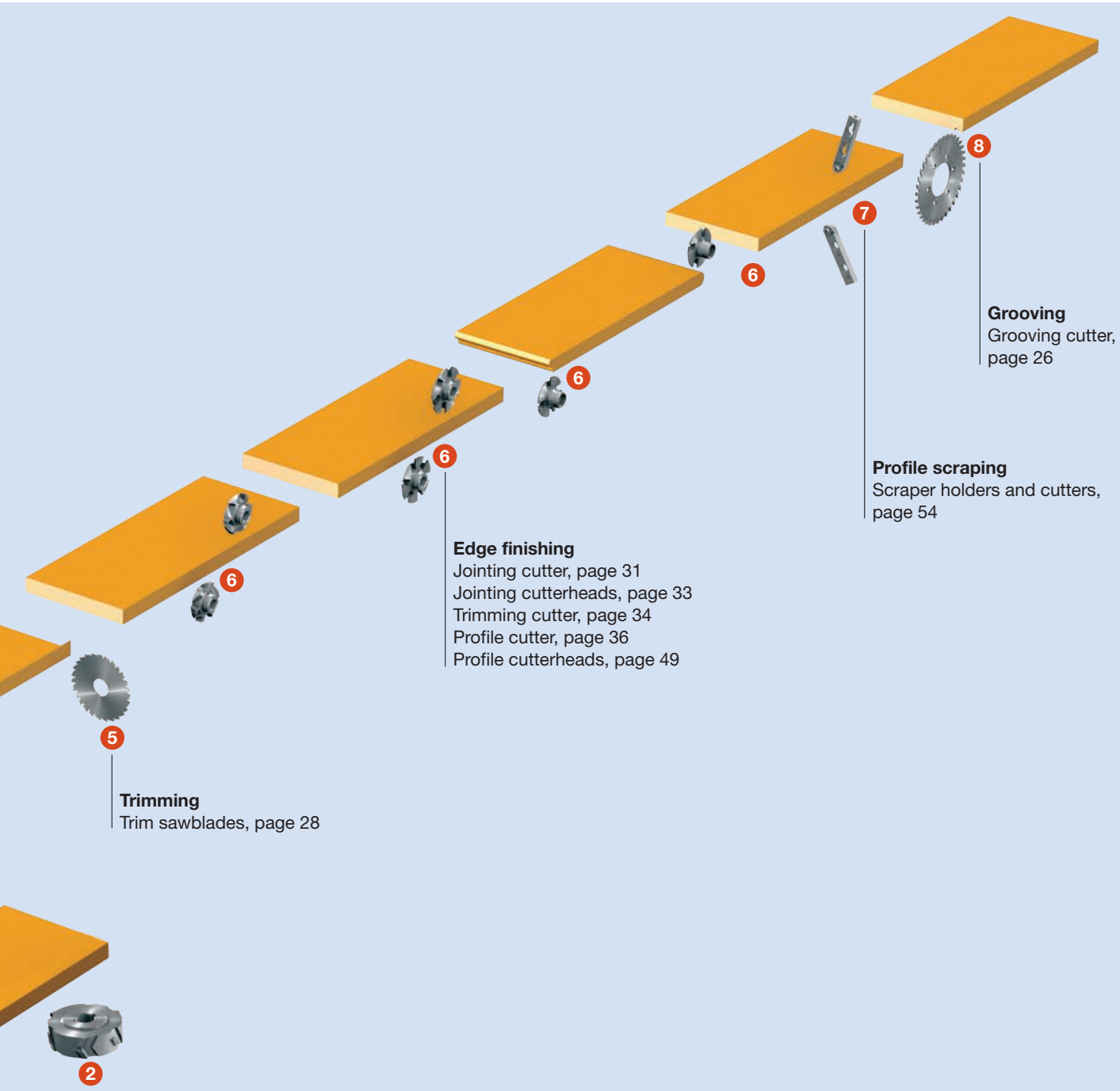

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Grooving
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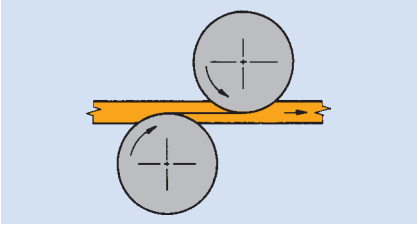
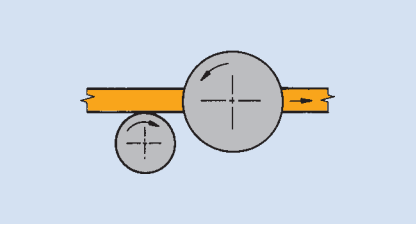
2.1 Edge processing
2.1.3 Compact hoggers - DP

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

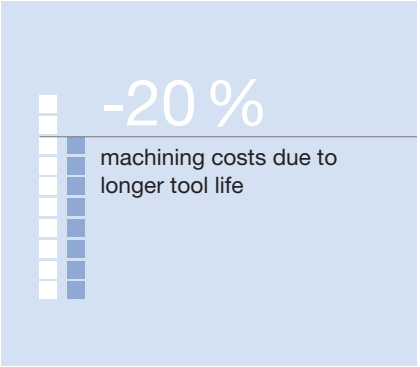


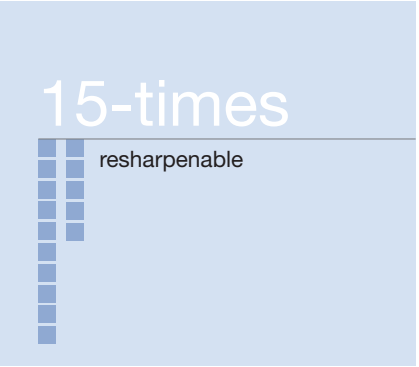
Double hogging: Both hoggers cut with feed.



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

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

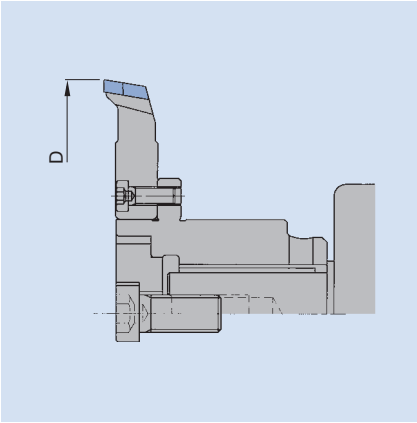




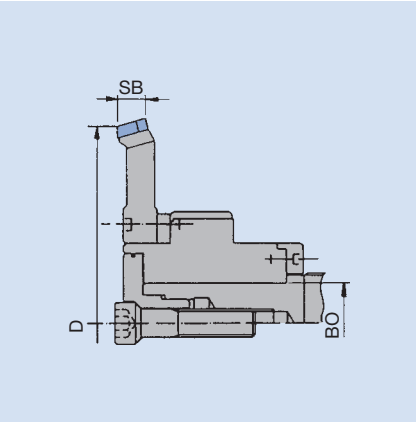
Productivity & efficiency	Maximum economic efficiency through long tool life – Long tool life even under difficult operating conditions thanks to new tooth shape – Reduction of set-up costs due to long tool life – Efficient chip removal due to innovative gullet geometry and integrated chipbreaker – Cost efficient processing of various materials – Ideal also for batch size 1 due to adapted cutting geometries – Resharpenable up to 15 times through larger resharpening area
Quality	Perfect edges and cutting surfaces – Excellent edge quality and smooth cutting surfaces through adapted cutting geometries – Clean workpiece finishes due to efficient chip removal with DFC®-Technology – Constant cutting width over the entire life cycle
Sustainability	Longer tool life time, less dust and noise – Reduced noise due to special tool design – Reduction of noise and vibration through damping elements – Longer tool life time through larger resharpening area

2.1 Edge processing
2.1.3 Compact hoggers - DP

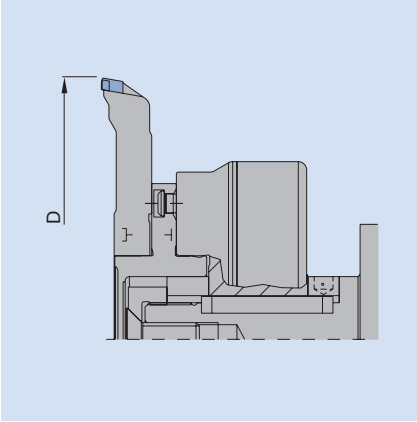
Designs



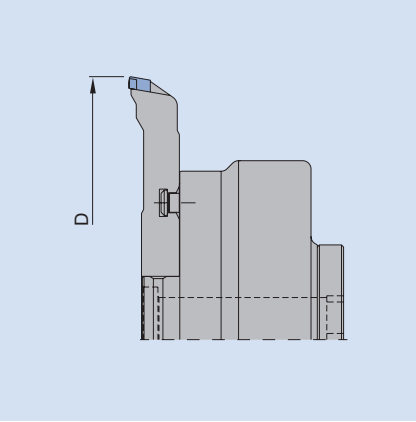
Tooth shape: top bevel decreasing.
Hogger on standard flange.



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.

Type of operation

Cutting of the finished size with pre-sized, panel shaped working pieces. Therefore the jointing tools only are peripheral cutting and not with side relief!

Workpiece material

Softwood and hardwood, glulam, chipboard and fibre material, uncoated and veneered, plastic and paper coated.

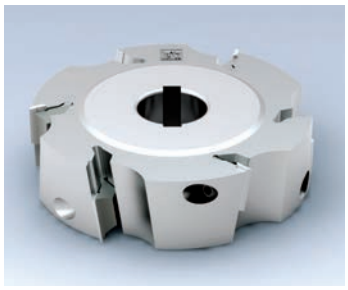
Machines

Spindle moulders, edgebanding machines with sizing part, double end tenoners. Counter milling or jump cutting: Depending on the processing quantity and material, diamond tools or cutterheads with tungsten carbide turnblades are used.

Application

Jointing against feed: For all panel working materials with or without coating.
Jointing with feed: For machining solid wood with heavily irregular course of fibres and risk of tear outs. Only allowed for machines with mechanical feed. Note: Chips are very difficult to remove.
Jump cutting: Jointing with and against feed when cutting across, to prevent tear outs on the front and backside of the workpiece when these are already glued.

Tool Designs



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

Diamond jointing cutter with alternate shear angle:
S = with symmetrical edge arrangement: Produce a slight hollow section on the milled jointing edge. This has the advantage that the edgebanding on the outside edge close tightly. The tool always must be adjusted symmetrically to the workpiece thickness. The tool can be used in RH and LH rotation.
AS = Asymmetrical edge arrangement: One cutting edge cuts from bottom to top, the top cutting edges all are directed downward which is advantageous for frequently changing material thicknesses.

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

Diamaster WhisperCut

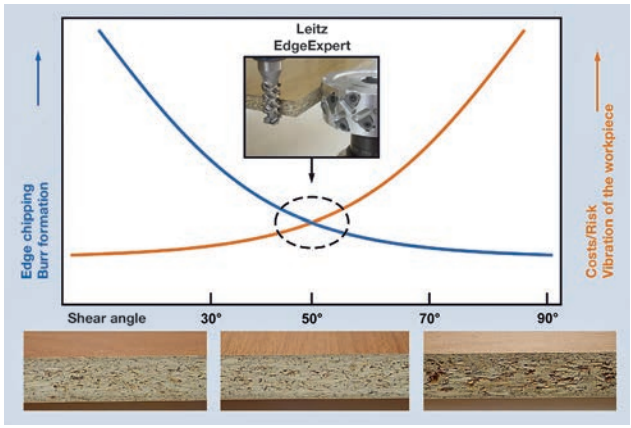
Diamaster WhisperCut – The lightweight and efficient jointing cutterhead for low noise sizing of panel material.

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

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.

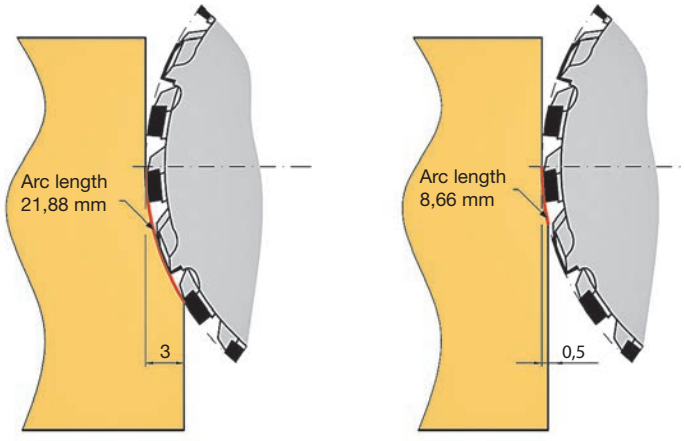


Dust collection

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.



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.

Resharpening Diamaster WhisperCut

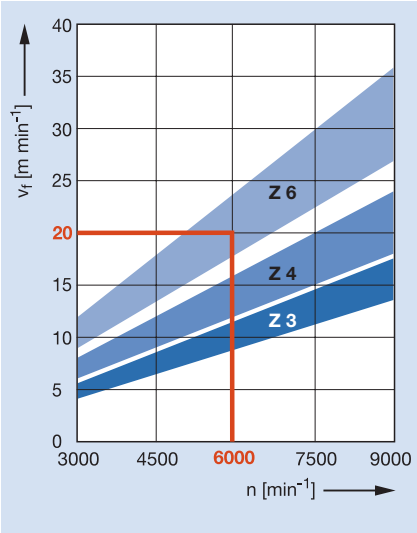
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

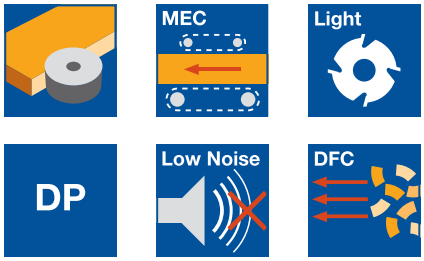
Diamaster WhisperCut – The jointing cutterhead with exchangeable knives

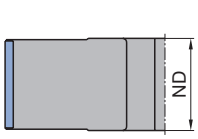
- constant diameter
- quick and easy knife change by the user on site
- no costly adjustment at the machine
- no interchangeable tool required
- optimal knife utilization with small material thicknesses

Feed speed related to RPM and number of teeth Z

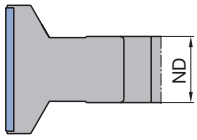
Material: Chipboard with melamine resin coating



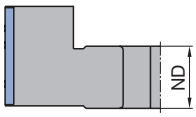




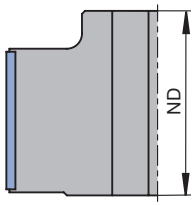
Position of boss (NAL) 1



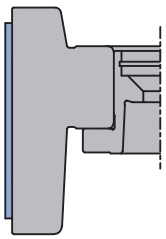
Position of boss (NAL) 2



Position of boss (NAL) 3



Position of boss (NAL) 4



Position of boss (NAL) 5

WhisperCut jointing / milling cutter - cutterhead design

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

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

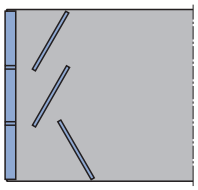
Workpiece material:
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

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

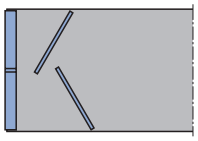
Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body
WF 230 2 DP, WM 230 2 01

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Ayza Mizrak	70	54	30	20 DKN	2	2x5	10xD	AS	**192320** ●	**192321** ●
Ayza Mizrak	125	54	40	30 DKN	3	3x5	15xE	AS	**192326**	**192327**
Biesse	80	45	53	30 DKN	1	2x4	8xB	S	**192127** ●	**192127** ●
Biesse	80	65	53	30 DKN	2	2x6	12xB	S	**192128** ●	**192128** ●
Biesse	100	43	75	30 DKN	1	3x4	12xA	S	**192088** ●	**192088** ●
Biesse	100	65	75	30 DKN	1	3x6	18xA	S	**192089** ●	**192089** ●
Biesse	125	43	40	30 DKN	2	3x4	12xE	S	**075627** ●	**075627** ●
Biesse	125	63	40	30 DKN	2	3x6	18xE	S	**075626** ●	**075626** ●
Brandt	100	43.6	40.6	25 DKN	3	2x4	8xA	AS	**192211** ●	**192212** ●
Brandt	100	62.5	40.6	25 DKN	3	2x6	12xA	AS	**192345**	**192346**
Brandt	100	43.6	40.6	30 DKN	3	3x4	12xA	AS	**090885** ●	**090886** ●
Brandt	100	65.2	40.6	30 DKN	3	3x6	18xA	AS	**090887** ●	**090888** ●
Brandt	100	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 2xC2	AS°		**192278** ●
Felder	60	63	63.5	25 DKN	3	2x7	12xC 2xC1	AS°	**192277** ●	
Felder	80	48.5	64	25 DKN	4	3x6	12xF 3xB1 3xB2	AS°	**192281** ●	**192282** ●
Felder	80	64	64	25 DKN	3	2x7	12xF 2xB2	AS°		**192300** ●
Felder	80	64	64	25 DKN	3	2x7	12xF 2xB1	AS°	**192299** ●	
Felder	80	64	64	25 DKN	3	3x7	18xF 3xB1	AS°	**192279** ●	
Felder	80	64	64	25 DKN	3	3x7	18xF 3xB2	AS°		**192280** ●
Fravol	60	63	63.5	25 DKN	3	2x7	12xC 2xC1	AS°	**192247** ●	
Fravol	60	63	63.5	25 DKN	3	2x7	12xC 2xC2	AS°		**192248** ●
Fravol	60	84	61	25 DKN	3	2x8	14xC 2xC1	AS°	**192241** ●	
Fravol	60	84	61	25 DKN	3	2x8	14xC 2xC2	AS°		**192242** ●

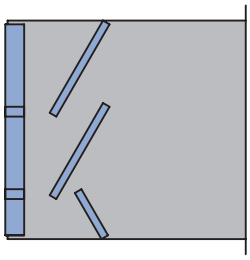
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



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

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Fravol	100	65	56.5	30 DKN	3	2x6	12xA	AS	**192243** ●	**192244** ●
Fravol	100	84	56.5	30 DKN	3	2x8	14xA 14xA1	AS°	**192285** ●	
Fravol	100	84	56.5	30 DKN	3	2x8	14xA 14xA2	AS°		**192286** ●
Fravol	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 1801/1802	70	48	41	30 DKN	2	2x5	8xD 2xD2	AS°		**192221** ●
Holz-Her 1801/1802	70	48	41	30 DKN	2	2x5	8xD 2xD1	AS°	**192222** ●	
Holz-Her 1801/1802	70	64	41	30 DKN	2	2x7	12xD 2xD2	AS°		**192223** ●
Holz-Her 1801/1802	70	64	41	30 DKN	2	2x7	12xD 2xD1	AS°	**192224** ●	
Holz-Her 1804	100	63	39.5	30 DKN	2	3x6	18xB	S	**192147** ●	**192148** ●
Holz-Her 1891	100	43	25	30 DKN	2	2x4	8xA	AS	**192082** ●	**192083** ●
Holz-Her 1891	100	65	25	30 DKN	2	2x6	12xA	AS	**192084** ●	**192085** ●
Holz-Her FG701	100	63	39.5	HSK 32 R	5	3x6	18xB	S	**192307** ●	**192308** ●
Homag	100	43.6	40.6	25 DKN	3	2x4	8xA	AS	**192211** ●	**192212** ●
Homag	100	62.5	40.6	25 DKN	3	2x6	12xA	AS	**192345**	**192346**
Homag	100	43.6	40.6	30 DKN	3	3x4	12xA	AS	**090885** ●	**090886** ●
Homag	100	65.2	40.6	30 DKN	3	3x6	18xA	AS	**090887** ●	**090888** ●
Homag	100	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 Advantage	125	43	57	30 DKN	4	3x5	15xD	AS	**192098** ●	**192099** ●
IMA Advantage	125	65	57	30 DKN	4	3x7	21xD	AS	**192100** ●	**192101** ●
Mizrak Makine	70	54	30	20 DKN	2	2x5	10xD	AS	**192320** ●	**192321** ●
Ott	85	48	50	30 DKN	3	3x5	12xB 3xB1	AS°	**192209** ●	
Ott	85	48	50	30 DKN	3	3x5	12xB 3xB2	AS°		**192210** ●
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 2xB1 2xB2	AS°	**192215** ●	**192216** ●
SCM	100	51	60	30 DKN	3	3x6	12xB 3xB1 3xB2	AS°	**192217** ●	**192218** ●
SCM	100	66	60	30 DKN	3	2x7	12xB 2xB1	AS°	**192213** ●	
SCM	100	66	60	30 DKN	3	2x7	12xB 2xB2	AS°		**192214** ●
SCM	100	66	60	30 DKN	3	3x7	18xB 3xB1	AS°	**192219** ●	
SCM	100	66	60	30 DKN	3	3x7	18xB 3xB2	AS°		**192220** ●

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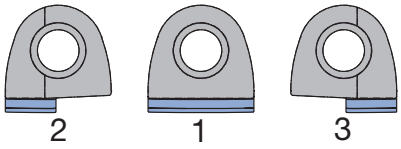


Shape of WhisperCut spare knives
SB 6.7 / 14 mm

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
SCM	125	51		HSK 32 R	5	3x6	12xA 3xA1 3xA2	AS°	**192337**	**192338**
SCM	125	51		HSK 32 R	5	4x6	16xA 4xA1 4xA2	AS°	**192341**	**192342**
SCM	125	66		HSK 32 R	5	3x7	18xA 3xA1	AS°	**192339**	
SCM	125	66		HSK 32 R	5	3x7	18xA 3xA2	AS°		**192340**
SCM	125	66		HSK 32 R	5	4x7	24xA 4xA1	AS°	**192343**	
SCM	125	66		HSK 32 R	5	4x7	24xA 4xA2	AS°		**192344**
Stefani	100	51	60	30 DKN	3	2x6	8xB 2xB1 2xB2	AS°	**192215** ●	**192216** ●
Stefani	100	51	60	30 DKN	3	3x6	12xB 3xB1 3xB2	AS°	**192217** ●	**192218** ●
Stefani	100	66	60	30 DKN	3	2x7	12xB 2xB1	AS°	**192213** ●	
Stefani	100	66	60	30 DKN	3	2x7	12xB 2xB2	AS°		**192214** ●
Stefani	100	66	60	30 DKN	3	3x7	18xB 3xB1	AS°	**192219** ●	
Stefani	100	66	60	30 DKN	3	3x7	18xB 3xB2	AS°		**192220** ●
Turanlar Makine	70	54	30	20 DKN	2	2x5	10xD	AS	**192320** ●	**192321** ●
Turanlar Makine	70	54	30	20 DKN	2	3x5	15xD	AS	**192324**	**192325**
Turanlar Makine	125	54	30	30 DKN	3	3x5	15xE	AS	**192322** ●	**192323** ●
Törk Makine	100	65.2	40.6	30 DKN	3	3x6	18xA	AS	**090887** ●	**090888** ●

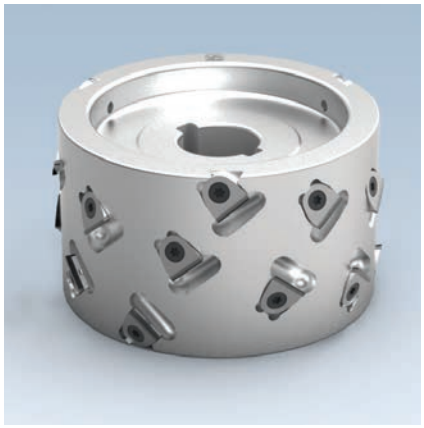
Spare knives:

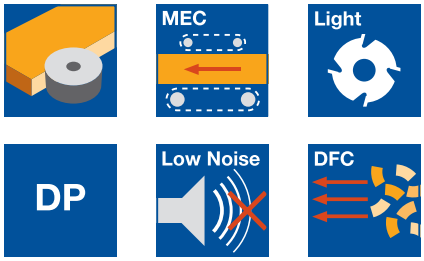
BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	A	1	**091052** ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A1	3	**091082** ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A2	2	**091081** ●
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	**091066** ●
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	3	**091067**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

Eroded spare knives for quick and easy knife change.

Spare parts:

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





WhisperCut EdgeExpert jointing / milling cutter - cutterhead design

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

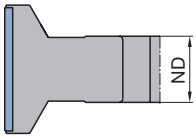
Machine:
Edgebanding machines, copy shaping machines, double-end tenoners etc.

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

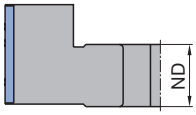
Technical information:
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces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

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

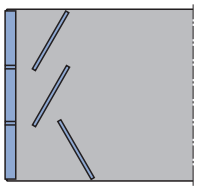
Machine	D mm	SB mm	ND mm	BO mm	NAL	n_{max} min^{-1}	Z	Type	ID LH	ID RH
Biesse	125	43	40	30 DKN	2	13,700	3x6	S	**192249** ●	**192249** ●
Biesse	125	63	40	30 DKN	2	13,700	3x8	S	**192250** ●	**192250** ●
Homag	125	43	40	30 DKN	2	13,700	3x6	S	**192249** ●	**192249** ●
IMA	125	43	40	30 DKN	2	13,700	3x6	AS	**192251** ●	**192252** ●
IMA	125	63	40	30 DKN	3	13,700	3x8	AS	**192301** ●	**192302** ●



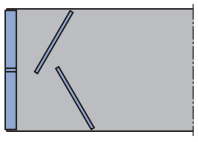
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement

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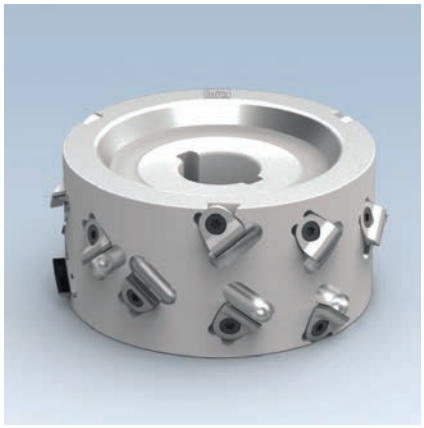
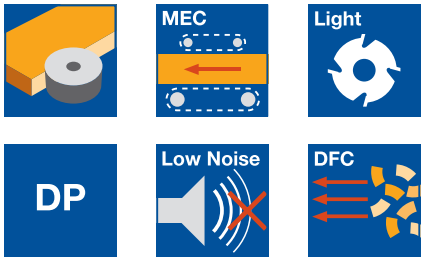
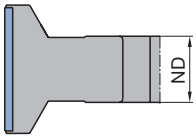
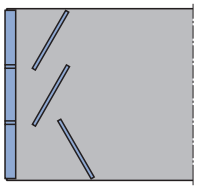
Instruction manual visit www.leitz.org



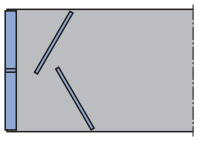




Position of boss (NAL) 2



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement

WhisperCut PLUS EdgeExpert jointing / milling cutter - cutterhead design

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

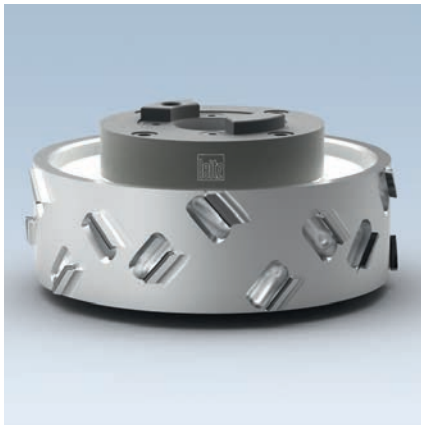
Machine:
Edgebanding machines, copy shaping machines, double-end tenoners etc.

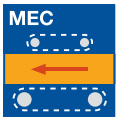
Workpiece material:
Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

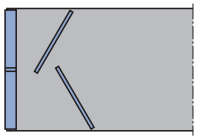
Technical information:
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces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

Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body
WM 230 2 02

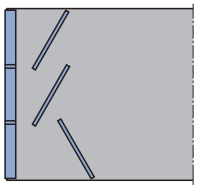
Machine	D mm	SB mm	ND mm	BO mm	NAL	n_{max} min^{-1}	Z	Type	ID LH	ID RH
Biesse	125	43	40	30 DKN	2	13,700	3x6	S	**192255** ●	**192255** ●
Homag	125	43	40	30 DKN	2	13,700	3x6	S	**192255** ●	**192255** ●
IMA	125	43	40	30 DKN	2	13,700	3x6	AS	**192256** ●	**192257** ●



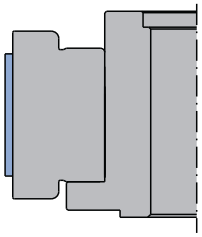





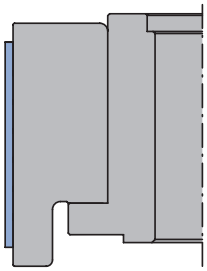
Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement



Position of boss (NAL) 1



Position of boss (NAL) 2

Jointing / milling cutter on hydro sleeve

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

Machine:
Edgebanding machines with zero joint technology.

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

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

Diamaster PRO mounted on hydro sleeve
HF 230 2, HF 230 2 DP

Machine	D mm	SB mm	BO mm	n_{max} min^{-1}	NAL	Z	Type	ID LH	ID 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_{max} min^{-1}	NAL	Z	Type	ID LH	ID 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_{max} min^{-1}	NAL	Z	ID LH	ID 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 mm	ID
Securing part	for HF-spindle HF 30	**066563** ●
Allen key	SW 5, L 150	**005501** ●

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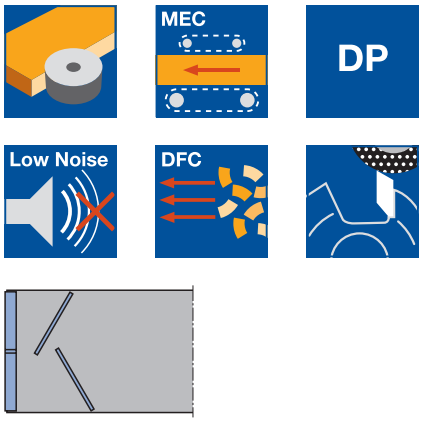
□ available at short notice
Instruction manual visit www.leitz.org



Type S = symmetric knife arrangement

Jointing / milling cutter on HSK-F 63 arbor

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

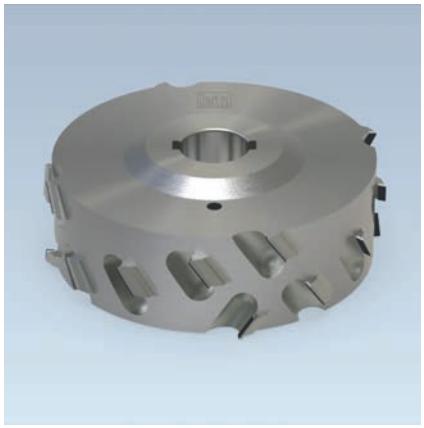
Machine:
Edgebanding machines with zero joint technology.

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^{-1}	Z	Type	ID LH	ID RH
Homag	150	43	HSK-F 63 mod.	13600	5x4	S	**192197** □	**192198** □
Homag	150	63	HSK-F 63 mod.	13600	5x6	S	**192199** □	**192200** □



Jointing / milling cutter

Application:
For jointing/milling rebates in panel edges.

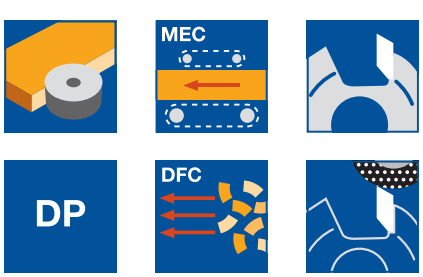
Machine:
Edgebanding machines and double-end tenoners.

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^{-1}	Z	ID LH	ID RH
150	45	39	30 DKN	11400	4x5	**192266**	**192267**
150	64	39	30 DKN	11400	4x7	**192268**	**192269**



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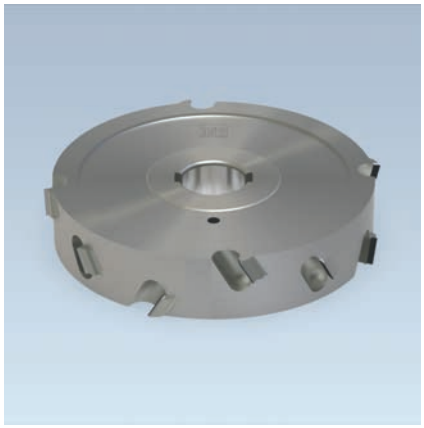
□ available at short notice
Instruction manual visit www.leitz.org



Protection milling / jump cutting

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

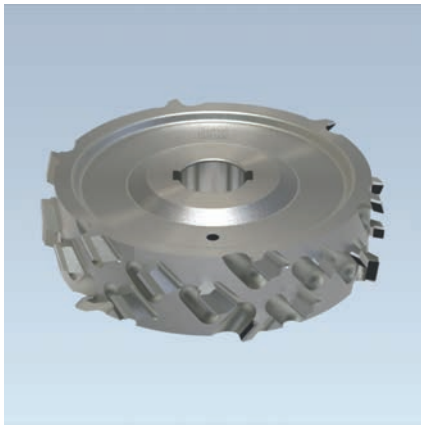
Machine:
Edgebanding machines and double-end tenoners.

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^{-1}	Z	Type	ID LH	ID RH
Homag, IMA	180	32	42	35 DKN	1	9,500	4x3	AS	**090851**	**090852**
Homag, IMA	180	43	46	35 DKN	1	9,500	4x4	AS	**090841** ●	**090842** ●
Homag, IMA	180	63	46	35 DKN	3	9,500	4x6	AS	**090839** ●	**090840** ●



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^{-1}	Z	Type	ID LH	ID RH
Homag, IMA	180	34	34	35 DKN	2	9500	6x3	AS	**090847**	**090848**
Homag, IMA	180	43	46	35 DKN	1	9500	6x5	AS	**192056**	**192057**
Homag, IMA	180	63	46	35 DKN	3	9500	6x7	AS	**192058**	**192059**
Homag, IMA	180	34	34	35 DKN	2	9500	8x4	AS	**192060**	**192061**
Homag, IMA	180	43	46	35 DKN	1	9500	8x5	AS	**192062**	**192063**
Homag, IMA	180	63	46	35 DKN	3	9500	8x7	AS	**192064**	**192065**

Recommended feed rate for 6000 min^{-1} for veneered or coated particle and fibre materials.
Z=4 25 m min^{-1}
Z=6 35 m min^{-1}
Z=8 45 m min^{-1}
Z=10 55 m min^{-1}
Z=12 65 m min^{-1}
Z=14 80 m min^{-1}

● available ex stock
□ available at short notice
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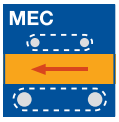



Order example:
Hogging set D-250 mm, Z 36, right
Hogging set consisting of:
DT Premium hogger D-250 ID **190391**
Hydro clamping sleeve ID **061702**

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.

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).

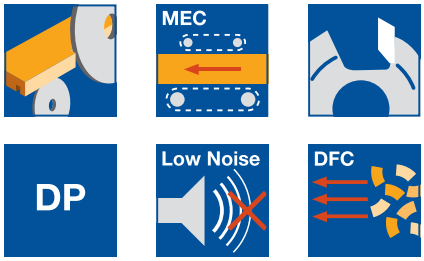
Diamaster DT Premium
HZ 210 2

D mm	SB mm	BO mm	ZF	Z	v_f* m min^{-1}	ID LH	ID 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**

Further dimensions on request.

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

* Recommended feed rate.



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.

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

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.

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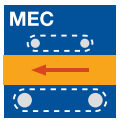
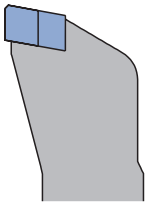
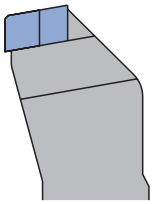


DP



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

Compact hogger
HZ 210 2

D mm	SB mm	BO mm	Z	ZF	v_f* m min^{-1}	ID LH	ID RH
250	10	60	35	decreasing	35	**190358** ●	**190359** ●
250	10	60	45	decreasing	45	**190360** ●	**190361** ●
250	10	60	55	decreasing	55	**190362**	**190363**
253	10	60	35	increasing	35	**190364**	**190365**
253	10	60	45	increasing	45	**190366**	**190367**
253	10	60	55	increasing	55	**190368**	**190369**
250	10	80	35	decreasing	35	**190370**	**190371**
250	10	80	45	decreasing	45	**190372**	**190373**
250	10	80	55	decreasing	55	**190374**	**190375**
253	10	80	35	increasing	35	**190376**	**190377**
253	10	80	45	increasing	45	**190378**	**190379**
253	10	80	55	increasing	55	**190380**	**190381**

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.

Process

Hogging along and across grain with/without scoring sawblades.

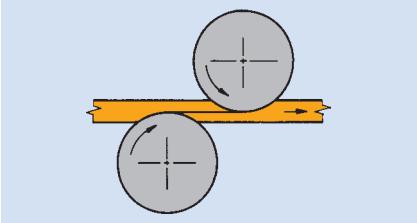
Workpiece materials

Solid wood, wood derived materials and composite materials.

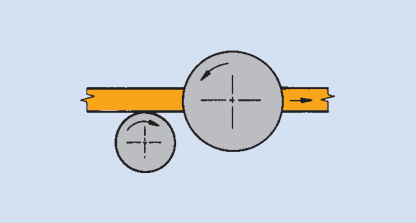
Machines

Multi-rip saws, double-end tenoners, window making machines, edgebanding machines.

Application



Double hogging:
Both hoggers cut with feed.



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

Recommended tooth shape hogger sawblades

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

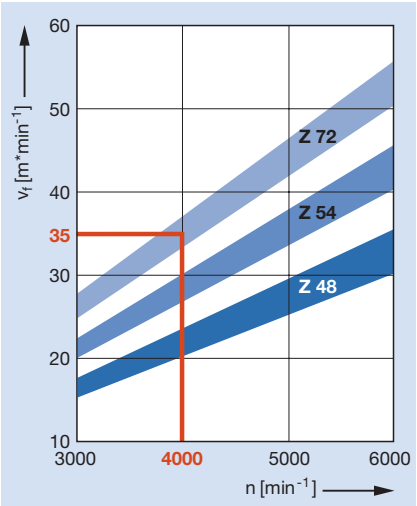
■ suitable
□ partly suitable

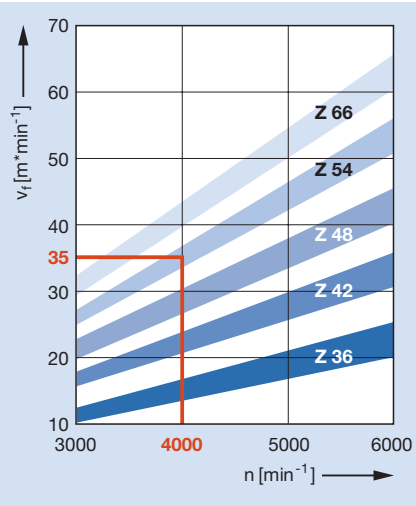
Cutting width and RPM

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

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

Segment hogger

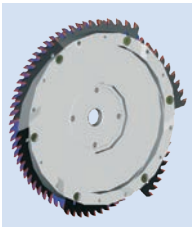




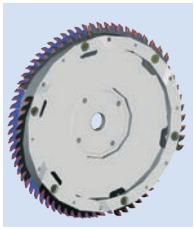
Feed speed v_f in relation to the number of teeth Z and RPM n.

Segment hogger

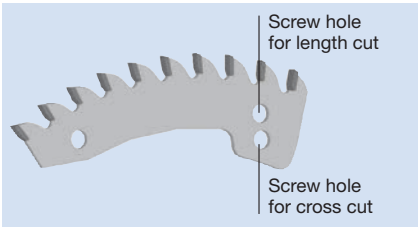
Segment hoggers are a modular design. Segment hoggers are used, depending on the diameter, for hogging widths from 25 to 70 mm. Hoggers or segment hoggers combined with different circular sawblades are suitable for cutting the following materials along and across the grain:
– Solid wood
– Wood derived materials without coating
– Wood derived materials with coating, with veneer, with paper etc.
– Composite materials



Cross cut



Length cut

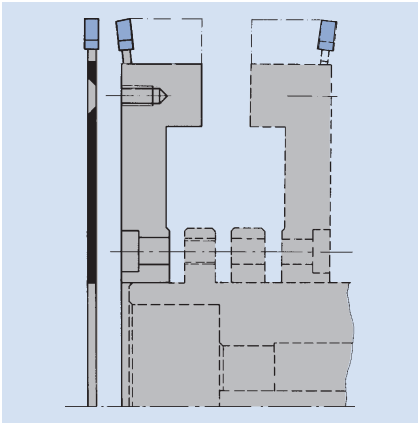


The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.
Segment hoggers with up to 12 segments are used for edging and sizing on wood-derived material production lines (e.g. Siempelkamp, Kontra etc.). A special segment hogger design has been developed for the finish cut on wood derived material production lines.

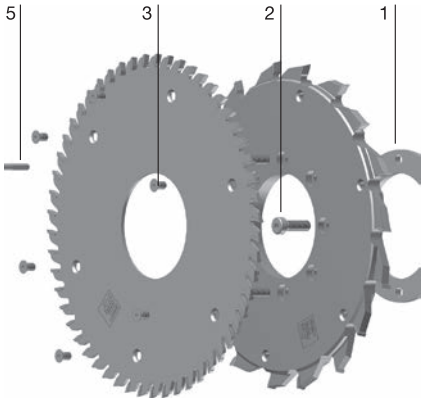
Saw hogger

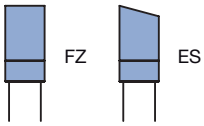
Saw hoggers, single tools or assemblies with cutting widths of 6.35 - 12.00 mm are used for hogging along and across the grain and to size solid wood on finger jointing machines.

Assembly design/examples



Segment hogger with extension hogger.





Hoggers

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

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

Workpiece material:
Solid wood and wood derived materials.

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

Basic hogger - steel tool body without flanged sleeve
WZ 210 2 01, WZ 210 2 02

BEZ	D mm	SB mm	BO mm	QAL	Z	ID LH	ID RH
Basic hogger	251	12	80	HW	18	**062602** ●	**062603** ●
Basic hogger	301	12	80	HW	24	**062604** ●	**062605** ●
Extension cutter	251	12	80	HW	18	**062652** ●	**062653** ●
Extension cutter	251	12	80	HW	24	**062654** ●	**062655** ●

Spare parts:

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

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	**061825** ●	**061826** ●
250	4.4	80	54	ES	HW	**061837** ●	**061838** ●
250	4.4	80	72	FZ	HW	**061945** ●	**061946** ●
260	4.4	80	72	ES	HW	**061860**	**061861**
260	4.4	80	72	FZ	HW	**061947** ●	**061948** ●
300	4.4	80	48	FZ	HW	**061827** ●	**061828** ●
300	4.4	80	48	ES	HW	**062028**	**062029**
300	4.4	80	72	FZ	HW	**061949**	**061950**

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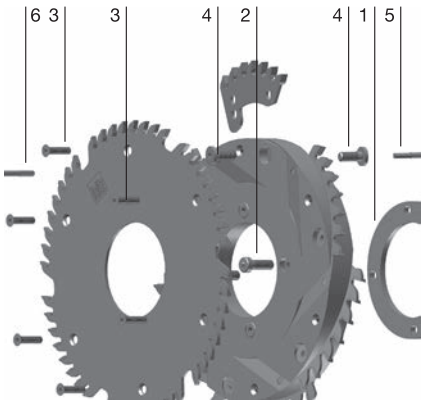
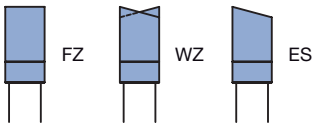
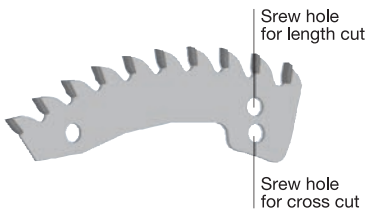
HW







Spare segments for segment hogger

Segment hoggers

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

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

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

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

Steel basic and extension hoggers without flanged sleeve
WZ 300 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	26,0	80	6x7	FZ	HW	**064410** ●	**064411** ●
300	31.5	30	6x9	FZ	HW	**064412** ●	**064413** ●
350	36.5	30	6x10	FZ	HW	**064414** ●	**064415** ●

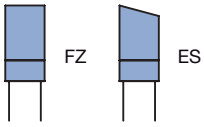
Spare parts:

Part-no.	BEZ	ABM mm	SB mm	QAL	ZF	Z	BEM	ID
	Hogging segment	D 250	5.7	HW	FZ	7		**064958** ●
	Hogging segment	D 250	5.7	HW	FZ	7		**064959** ●
	Hogging segment	D 300	5.7	HW	FZ	9		**064960** ●
	Hogging segment	D 300	5.7	HW	FZ	9		**064961** ●
	Hogging segment	D 350	5.7	HW	FZ	10		**064962** ●
	Hogging segment	D 350	5.7	HW	FZ	10		**064963** ●
1	Spacer	115x5x80						**028046** ●
2	Cylindrical screw with ISK	M8x20						**005946** ●
3	Countersink screw, Torx® 20	M6x10					Torx® 20	**006083** ●
4	Screw with ISK	M8x17					for D = 250, 350, 305, 355	**006237** ●
5	Allen key	SW 6						**005494** ●
6	Torx® key	Torx® 20						**117503** ●

Spare circular sawblade for segment hogging set
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



DFC segment hogger available on special request.

Spare circular sawblade for DFC segment hogger
WK 801 2, WK 801 2 05

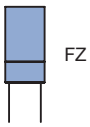
D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	4.4	80	54	ES	HW	**061837** ●	**061838** ●
260	4.4	80	54	ES	HW	**061858**	**061859**
260	4.4	80	72	ES	HW	**061860**	**061861**

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 mm	Z	ZF	QAL	ID LH	ID 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 mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID 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

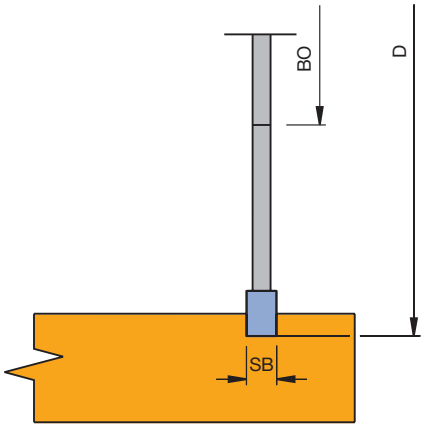
Type	for D mm	SB mm	Z	ZF	QAL	ID LH	ID RH
1	200/250	4	4	FZ	HW	**064976** ●	**064977** ●

Type 1 for Leuco.

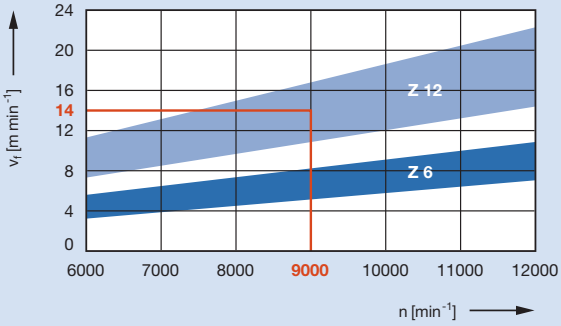
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

Grooving with feed

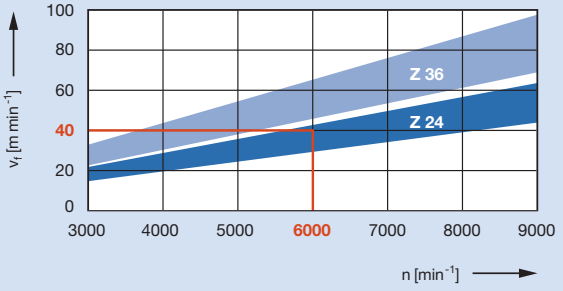
Straight cut composite tool for grooving with feed (MEC).



Cutting rear panel grooves



Feed speed v_f depending on number of teeth Z and RPM n for wood derived materials (top layer)



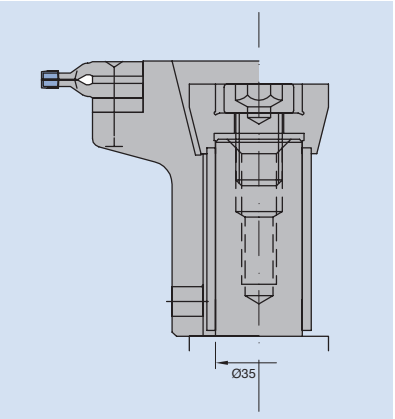
Feed speed v_f depending on number of teeth Z and RPM n for wood derived materials (middle layer)

Grooving against feed

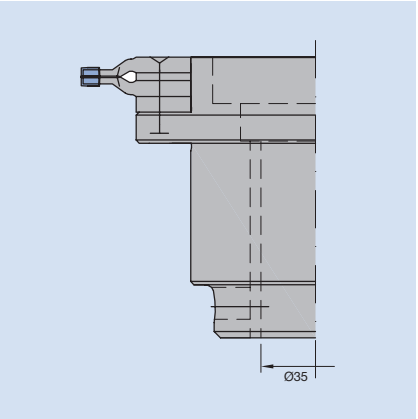
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

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

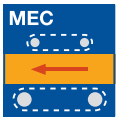
Tools for grooving against feed available on request.

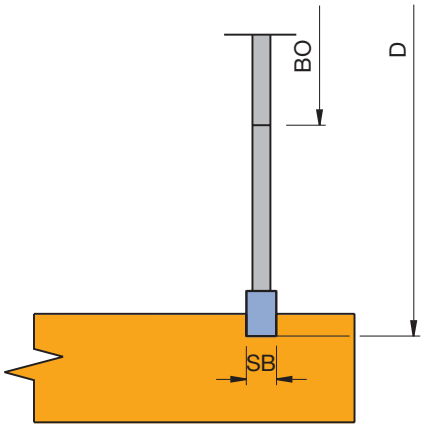


Assembly example:
Spindle 30 KN or DKN

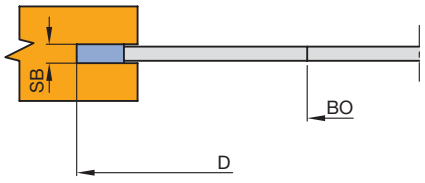


Assembly example:
Spindle 35 KN or DKN

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.

HW tipped
WF 100 2, WF 100 2 02, WF 100 2 03

D mm	SB mm	TDI mm	BO mm	BO_{max} mm	Z	n_{max} min^{-1}	ID
80	4,0		16 DKN		3	12,000	**182000**
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	1.5	0.8	30	60	18	11,400	**020164** ●
150	2,0	1.2	30	60	18	11,400	**020166** ●
150	2.5	1.4	30	60	18	11,400	**020168** ●
150	3,0	2,0	30	60	12	11,400	**020154** ●
150	3,0	2,0	30	60	18	11,400	**020169** ●
150	3.5	2.2	30	60	12	11,400	**020155** ●
150	4,0	2.5	30	60	12	11,400	**020156** ●
150	4,0	2.5	30	60	18	11,400	**020170** ●
150	4.5	3,0	30	60	12	11,400	**020157** ●
150	5,0	3.5	30	60	12	11,400	**020158** ●
150	5,0	3.5	30	60	18	11,400	**020171** ●
150	6,0	4.5	30	60	12	11,400	**020159** ●
150	6,0	4.5	30	60	18	11,400	**020172** ●
150	7,0	5,0	30	60	12	11,400	**020160** ●
150	8,0	6,0	30	60	12	11,400	**020161** ●
150	8,0	6,0	30	60	18	11,400	**020173** ●
150	8.5	6,0	30	60	18	11,400	**020319** ●
150	10,0	7,0	30	60	12	11,400	**020163** ●
150	10,0	7,0	30	60	18	11,400	**020174** ●
180	2,0	1.2	30	70	18	9,500	**020202** ●
180	2.5	1.4	30	70	18	9,500	**020203** ●
180	3,0	2,0	30	70	18	9,500	**020204** ●
180	3.5	2.2	30	70	18	9,500	**020205** ●
180	4,0	2.5	30	60	18	9,500	**020197** ●
180	5,0	3.5	30	60	18	9,500	**020198** ●
180	6,0	4.5	30	60	18	9,500	**020199** ●
180	8,0	6,0	30	60	18	9,500	**020200** ●
180	8.5	6,0	30	60	18	9,500	**020320** ●
180	10,0	7,0	30	60	18	9,500	**020201** ●
200	2,0	1.2	35	80	18	8,500	**020299** ●
200	2.5	1.4	35	80	18	8,500	**020301**
200	3,0	2,0	35	80	18	8,500	**020302** ●
200	4,0	2.5	35	80	18	8,500	**020303** ●
200	5,0	3.5	35	80	18	8,500	**020304** ●
200	6,0	4.5	35	80	18	8,500	**020305** ●
200	8,0	6,0	35	80	18	8,500	**020306** ●
200	8.5	6,0	30	80	18	8,500	**020321** ●
200	10,0	7,0	35	80	18	8,500	**020307** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

DP

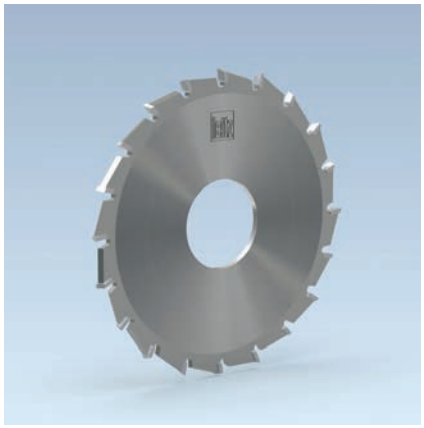
DP tipped
WF 100 2, WF 100 2 DP

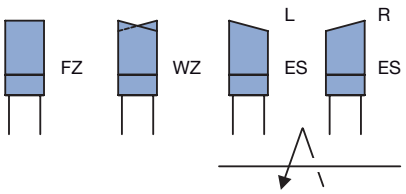
D mm	SB mm	TDI mm	BO mm	BO_{max} mm	NLA mm	Z	ZF	QAL	n_{max} min^{-1}	ID
80	4,0		16			3	FZ	DP		**192334**
150	4,0	2.5	30	60		18	FZ	DP	11,400	**192304** ●
180	4,0	2.5	30	60		24	FZ	DP	9,500	**192305** ●
180	8.5	6,5/8,5	80		4/9/100 4/9/100	35	WZ/WZ/FZ	DP	9,500	**190755** ●
200	4,0	2.5	30	80		24	FZ	DP	8,500	**192306** ●

DP tipped, mounted on flanged sleeve ID 61681
SF 500 2

D mm	SB mm	BO mm	DKN mm	Z	ZF	QAL	n_{max} min^{-1}	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





Circular sawblade for end trim on edgebanding machines

Application:
For low noise edgebanding trim cuts.

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

Workpiece material:
Veneered, melamine and plastic edging.

Technical information:
Tooth geometries and pitch designed for optimum cutting quality.
Veneered and plastic edging:
Edging thickness ≥ 2.0 mm - crosscut saw ES pos.
Edging thickness < 2.0 mm - crosscut saw ES neg.

Circular sawblade - LowNoise, ES
SK 499 2, WK 101 2, WK 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	ID RH
	Biesse	115	3.2	52	3/7,1/64	30	ES pos.	**166420**	**166421**
	Biesse	115	3.2	56	3/7,1/68	30	ES pos.	**166422**	**166423**
	Biesse	130	3.6	30	4/7,4/46	24	ES pos.	**166424** ●	**166425** ●
	Biesse	140	3.2	30		36	ES pos.	**166427** ●	**166426** ●
	Brandt	100	2.6	32		30	ES neg.	**166400** ●	**166401** ●
	Brandt	100	2.6	32		30	ES pos.	**166429** ●	**166430** ●
	Brandt	110	2.4	32		40	ES pos.	**166432**	**166433**
	Brandt	125	2.6	32		30	ES neg.	**166403** ●	**166404** ●
	Brandt	150	2.8	20		36	ES pos.	**166434** ●	**166435** ●
	Cehisa	100	3,0	32		30	ES pos.	**166436** ●	**166437** ●
	Fravol	100	3.2	22		24	ES pos.	**166407** ●	**166406** ●
	Fravol	100	2.6	30		30	ES pos.	**166476** ●	**166477** ●
	Fravol	125	3.2	22		30	ES pos.	**166411** ●	**166410** ●
	Holz-Her	110	3.6	22		16	ES pos.	**166439** ●	**166440** ●
	Homag	80	3.2	34	8/4,2/44	30	ES pos.	**166443** ●	**166444** ●
*	Homag	100	3,0	32		20	ES pos.	**166445** ●	**166446** ●
	Homag	100	3.2	32		20	ES neg.	**166449** ●	**166450** ●
	Homag	100	2.6	32		30	ES neg.	**166400** ●	**166401** ●
	Homag	100	2.6	32		30	ES pos.	**166429** ●	**166430** ●
	Homag	110	2.4	32		40	ES pos.	**166432**	**166433**
	Homag	110	1.7	40	4/5,5/52	30	FZ/TR pos.	**166453** ●	**166453** ●
*	Homag	120	3.2	40		30	ES pos.	**166454** ●	**166455** ●
	Homag	125	2.6	32		30	ES neg.	**166403** ●	**166404** ●
	Homag	150	2.8	20		36	ES pos.	**166434** ●	**166435** ●
	Homag	150	3.5	30	4/5,6/52	40	ES pos.	**166458**	**166459**
	IDM	90	3,0	30		20	FZ pos.	**166461**	**166461**
	SCM	150	3.8	35	4/6,5/50	30	ES pos.	**166468** ●	**166469** ●
	Törk Makine	140	3.2	30		36	ES pos.	**166417**	**166418**
	Wilmsmeyer	100	3.2	32		20	ES neg.	**166449** ●	**166450** ●

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

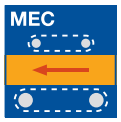
Workpiece material:
Softwood, hardwood edging.

Technical information:
Tooth geometries and pitch designed for optimum cutting quality.
Solid wood edging and multi-purpose application:
Edging thickness ≥ 2.0 mm - crosscut saw WZ pos.
Edging thickness < 2.0 mm - crosscut saw WZ neg.

Circular sawblade - LowNoise, WZ
WK 250 2, WK 350 2, WK 360 2, WK 370 2, WK 380 2, WK 850 2

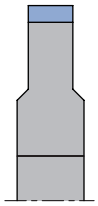
Machine	D	SB	BO	NLA	Z	ZF	ID	ID
	mm	mm	mm	mm			LH	RH
Biesse	100	3.2	30		20	WZ pos.	**166478** ●	**166478** ●
Biesse	160	3.2	20		48	WZ pos.	**166428** ●	**166428** ●
Brandt	100	2.6	32		30	WZ pos.	**166431** ●	**166431** ●
Brandt	125	2.4	32		24	WZ pos.	**166402** ●	**166402** ●
EBM	100	2.4	22	2/4/30	20	WZ neg.	**166405** ●	**166405** ●
Felder	100	3.2	22		20	WZ pos.	**166438** ●	**166438** ●
Felder	110	3.2	30		20	WZ pos.	**166475** ●	**166475** ●
Hebrock	100	2.4	22	2/4/30	20	WZ neg.	**166405** ●	**166405** ●
Holz-Her	110	3.6	22		20	WZ pos.	**065663** ●	**065663** ●
Holz-Her	120	3.2	22		20	WZ pos.	**166474** ●	**166474** ●
Holz-Her	140	3.2	22		36	WZ pos.	**166441** ●	**166441** ●
Holz-Her	160	3.2	20		48	WZ pos.	**166428** ●	**166428** ●
Holz-Her	160	3.2	30		24	WZ pos.	**065664** ●	**065664** ●
Homag	100	3.6	32		20	WZ pos.	**166451** ●	**166451** ●
Homag	100	2.6	32		30	WZ pos.	**166431** ●	**166431** ●
Homag	110	3.6	32		20	WZ pos.	**166452** ●	**166452** ●
Homag	120	3.6	40	8/5,6/52	24	WZ pos.	**166419** ●	**166419** ●
Homag	120	3.2	40	8/5,6/52	36	WZ pos.	**166456** ●	**166456** ●
Homag	120	3.6	40	8/5,6/52	36	WZ pos.	**166457** ●	**166457** ●
Homag	125	2.4	30	8/6,5/48	36	WZ pos.	**058234** ●	**058234** ●
Homag	125	2.4	32		24	WZ pos.	**166402** ●	**166402** ●
Homag	170	3.2	30	8/5,6/52	36	WZ pos.	**166412** ●	**166412** ●
Homag	180	3.2	30	4/5,6/52	54	WZ pos.	**166460** ●	**166460** ●
IMA	160	3.5	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	90	2.6	20		20	WZ	**166483**	**166483**
SCM	107	6,0	40		12	R3	**166481**	**166482**
SCM	115	3.2	30		30	WZ pos.	**166416** ●	**166416** ●
SCM	125	3.2	30		24	WZ	**166480** ●	**166480** ●

Working processes	Finishing plastic, veneered and solid wood edges of wood material boards. – Pre-cutting to remove asymmetric edge protrusions on top and bottom edges and edge trimming solid wood edges. – Profiling a bevel or round edge on top and bottom edges. – Profiling a bevel and round edges on top and bottom edges and front and back. – Profile scrapers to remove knife marks. – Flat scrapers for excellent alignment of edge and workpiece.
Workpiece material	Thick plastic edgebanding made from PVC, PP, ABS, thin plastic edgebanding made from melamine resin, veneer edgebanding, solid wood banding and edgebanding.
Machines	Single or double-sided edgebanding machines, double-end tenoners.
Application	Against feed for plastic edgebanding, preferably with feed for solid wood edge lippings.
Technical features	Tool and touch roller positions are coordinated, requiring constant tool dimensions. It is recommended not to resharpen edge processing tools.
Chip disposal	Tools with optimised chip collection are designed to the corresponding machines (i-System, ED-System), and guide the chips from the tool cutting edge into the extraction. Even at low extraction air speeds more than 97% of the chips are collected. This improves not only process efficiency and productivity, but also the working environment. New machines require less extraction.

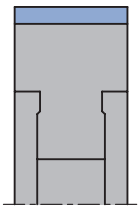


DP

HW



Type 1



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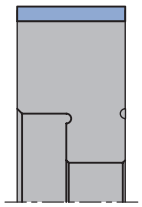

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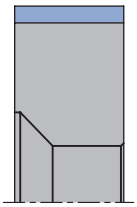


Type 4

Pre / finishing edge trimming cutter

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

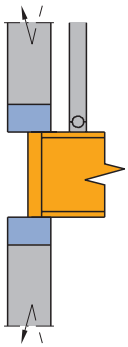
Machine:
Single or double-sided edgebanding machines.

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

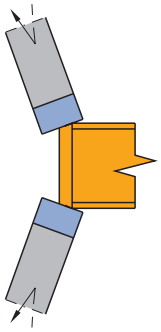
Technical information:
HW/DP tipped tools with cylindrical bore.

Jointing cutter
WF 200 2, WF 200 2 DP, WF 210 2, WF 210 2 DP

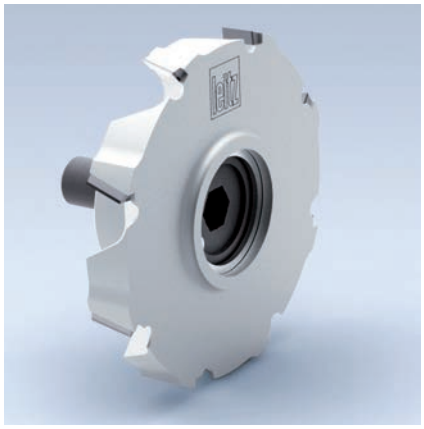
Machine	D mm	SB mm	ND mm	BO mm	Type	Z	QAL	ID LH	ID RH
Biesse	70	10	12	16 DKN	1	6	DP	**090899**	**090899**
Biesse	70	20	12	16 DKN	2	6	DP	**090893**	**090893**
Biesse	80	22	12	16 DKN	3	6	DP	**192103** ●	**192102** ●
Brandt	70	10	12	16 DKN	1	6	DP	**090899**	**090899**
Brandt	70	20	12	16 DKN	2	6	DP	**090893**	**090893**
Brandt	70	25	25	16 DKN	3	4	HW	**065588** ●	**065589** ●
Fravol	80	30	27.5	20 DKN	3	4	DP	**192270** ●	**192271** ●
Holz-Her 1828	70	19.5	19.5	20 DKN	4	4	HW	**065592**	**065593**
Homag	70	10	12	16 DKN	1	6	DP	**090899**	**090899**
Homag	70	20	12	16 DKN	2	6	DP	**090893**	**090893**
Homag	70	25	25	16 DKN	3	4	HW	**065588** ●	**065589** ●
Ott	70	16.5	10	16 DKN	3	4	DP	**192283** ●	**192284** ●
SCM	80	30	11	16 DKN	2	4	HW	**065595** □	**065596** □
Stefani	80	20	11	16 DKN	2	4	DP	**192110** ●	**192111** ●

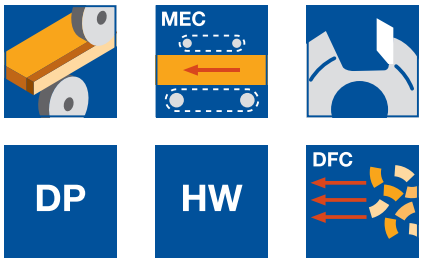


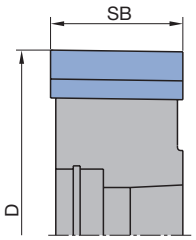
Trimming of edges on horizontal spindle - top motor tracing.



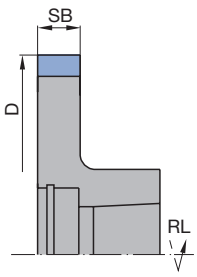
Bevelling of edges with inclined spindle.







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



DP jointing cutter with HSK 25 R adaptor

Pre / finishing edge trimming cutter with optimised chip collection

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

Machine:
Single or double-sided edgebanding machines.

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

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

Jointing cutter - optimised chip collection
WF 200 2 DP, WF 210 2, WF 210 2 DP

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

Recommended number of teeth:
Feed rates of up to 35 m min^{-1} Z 4
Feed rates of up to 60 m min^{-1} Z 6
Feed rates of up to 100 m min^{-1} Z 8 (thin edge)

● available ex stock
□ available at short notice
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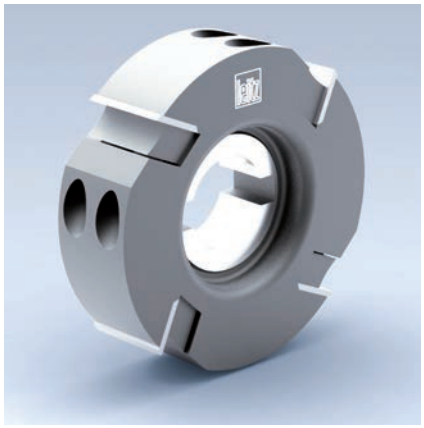
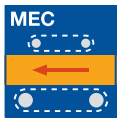
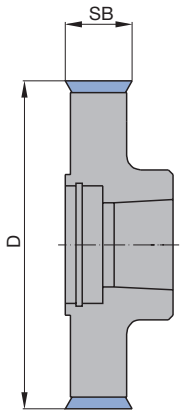
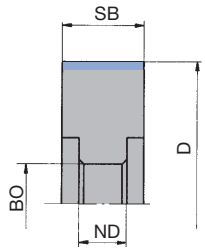




HW



Type 1: WW 200 2 25



Type 2: WW 200 2 06

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.

Jointing cutterhead
WW 200 2, WW 200 2 06, WW 200 2 25

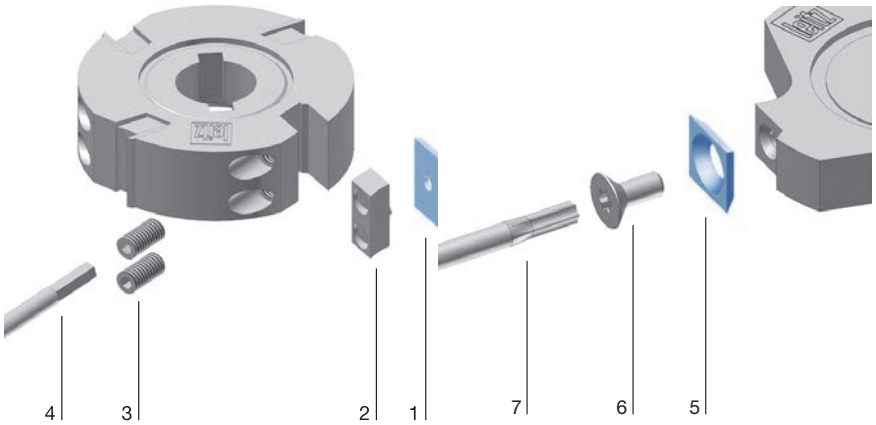
Machine	Type	D mm	SB mm	BO mm	Z	ID LH	ID RH
Brandt, Homag	1	70	14.3	16 DKN	4	**025130** ●	**025130** ●
Homag	1	70	14.3	HSK 25 R	4	**073599** ●	**073600** ●
Homag	2	70	20	16 DKN	4	**025079** ●	**025079** ●
Ott, Holz-Her	2	70	20	16	4	**025078**	**025078**
Holz-Her 1962	2	80	40	30 KN	4	**024415**	**024415**

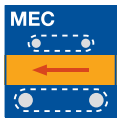
Spare knives:

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

Spare parts:

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



DP HW

Bevel cutter

Application:
To bevel edgebandings.

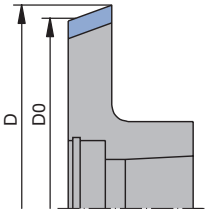
Machine:
Single or double-sided edgebanding machines.

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

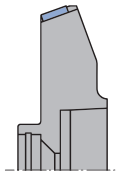
Technical information:
HW/DP tipped tools with cylindrical bore, HSK 25 R or HSK 32 adaptor for FK aggregates.

Various bevel angles
WF 300 2 DP, WF 350 2 DP, WF 502 2

Machine	D	D_0	SB	BO	Z	QAL	FAW	Type	ID	ID
	mm	mm	mm	mm			°		LH	RH
Biesse	67.2	60	9	16 DKN	6	DP	25	5	**091976**	**091975**
Biesse	67.2	60	9	20 DKN	6	DP	25	5	**091970**	**091969**
Biesse	68.1	60	9	20 DKN	6	DP	45	5	**091972**	**091971**
Biesse	68.9	60	9	16 DKN	6	DP	45	5	**091978**	**091977**
Biesse	80	69.86	10.5	16 DKN	4	DP	15	6	**091974**	**091973**
Holz-Her 1825	52.1	50	6	16 DKN	2	DP	15	3	**091982**	**091981**
Holz-Her 1832	53.2	50	8	16 DKN	3	DP	15	3	**091986**	**091985**
Holz-Her 1832	56	50	5	16 DKN	3	DP	45	3	**091988**	**091987**
Holz-Her 1833	72.6	61	8	20 DKN	4	DP	45	4	**091984**	**091983**
Homag	64.5	62	5	HSK 32	4	DP	20	2	**091518**	**091519**
Homag	66	62	5	HSK 32	6	DP	30	2	**091690**	**091691**
Homag	67	62	5	HSK 32	6	DP	20	2	**091658**	**091659**
Homag	69	62	5	HSK 32	6	DP	45	2	**091692**	**091693**
Homag	74.7	70	8	HSK 25 R	4	DP	20	1	**091790**	**091791**
IMA	74.7	70	8	HSK 25 R	4	DP	20	1	**091790**	**091791**
SCM	66.7	63.9	8	HSK 25 R	4	HW	25	7	**182536** □	**182537** □
Stefani	73	61.7	5	12 DKN	4	DP	20	3	**091980**	**091979**



Type 1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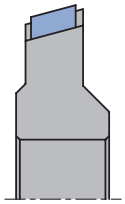
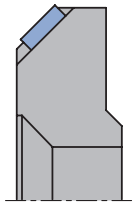

Type 3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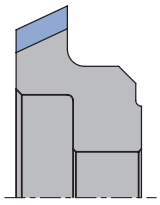
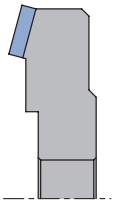
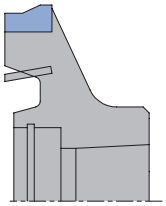

Type 5


Type 6


Type 7

● available ex stock
□ available at short notice
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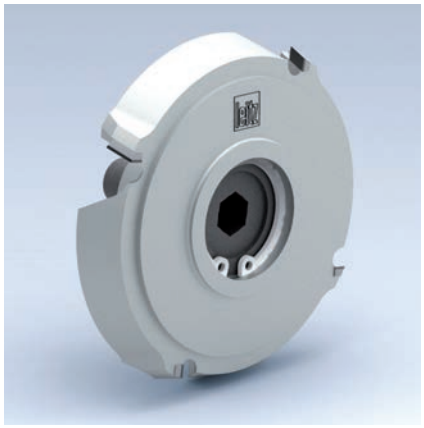
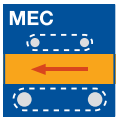
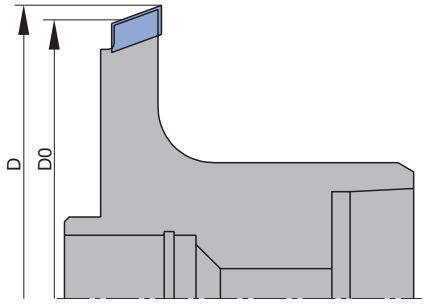
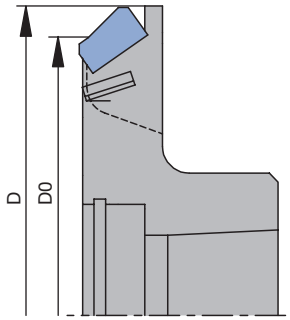






Bevel cutter with HSK 32 adaptor for FK aggregates



Bevel cutter with HSK 25 R adaptor

Bevel cutter with optimised chip collection

Application:
To bevel edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

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

Various bevel angles - optimised chip collection
WF 300 2 DP, WF 350 2 DP

Machine	D mm	D_0 mm	SB mm	BO mm	Z	QAL	FAW °	NH mm	ID LH	ID RH
Homag	65.14	62.3	5.7	HSK 32	4	DP	20	31.5	**198200** ●	**198201** ●
Homag	70	62.3	5.7	HSK 32	4	DP	45	31.5	**198240** ●	**198241** ●
Homag	65.14	62.3	5.7	HSK 32	6	DP	20	31.5	**198202** ●	**198203** ●
Homag	68.3	62.3	5.7	HSK 32	6	DP	45	31.5	**198242** ●	**198243** ●
Homag	72.91	70	5.5	HSK 25 R	4	DP	20	19.5	**198408** ●	**198409** ●
Homag	78	70	5.5	HSK 25 R	4	DP	45	19.5	**198464** ●	**198465** ●
Homag	73	70	5.5	HSK 25 R	6	DP	20	19.5	**198410** ●	**198411** ●
Homag	78	70	5.5	HSK 25 R	6	DP	45	19.5	**198466** ●	**198467** ●
IMA	72.91	70	5.5	HSK 25 R	4	DP	20	19.5	**198408** ●	**198409** ●
IMA	78	70	5.5	HSK 25 R	4	DP	45	19.5	**198464** ●	**198465** ●
IMA	73	70	5.5	HSK 25 R	6	DP	20	19.5	**198410** ●	**198411** ●
IMA	78	70	5.5	HSK 25 R	6	DP	45	19.5	**198466** ●	**198467** ●
SCM	69.6	62.5	5.5	HSK 25 R	4	DP	45	22	**192707** □	**192708** □
SCM	69.6	62.5	5.5	HSK 25 R	4	DP	30	22	**192705** □	**192706** □
SCM	69.6	62.5	5.5	HSK 25 R	4	DP	20	22	**192703** □	**192704** □

● available ex stock
□ available at short notice
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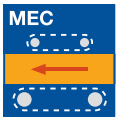
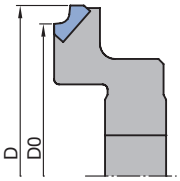
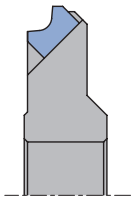


DP HW



Type 1

Type 2



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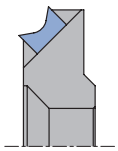

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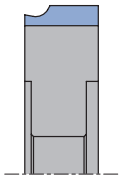

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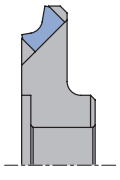

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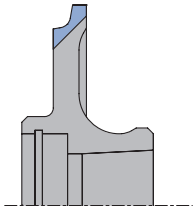
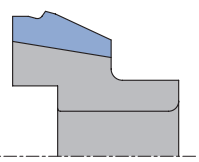


Type 7



Type 8

Profile cutter

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

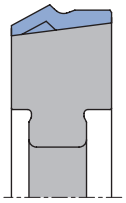
Technical information:
HW/DP tipped tools with cylindrical bore, HSK 25 R adaptor or HSK 32 adaptor for FK-aggregates. High concentricity. D_0 = constant reference diameter.

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

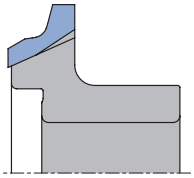
	Machine	D mm	D_0 mm	BO mm	Z	QAL	R mm	Type	ID LH	ID RH
	Biesse	67	60	16 DKN	6	DP	1,0	1	**091960** ●	**091961** ●
	Biesse	68	60	16 DKN	6	DP	2,0	1	**091962** ●	**091963** ●
	Biesse	70	60	16 DKN	6	DP	3,0	1	**091964** ●	**091965** ●
	Biesse	72	70	16 KN	6	DP	1,0	5	**192518** ●	**192519** ●
	Biesse	73	70	16 KN	6	DP	2,0	5	**192520** ●	**192521** ●
	Biesse	75	70	16 KN	6	DP	3,0	5	**192522** ●	**192523** ●
*	Brandt	58	50	16	4	DP	1,0	2		**091999** □
**	Brandt	58	50	16	4	DP	1.5	2		**192602** ●
*	Brandt	58	50	16	4	DP	2,0	2		**091966** ●
**	Brandt	58	50	16	4	DP	2,0	2		**192603** ●
	Brandt	70	62	HSK 25 R	4	DP	1,0	7	**192588** ●	**192589** ●
	Brandt	70	62	HSK 25 R	4	DP	1.3	7	**192590** ●	**192591** ●
	Brandt	70	62	HSK 25 R	4	DP	1.5	7	**192592** ●	**192593** ●
	Brandt	70	62	HSK 25 R	4	DP	2,0	7	**192594** ●	**192595** ●
	Brandt	70	62	HSK 25 R	4	DP	3,0	7	**192596** ●	**192597** ●
	EBM	32	24	14 DKN	2	DP	2,0	3	**074526** ●	
	EBM	56	49.7	16 DKN	2	DP	2,0	6	**192669** ●	**192670** ●
	EBM	56	49.7	16 DKN	2	DP	2.5	6	**192641** ●	**192642** ●
	Fravol	73	71.15	20 DKN	4	DP	1-3	8	**192645** ●	**192646** ●
	Fravol	76.8	74.71	20 DKN	4	DP	1-3	9	**192647** ●	**192648** ●
	Fravol	50	40.1	15 KN	4	DP	1-3	10	**192663** ●	**192664** ●
	Fravol	50	39.91	15 KN	4	DP	1-3	11		**192665** ●
	Fravol	50	39.91	15 KN	6	HW	1-3	11		**065594** ●
	Hebrock	32	24	14 DKN	2	DP	2,0	3	**074526** ●	
	Hebrock	56	49.7	16 DKN	2	DP	2,0	6	**192669** ●	**192670** ●
	Hebrock	56	49.7	16 DKN	2	DP	2.5	6	**192641** ●	**192642** ●
	Holz-Her 1825	57	50	16 DKN	2	DP	2,0	3	**192536** ●	**192537** ●
	Holz-Her 1825	57	50	16 DKN	2	DP	2.5	3	**192538** ●	**192539** ●
	Holz-Her 1825	57	50	16 DKN	2	DP	3,0	3	**192540** ●	**192541** ●
	Holz-Her 1827	56	50	20 DKN	2	DP	2,0	4	**192506** ●	**192507** ●
	Holz-Her 1827	56	50	20 DKN	2	DP	2.5	4	**192508** ●	**192509** ●
	Holz-Her 1827	57	50	20 DKN	2	DP	3,0	4	**192510** ●	**192511** ●
	Holz-Her 1832	58.7	50	16 DKN	3	DP	2,0	3	**192512** ●	**192513** ●
	Holz-Her 1832	58.7	50	16 DKN	3	DP	2.5	3	**192514** ●	**192515** ●
	Holz-Her 1832	58.7	50	16 DKN	3	DP	3,0	3	**192516** ●	**192517** ●
	Holz-Her 1833	72.5	61	20 DKN	4	DP	2,0	4	**192500** ●	**192501** ●
	Holz-Her 1833	72.5	61	20 DKN	4	DP	2.5	4	**192502** ●	**192503** ●
	Holz-Her 1833	72.5	61	20 DKN	4	DP	3,0	4	**192504** ●	**192505** ●

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Type 9



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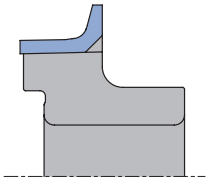

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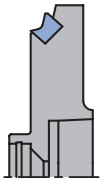

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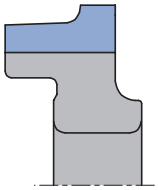

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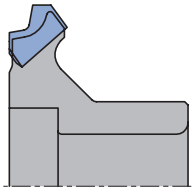

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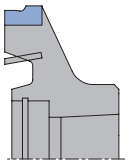
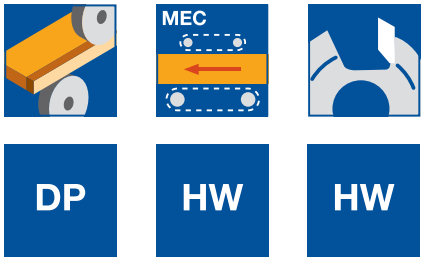
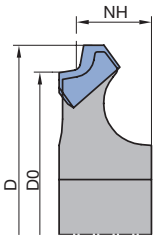


Type 15

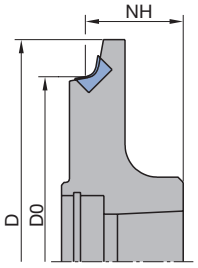
	Machine	D mm	D_0 mm	BO mm	Z	QAL	R mm	Type	ID LH	ID RH
*	Homag	58	50	16	4	DP	1,0	2		**091999** □
**	Homag	58	50	16	4	DP	1.5	2		**192602** ●
*	Homag	58	50	16	4	DP	2,0	2		**091966** ●
**	Homag	58	50	16	4	DP	2,0	2		**192603** ●
	Homag	70	62	HSK 25 R	4	DP	1,0	7	**192588** ●	**192589** ●
	Homag	70	62	HSK 25 R	4	DP	1.3	7	**192590** ●	**192591** ●
	Homag	70	62	HSK 25 R	4	DP	1.5	7	**192592** ●	**192593** ●
	Homag	70	62	HSK 25 R	4	DP	2,0	7	**192594** ●	**192595** ●
	Homag	70	62	HSK 25 R	4	DP	3,0	7	**192596** ●	**192597** ●
	Homag	67.1	62	HSK 32	4	DP	1,0	12	**091500** □	**091501** □
	Homag	68.1	62	HSK 32	4	DP	1.5	12	**091502** □	**091503** □
	Homag	69.1	62	HSK 32	4	DP	2,0	12	**091504** □	**091505** □
	Homag	70.1	62	HSK 32	4	DP	2.5	12	**091506** □	**091507** □
	Homag	71.2	62	HSK 32	4	DP	3,0	12	**091508** □	**091509** □
	Homag	67.05	62	HSK 32	6	DP	1,0	12	**091672**	**091673**
	Homag	68.08	62	HSK 32	6	DP	1.5	12	**091674**	**091675**
	Homag	69.1	62	HSK 32	6	DP	2,0	12	**091650**	**091651**
	Homag	70.13	62	HSK 32	6	DP	2.5	12	**091676**	**091677**
	Homag	71.16	62	HSK 32	6	DP	3,0	12	**091652**	**091653**
	Ott	69	61	16 DKN	3	DP	2,0	1	**192649** ●	**192650** ●
	Ott	69	61	16 DKN	4	DP	2,0	1	**192651** ●	**192652** ●
	SCM	55.3	49.33	16 DKN	3	DP	2,0	13	**192701**	**192702**
	SCM	55.3	49.33	16 DKN	3	HW	2,0	13	**182510** ●	**182511** ●
	SCM	55.7	48	16 DKN	3	HW	1,0	14	**182512** □	**182513** □
	SCM	55.7	48	16 DKN	3	HW	1.5	14	**182514** □	**182515** □
	SCM	55.7	48	16 DKN	3	HW	2,0	14	**182516** □	**182517** □
	SCM	55.7	48	16 DKN	3	HW	3,0	14	**182518** □	**182519** □
	SCM	65.82	63.88	HSK 25 R	4	HW	1,0	15	**182526** □	**182527** □
	SCM	66.44	63.88	HSK 25 R	4	HW	1.5	15	**182528** □	**182529** □
	SCM	67.09	63.88	HSK 25 R	4	HW	2,0	15	**182530** □	**182531** □
	SCM	67.55	63.88	HSK 25 R	4	HW	2.5	15	**182532** □	**182533** □
	SCM	68	63.88	HSK 25 R	4	HW	3,0	15	**182534** □	**182535** □
	Stefani	70	60	16 DKN	4	DP	1,0	6	**192524** ●	**192525** ●
	Stefani	70	60	16 DKN	4	DP	2,0	6	**192526** ●	**192527** ●
	Stefani	70	60	16 DKN	4	DP	3,0	6	**192528** ●	**192529** ●
	Stefani	51.5	49.71	16 DKN	4	HW	1,0	8	**192657** ●	**192658** ●
	Stefani	51.5	49.71	16 DKN	4	HW	1.5	8	**192659** ●	**192660** ●
	Stefani	51.5	49.71	16 DKN	4	HW	2,0	8	**192661** ●	**192662** ●
	Törk Makine	46	39	16	4	DP	2,0	3	**192643**	**192644**

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

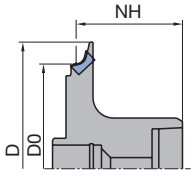




Radius cutter with cylindrical bore



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 adaptor for FK aggregates

Profile cutter with optimised chip collection

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

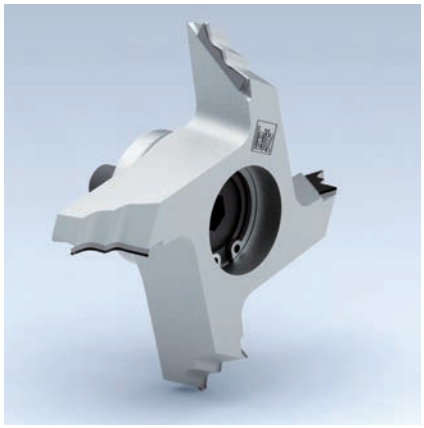
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

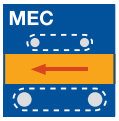
Technical information:
HW/DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity.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

Various radii - optimised chip collection
WF 210 2 DP, WF 501 2, WF 501 2 DP

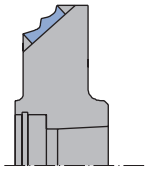
Machine	D mm	D_0 mm	NH mm	BO mm	Z	QAL	R mm	ID LH	ID RH
Homag	75	62	31.5	HSK 32	4	DP	1,0	**198212** ●	**198213** ●
Homag	75	62	31.5	HSK 32	4	DP	1.5	**198214** ●	**198215** ●
Homag	75	62	31.5	HSK 32	4	DP	2,0	**198216** ●	**198217** ●
Homag	75	62	31.5	HSK 32	4	DP	2.5	**198220** ●	**198221** ●
Homag	75	62	31.5	HSK 32	4	DP	3,0	**198222** ●	**198223** ●
Homag	75	62	31.5	HSK 32	6	DP	1,0	**198246** ●	**198247** ●
Homag	75	62	31.5	HSK 32	6	DP	1.5	**198244** ●	**198245** ●
Homag	75	62	31.5	HSK 32	6	DP	2,0	**198218** ●	**198219** ●
Homag	75	62	31.5	HSK 32	6	DP	2.5	**198238**	**198239**
Homag	75	62	31.5	HSK 32	6	DP	3,0	**198224** ●	**198225** ●
Homag, IMA	76	70	17.5	HSK 25 R	4	DP	1,0	**198494** ●	**198484** ●
Homag, IMA	76	70	17.5	HSK 25 R	4	DP	1.5	**198495** ●	**198485** ●
Homag, IMA	76	70	18.5	HSK 25 R	4	DP	2,0	**198496** ●	**198486** ●
Homag, IMA	76	70	17.5	HSK 25 R	6	DP	1,0	**198499** ●	**198489** ●
Homag, IMA	76	70	17.5	HSK 25 R	6	DP	1.5	**198500** ●	**198490** ●
Homag, IMA	76	70	18.5	HSK 25 R	6	DP	2,0	**198501** ●	**198491** ●
Homag, IMA	78	70	19	HSK 25 R	4	DP	2.5	**198497** ●	**198487** ●
Homag, IMA	78	70	19.5	HSK 25 R	4	DP	3,0	**198498** ●	**198488** ●
Homag, IMA	78	70	19	HSK 25 R	6	DP	2.5	**198502** ●	**198492** ●
Homag, IMA	78	70	19.5	HSK 25 R	6	DP	3,0	**198503** ●	**198493** ●
SCM	55.3	48	11.4	16 DKN	3	DP	1,0	**192699**	**192700**
SCM	55.3	48	11.4	16 DKN	3	HW	1,0	**182502** □	**182503** □
SCM	55.3	48	11.4	16 DKN	3	HW	1.5	**182504** □	**182505** □
SCM	55.3	48	11.4	16 DKN	3	DP	2,0	**192697** ●	**192698** ●
SCM	55.3	48	11.4	16 DKN	3	HW	2,0	**182506** □	**182507** □
SCM	55.3	48	11.4	16 DKN	3	HW	3,0	**182508** □	**182509** □
SCM	69.9	62.3	22	HSK 25 R	4	DP	1,0	**192709** □	**192710** □
SCM	69.9	62.3	22	HSK 25 R	4	DP	1.5	**192711** □	**192712** □
SCM	69.9	62.3	22	HSK 25 R	4	DP	2,0	**192713** □	**192714** □
SCM	69.9	62.3	22	HSK 25 R	4	DP	2.5	**192715** □	**192716** □
SCM	69.9	62.3	22	HSK 25 R	4	DP	3,0	**192717** □	**192718** □

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



DP HW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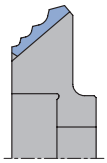
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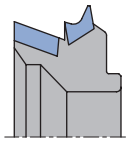
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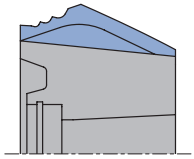
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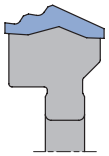
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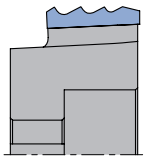
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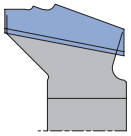
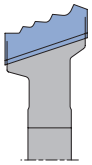

Type 7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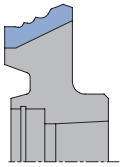

Type 9

Multi-profile cutter

Application:
For a choice of radii or bevels on edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

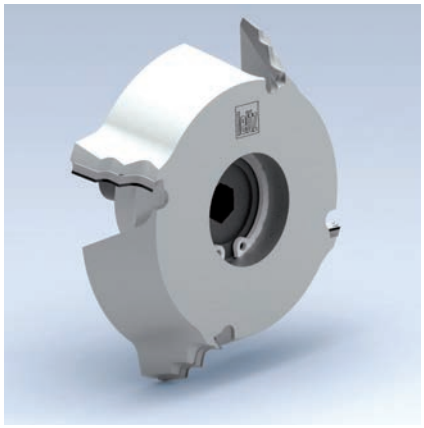
Technical information:
HW/DP tipped tools with cylindrical bore or HSK 25 R adaptor. Profiling with e.g. radii 2.0 and 3.0 mm and bevel 20°. D_0 = constant reference diameter.

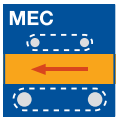
Multi-profile cutter
WF 210 2, WF 210 2 DP, WF 501 2, WF 501 2 DP, WF 501 2 DP , WF 502 2, WF 502 2 DP, WF 502 2 DP

Machine	D mm	D_0 mm	BO mm	Z	QAL	R mm	FAW °	Type	ID LH	ID RH
Biesse	75.4	60	16 DKN	6	DP	1/2/3	25	2	**091996** ●	**091995** ●
Brandt	78	57.3	16 DKN	4	DP	1,2/2/3	15	2	**091967**	**091968**
Holz-Her	58	50	20 DKN	2	DP	2		3	**192530** ●	**192531** ●
Holz-Her	58	50	20 DKN	2	DP	2.5		3	**192532** ●	**192533** ●
Holz-Her	58	50	20 DKN	2	DP	3		3	**192534** ●	**192535** ●
Holz-Her 1826	58	50	20 DKN	2	DP	2		3	**192530** ●	**192531** ●
Holz-Her 1826	58	50	20 DKN	2	DP	2.5		3	**192532** ●	**192533** ●
Holz-Her 1826	58	50	20 DKN	2	DP	3		3	**192534** ●	**192535** ●
Holz-Her FR 701	71	68	16 DKN	4	DP	3/2/1,3	45	6	**192673** ●	**192674** ●
Holz-Her FR 701	71	68	16 DKN	4	DP	1,3/1/0,8	45	6	**192681** ●	**192682** ●
Holz-Her FR 701	71	68	16 DKN	4	DP	3/2/1,3	10	6	**192679** ●	**192680** ●
Holz-Her FR 701	71	68	16 DKN	4	DP	2/1,3/1,3	45	6	**192677** ●	**192678** ●
Holz-Her FR 701	71	68	16 DKN	4	DP	2/2/1,3	45	6	**192675** ●	**192676** ●
Homag	74.33	65.7	HSK 25 R	4	DP	1/2		4	**198506** ●	**198507** ●
Homag	74.67	65.7	HSK 25 R	4	DP	1,3/2		4	**198508** ●	**198509** ●
Homag	85	65.2	HSK 25 R	4	DP	2/3	20	1	**091798**	**091799**
Homag	74.33	62.99	16 DKN	4	DP	1/2		5	**192683** ●	**192684** ●
Homag	74.66	65.69	16 DKN	4	DP	1,3/2		5	**192685** ●	**192686** ●
Homag	78	57.3	16 DKN	4	DP	1,2/2/3	15	2	**091967**	**091968**
IMA	85	65.2	HSK 25 R	4	DP	2/3	20	1	**091798**	**091799**
SCM	74.5	63.9	HSK 25 R	4	HW	1/1,5/2		9	**182538** □	**182539** □
SCM	74.5	63.9	HSK 25 R	4	HW	1/1,5/3		9	**182540** □	**182541** □
SCM	74.5	63.9	HSK 25 R	4	HW	1/2/3		9	**182542** □	**182543** □
SCM	75.7	63.9	HSK 25 R	4	HW	1,5/2/3		9	**182544** □	**182545** □
SCM	75.7	63.9	HSK 25 R	4	HW	1/1,5/2,5		9	**182558** □	**182559** □
SCM	75.7	63.9	HSK 25 R	4	HW	2/2,5/3		9	**182560** □	**182561** □
SCM	62.03	49.44	16 DKN	4	HW	1/1,5		7	**182522** □	**182523** □
SCM	62.47	50.12	16 DKN	4	HW	1/2		7	**182520** □	**182521** □
SCM	73	60	16 DKN	4	HW	2/3		8	**182501**	**182500**
SCM	73	60	16 DKN	4	DP	2/3		8	**192696**	**192695**
SCM	77.4	63.1	16 DKN	4	HW	1/1,5/2		8	**182524** □	**182525** □
Stefani	74.5	63.88	HSK 25 R	4	DP	1/1,5/2	20	1	**192653** ●	**192654** ●
Stefani	74.5	63.88	HSK 25 R	4	DP	1/1,5/2	20	4	**192655** ●	**192656** ●

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





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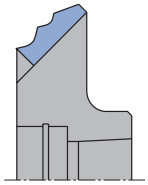
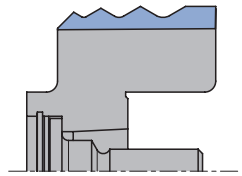


Type 1



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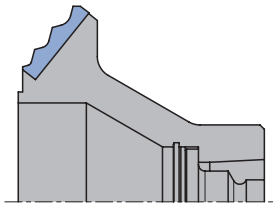


Type 3

Multi-profile cutter with optimised chip collection

Application:
For a choice of radii or bevels on edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

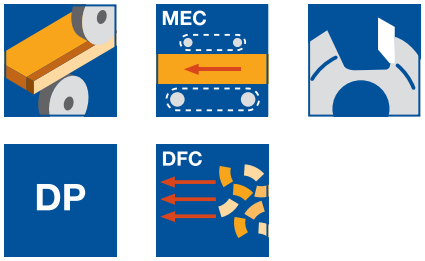
Technical information:
DP tipped tools designed for systems for controlled chip collection (i-System, ED-System) for highly efficient chip collection (approx. 97%) with reduced energy consumption for extraction. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity.

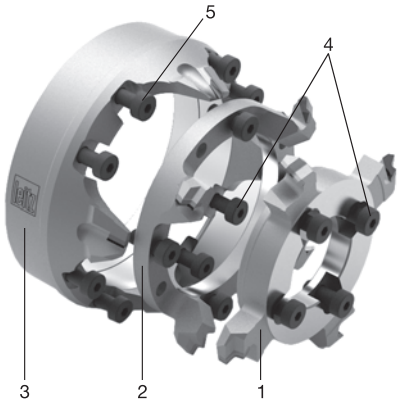
Multi-profile cutter - optimised chip collection
WF 501 2 DP, WF 502 2 DP

Machine	D mm	D_0 mm	B mm	BO mm	Z	QAL	R mm	FAW °	Type	ID LH	ID RH
Homag, IMA	85	62		HSK 25 R	4	DP	2/3	20	1	**198444** ●	**198445** ●
Homag, IMA	85	62		HSK 25 R	4	DP	1,5/2	20	1	**198504** ●	**198505** ●
Homag, IMA	85	62		HSK 25 R	6	DP	2/3	20	1	**198456** ●	**198457** ●
IMA Multiprofiler	75		30	HSK 25 R	6	DP	1/2/3	15	2	**091916** ●	**091917** ●
IMA Multiprofiler	75		30	HSK 25 R	6	DP	1/1,5/2	20	2	**091922** ●	**091923** ●
IMA Multiprofiler KFA	75		28	HSK 25 R	6	DP	1/2/3	15	2	**091912** ●	**091913** ●
IMA Multiprofiler KFA	75		28	HSK 25 R	6	DP	1/1,5/2	20	2	**091924** ●	**091925** ●
IMA Multiprofiler KFA	75		28	HSK 25 R	6	DP	1/2/3	45	2	**091926** ●	**091927** ●
IMA MFA	89	62		HSK 25 R	6	DP	1/2	15	3	**091918** ●	**091919** ●
IMA MFA	89	57		HSK 25 R	6	DP	1/2/3	15	3	**091920** ●	**091921** ●

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

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





Multi-profile cutter with optimised chip collection

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

Machine:
Homag edgebanding machines with profile FK31 trimming aggregate.

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

Technical information:
Three profiles in one tool. DFC design for highly efficient chip clearance of more than 97%. D_0 = constant reference diameter. Low noise DP tool. Maximum concentricity. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.

Diamaster PRO, FK31 aggregate
WF 300 2 DP, WF 501 2 DP

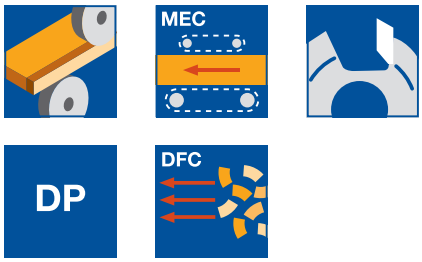
Machine	Tool no.	D mm	D_0 mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID RH
Homag	1	88	80.1	46	4	DP	1.5		**192558** ●	**192559** ●
Homag	1	88	80.1	46	4	DP	2,0		**192556** ●	**192557** ●
Homag	1	88	80.1	46	4	DP	2.2		**192580** ●	**192581** ●
Homag	1	88	80.1	46	4	DP	2.5		**192554** ●	**192555** ●
Homag	1	88	80.1	46	4	DP	3,0		**192552** ●	**192553** ●
Homag	2	87	80.1	55	4	DP	1,0		**192568** ●	**192569** ●
Homag	2	87	80.1	55	4	DP	1.5		**192566** ●	**192567** ●
Homag	2	87	80.1	55	4	DP	1.7		**192582**	**192583**
Homag	2	87	80.1	55	4	DP	2,0		**192564** ●	**192565** ●
Homag	2	87	80.1	55	4	DP	2.5		**192562** ●	**192563** ●
Homag	2	87	80.1	55	4	DP	3,0		**192560** ●	**192561** ●
Homag	2	87	80.1	55	4	DP		45	**192112** ●	**192113** ●
Homag	2	87	80.1	55	4	DP		30	**192123**	**192124**
Homag	2	87	80.1	55	4	DP		20	**192114**	**192115**
Homag	3	92	80.1	73	4	DP	1,0		**192574** ●	**192575** ●
Homag	3	92	80.1	73	4	DP	1.5		**192572** ●	**192573** ●
Homag	3	92	80.1	73	4	DP	1.7		**192584** ●	**192585** ●
Homag	3	92	80.1	73	4	DP	2,0		**192570** ●	**192571** ●
Homag	3	92	80.1	73	4	DP		15	**091520**	**091521**
Homag	3	92	80.1	73	4	DP		20	**192118** ●	**192119** ●
Homag	3	92	80.1	73	4	DP		30	**192125**	**192126**
Homag	3	92	80.1	73	4	DP		45	**192116** ●	**192117** ●

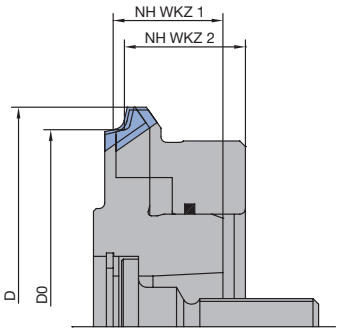
Differing radii available at short notice from a tool bank. Tool 1 radius must be greater than tool 2 and 3. The larger radius defines the maximal bevel size of the moveable bevel tools 2 and 3.

Spare parts:

Part-no.	BEZ	ABM mm	ID
4	Cylindrical screw with ISK	M5x12	**114046** ●
5	Cylindrical screw with ISK	M5x30	**114045** ●
	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 with cutting unit type FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

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

Technical information:
Two profiles in one tool. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, RPM n_{max} = 18000 min^{-1}. It is recommended to have individual tools changed by the Leitz tool service.

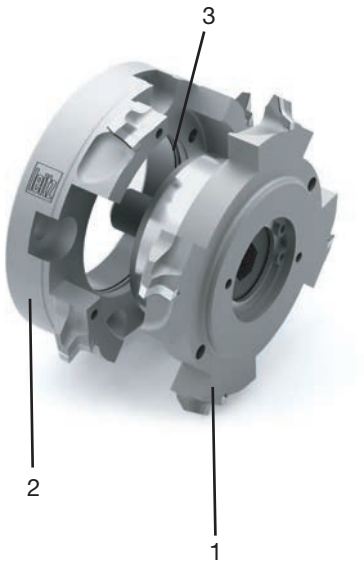
Multi-profile cutterset flexTrim - Diamaster PRO
SF 542 2 15

Machine	D mm	D_0 mm	NH mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID 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.

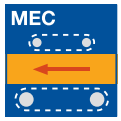
Spare parts:

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



1 = Werkzeug 1
2 = Werkzeug 2
3 = O-Ring

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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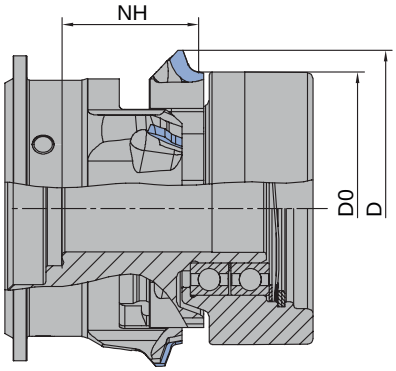


Profile cutter flexTrim

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

Machine:
Homag edgebanding machines with cutting unit type FF6210.

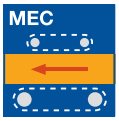
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

Technical information:
Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, RPM n_{max} = 12000 min^{-1}.

Multi-profile cutterset flexTrim - Diamaster PRO, aggregate FF6210
SF 542 2 18, WF 501 2 18

Machine	D mm	D_0 mm	NH mm	BO mm	Z	QAL	R mm	FAW °	ID RH
Homag	58	50	25	16	3	DP	3,0/1,0		**194700** □
Homag	58	50	25	16	3	DP	3,0/1,3		**194701** □
Homag	58	50	25	16	3	DP	3,0/2,0		**194702** □
Homag	58	50	25	16	3	DP	2,0/1,0		**194703** ●
Homag	58	50	25	16	3	DP	2,0/1,3		**194704** ●
Homag	58	50	25	16	3	DP	2,0/1,5		**194705** □
Homag	58	50	25	16	3	DP	2,0	45	**194706** □
Homag	58	50	25	16	3	DP	1,5/1,5		**194707** □
Homag	58	50	25	16	3	DP	3,0		**194724** □
Homag	58	50	25	16	3	DP	2,0		**194725** ●
Homag	58	50	25	16	3	DP	1.5		**194726** ●
Homag	58	50	25	16	3	DP	1.3		**194727** □
Homag	58	50	25	16	3	DP	1,0		**194728** □
Homag	58	50	25	16	3	DP		45	**194729** □
Homag	58	50	25	16	3	DP		30	**194730** □
Homag	58	50	25	16	3	DP		15	**194731** □

Further profile variants and combinations possible on request.



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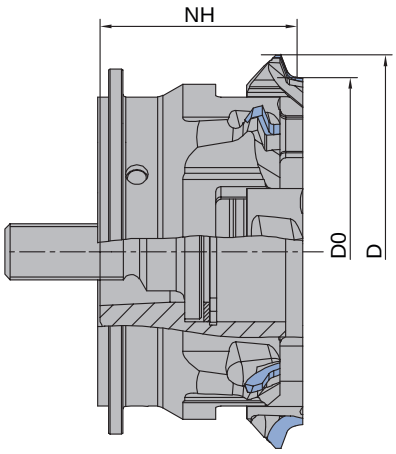


Profile cutter flexTrim

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

Machine:
Homag edgebanding machines with cutting unit type MF50, MF60.

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

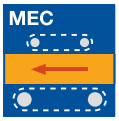
Technical information:
Two profiles in one tool. Alternatively with only one profile. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, RPM n_{max} = 12000 min^{-1}.

Multi-profile cutterset flexTrim - Diamaster PRO, aggregate MF50, MF60
SF 542 2 18, WF 501 2 18

Machine	D mm	D_0 mm	NH mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID RH
Homag	70	62	35	HSK 25 R	4	DP	3,0/1,0		**194708** □	**194709** □
Homag	70	62	35	HSK 25 R	4	DP	3,0/1,3		**194710** □	**194711** □
Homag	70	62	35	HSK 25 R	4	DP	3,0/2,0		**194712** □	**194713** □
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,0		**194714** ●	**194715** ●
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,3		**194716** ●	**194717** ●
Homag	70	62	35	HSK 25 R	4	DP	2,0/1,5		**194718** □	**194719** □
Homag	70	62	35	HSK 25 R	4	DP	2,0	45	**194720** □	**194721** □
Homag	70	62	35	HSK 25 R	4	DP	1,5/1,5		**194722** □	**194723** □
Homag	70	62	35	HSK 25 R	4	DP	1,3/1,0		**194732** □	**194733** □
Homag	70	62	35	HSK 25 R	4	DP	3,0		**194740** □	**194741** □
Homag	70	62	35	HSK 25 R	4	DP	2,0		**194742** □	**194743** □
Homag	70	62	35	HSK 25 R	4	DP	1.5		**194744** □	**194745** □
Homag	70	62	35	HSK 25 R	4	DP	1.3		**194746** □	**194747** □
Homag	70	62	35	HSK 25 R	4	DP	1,0		**194748** □	**194749** □
Homag	70	62	35	HSK 25 R	4	DP		45	**194750** □	**194751** □
Homag	70	62	35	HSK 25 R	4	DP		30	**194752** □	**194753** □
Homag	70	62	35	HSK 25 R	4	DP		15	**194754** □	**194755** □

Further profile variants and combinations possible on request.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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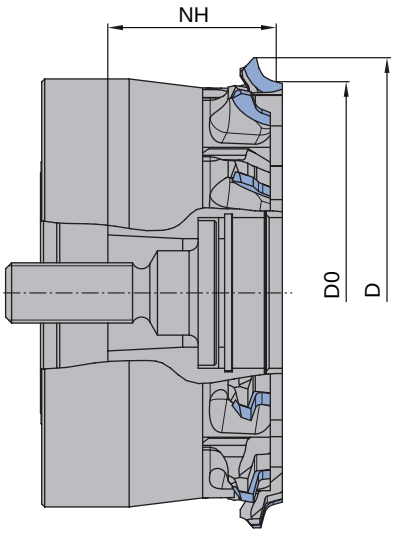


Profile cutter flexTrim3

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

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

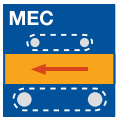
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

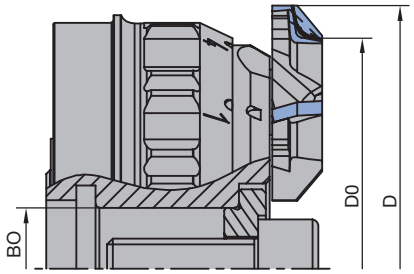
Technical information:
Three profiles in one tool. Maximum processing quality through high running accuracy and quiet running. D_0 = constant reference diameter, RPM n_{max} = 12.000 min^{-1}. Replacement of tool components only by qualified personnel of the tool or machine manufacturer.

Multi-profile cutterset flexTrim3 - Diamaster PRO
SF 541 2 17

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

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





Profile cutter Quattro^{Form}

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

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

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

Technical information:
DP composite tool with four profiles and mounting screw. Profiles automatically adjustable by the machine control. Patented system. D_0 = constant reference diameter, RPM n = 18000 min^{-1}. It is recommended to have individual tools changed by the Leitz tool service.

Multi-profile cutter Quattro^{Form} - Diamaster PRO
SF 540 2 10

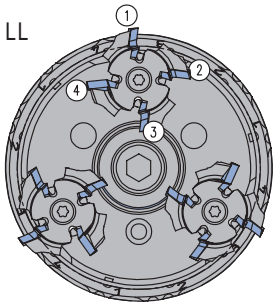
Machine	D mm	D_0 mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/2	45	**193901** ●	**193900** ●
Holz-Her FF 701 Multi	70	61	16	3	3/1,3/2	45	**193903** ●	**193902** ●
Holz-Her FF 701 Multi	70	61	16	3	3/1,3/2	10	**193905** ●	**193904** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/1,3	45	**193907** ●	**193906** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,5/1	45	**193909** ●	**193908** ●
Holz-Her FF 701 Multi	70	61	16	3	0,8/1/1,3	45	**193911** ●	**193910** ●
Holz-Her FF 701 Multi	70	61	16	3	3/2/2	45	**193913** ●	**193912** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,3	45	**193915** ●	**193914** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/2/1,3		**193917** ●	**193916** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1/2	45	**193919** ●	**193918** ●
Holz-Her FF 701 Multi	70	61	16	3	2/1,3/1,3/1,3		**193921** ●	**193920** ●
Holz-Her FF 701 Multi	70	61	16	3	2/3/2/3		**193923** ●	**193922** ●

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

Spare parts:

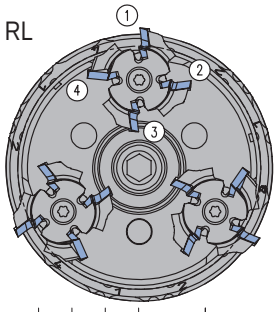
BEZ	ID
Maintenance set Quattro Form	**008383** ●

LL



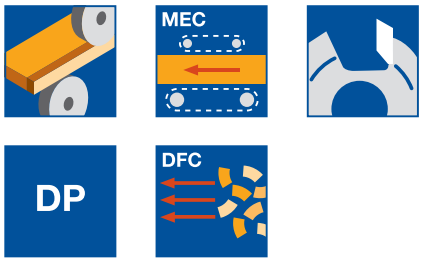
①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	193901	5073457
R3	R1.3	R2	F45°	193903	5073459
R3	R1.3	R2	F10°	193905	5073462
R2	R1.3	R1.3	F45°	193907	5073465
R2	R1.5	R1	F45°	193909	5073467
R0.8	R1	R1.3	F45°	193911	5073469
R3	R2	R2	F45°	193913	5073471
R2	R1.3	F45°	F45°	193915	5073474
R2	R1.3	R2	R1.3	193917	5073447
R2	R1	R2	F45°	193919	5073450
R2	R1.3	R1.3	R1.3	193921	5073454
R2	R3	R2	R3	193923	5073452

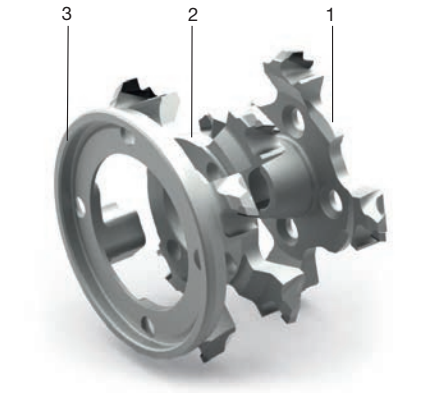
RL



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	193900	5073458
R3	R1.3	R2	F45°	193902	5073461
R3	R1.3	R2	F10°	193904	5073463
R2	R1.3	R1.3	F45°	193906	5073466
R2	R1.5	R1	F45°	193908	5073468
R0.8	R1	R1.3	F45°	193910	5073470
R3	R2	R2	F45°	193912	5073473
R2	R1.3	F45°	F45°	193914	5073475
R2	R1.3	R2	R1.3	193916	5073449
R2	R1	R2	F45°	193918	5073451
R2	R1.3	R1.3	R1.3	193920	5073456
R2	R3	R2	R3	193922	5073453

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





1 = tool 1
2 = tool 2
3 = tool 3

Profile cutter Multi-Edge

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

Machine:
Stefani.

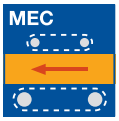
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

Technical information:
Three profiles in one tool. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running. D_0 = constant reference diameter, RPM n_{max} = 18000 min^{-1}. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.

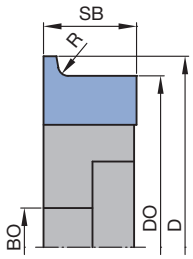
Diamaster PRO
WF 501 2 16

Machine	Tool no.	D mm	D_0 mm	BO mm	Z	QAL	R mm	ID LH	ID RH
Stefani	1	68	61.7	10 DKN	4	DP	1,0	**192606** ●	**192605** ●
Stefani	1	68	61.7	10 DKN	4	DP	1.3	**192608** ●	**192607** ●
Stefani	1	68	61.7	10 DKN	4	DP	1.5	**192610** ●	**192609** ●
Stefani	1	68	61.7	10 DKN	4	DP	2,0	**192612** ●	**192611** ●
Stefani	1	68	61.7	10 DKN	4	DP	2.5	**192614** ●	**192613** ●
Stefani	1	68	61.7	10 DKN	4	DP	3,0	**192616** ●	**192615** ●
Stefani	2	68	61.7	23	4	DP	1,0	**192618** ●	**192617** ●
Stefani	2	68	61.7	23	4	DP	1.3	**192620** ●	**192619** ●
Stefani	2	68	61.7	23	4	DP	1.5	**192622** ●	**192621** ●
Stefani	2	68	61.7	23	4	DP	2,0	**192624** ●	**192623** ●
Stefani	2	68	61.7	23	4	DP	2.5	**192626** ●	**192625** ●
Stefani	2	68	61.7	23	4	DP	3,0	**192628** ●	**192627** ●
Stefani	3	68	61.7	38	4	DP	1,0	**192672** ●	**192671** ●
Stefani	3	68	61.7	38	4	DP	1.3	**192632** ●	**192631** ●
Stefani	3	68	61.7	38	4	DP	1.5	**192634** ●	**192633** ●
Stefani	3	68	61.7	38	4	DP	2,0	**192636** ●	**192635** ●
Stefani	3	68	61.7	38	4	DP	2.5	**192638** ●	**192637** ●
Stefani	3	68	61.7	38	4	DP	3,0	**192640** ●	**192639** ●

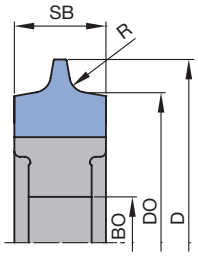
Further profile variants in various dimensions available on request at short notice.

HW



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. The same cutterhead tool body for R 1.5 to 3.0 mm. D_0 = constant reference diameter.

Various radii - Brandt, Homag
WE 500 2

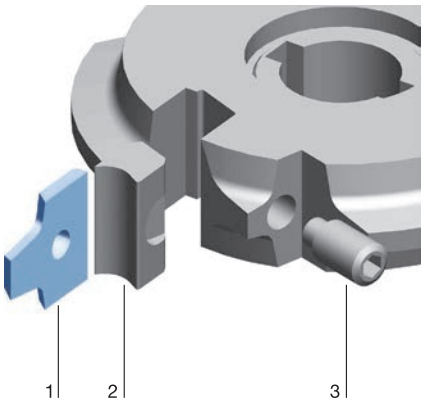
Machine	D mm	D_0 mm	SB mm	BO mm	Z	R mm	Type	ID LH	ID RH
Brandt, Homag	56	50	16	16 DKN	4	2	1	**075006**	**075005**
Brandt, Homag	58	50	12	16 DKN	4	3	2	**075004**	**075004**
Brandt, Homag	78	70	19	16 DKN	4	3	1	**075003**	**075002**
Brandt, Homag	82	70	16	16 DKN	4	2	2	**075009**	**075009**

Spare knives:

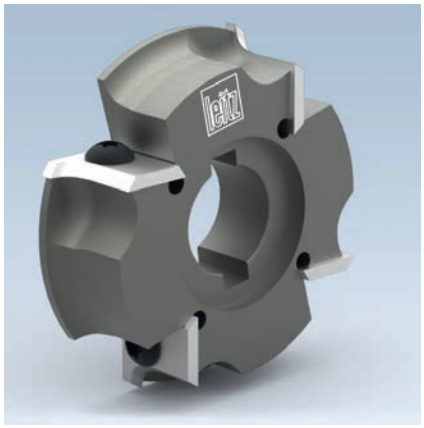
Part-no.	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x13,4x2	HW	1.5	10	**075325** ●	**075324** ●
1	Exchange knife	16x13,4x2	HW	2,0	10	**075327** ●	**075326** ●
1	Exchange knife	16x13,4x2	HW	3,0	10	**075329** ●	**075328** ●
1	Exchange knife	19,6x15,2x2	HW	1.5	10	**075334** ●	**075333** ●
1	Exchange knife	19,6x15,2x2	HW	2,0	10	**075336** ●	**075335** ●
1	Exchange knife	19,6x15,2x2	HW	2.5	10	**075338** ●	**075337** ●
1	Exchange knife	19,6x15,2x2	HW	3,0	10	**075303** ●	**075302** ●
1	Exchange knife	12x13x2	HW	1.5	10	**075339** ●	**075339** ●
1	Exchange knife	12x13x2	HW	2,0	10	**075330** ●	**075330** ●
1	Exchange knife	12x13x2	HW	3,0	10	**075304** ●	**075304** ●
1	Exchange knife	16x17,5x2	HW	1.5	10	**009539** ●	**009539** ●
1	Exchange knife	16x17,5x2	HW	2,0	10	**005132** ●	**005132** ●
1	Exchange knife	16x17,5x2	HW	3,0	10	**005133** ●	**005133** ●

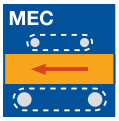
Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge	10x11,5x7	**075400** ●
2	Clamping wedge	10x10,9x7	**075403** ●
2	Clamping wedge	13,5x11x7	**075404** ●
2	Clamping wedge	19	**075401** ●
2	Clamping wedge	19	**075402**
3	Allen screw	M6x12	**006035**
	Allen key	SW 3	**005444** ●
	Setting gauge for knives	43x12x6	**005350** ●

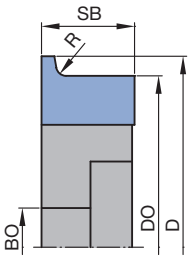


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





HW



Profile cutterhead / bevel cutterhead

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

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

Various radii - Hebrock/EBM
WE 500 2

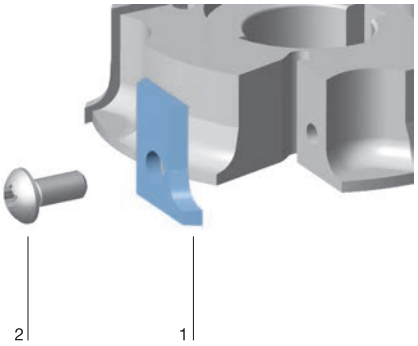
Machine	D mm	D_0 mm	SB mm	BO mm	Z	R mm	ID LH	ID RH
Hebrock, EBM	56	49.7	14.5	16 DKN	4	2,0	**074559**	**074560**
Hebrock, EBM	56	49.7	14.5	16 DKN	4	2.5	**074557**	**074558**

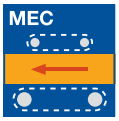
Spare knives:

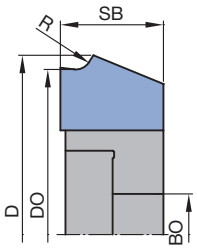
Part-no.	Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	1	Combi exchange knife	14.5x14.5x2	HW	2,0	10	**074632** ●	**074633** ●
1	1	Combi exchange knife	14.5x14.5x2	HW	2.5	10	**074630** ●	**074631** ●

Spare parts:

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







Profile cutterhead / bevel cutterhead

Application:
To round and bevel edgebandings.

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

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

Technical information:
Cutterheads with HW knives and cylindrical bore with DKN. $D_{0=}$ constant reference diameter. DFC design for highly efficient chip clearance of more than 97%.

Various profiles - DFC, Brandt, Homag
WE 500 2

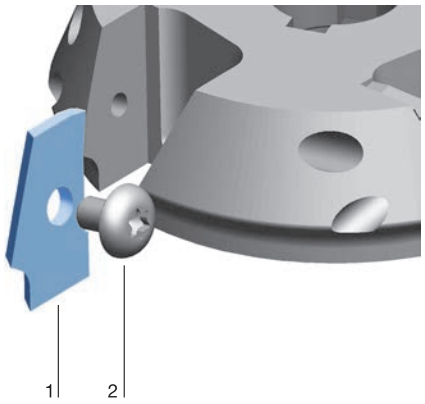
Machine	D mm	SB mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Brandt, Homag	70.23	20.28	16 DKN	4		15	**075012** □	**075013** □
Brandt, Homag	70.23	20.28	16 DKN	4		30	**075014** □	**075015** □
Brandt, Homag	69.98	20.28	16 DKN	4		45	**075016** □	**075017** □
Brandt, Homag	70.57	20.28	16 DKN	4	1,0		**075018** □	**075019** □
Brandt, Homag	70.57	20.28	16 DKN	4	1.2		**075020** □	**075021** □
Brandt, Homag	70.57	20.28	16 DKN	4	1.3		**075072** □	**075073** □
Brandt, Homag	70.57	20.28	16 DKN	4	1.5		**075022** □	**075023** □
Brandt, Homag	70.57	20.28	16 DKN	4	2,0		**075024** ●	**075025** ●
Brandt, Homag	70.57	20.28	16 DKN	4	2.5		**075026** □	**075027** □
Brandt, Homag	70.57	20.28	16 DKN	4	3,0		**075028** ●	**075029** ●

Spare knives:

Part-no.	Type	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	1	Exchange knife	22,3x14x2	HW	1,0		10	**075315** ●	**075314** ●
1	1	Exchange knife	22,3x14x2	HW	1.2		10	**075317** □	**075316** □
1	1	Exchange knife	22.3x14x2	HW	1.3		10	**075272** ●	**075271** ●
1	1	Exchange knife	22,3x14x2	HW	1.5		10	**075319** ●	**075318** ●
1	1	Exchange knife	22,3x14x2	HW	2,0		10	**075307** ●	**075306** ●
1	1	Exchange knife	22,3x14x2	HW	2.5		10	**075321** □	**075320** □
1	1	Exchange knife	22,3x14x2	HW	3,0		10	**075309** ●	**075308** ●
1	1	Exchange knife	22,3x14x2	HW		15	10	**075311** ●	**075310** ●
1	1	Exchange knife	22,3x14x2	HW		30	10	**075331** □	**075332** □
1	1	Exchange knife	22,3x14x2	HW		45	10	**075313** ●	**075312** ●

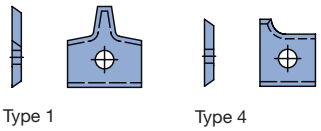
Spare parts:

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

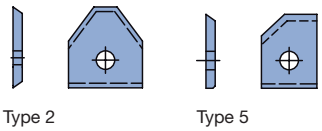


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

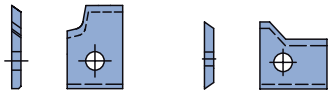
Profile cutterhead / bevel cutterhead



Type 1 Type 4



Type 2 Type 5

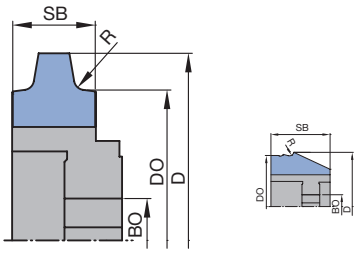


Type 3 Type 6

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** □

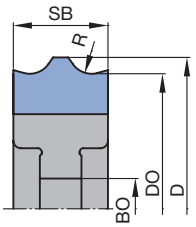


Type 1 Type 2

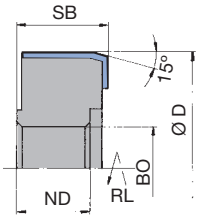
Profile knives for system Biesse

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** □



Type 3



Type 4: WW 500 2 03

Profile knives for system Holz-Her

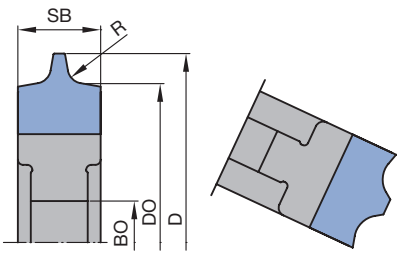
TM 435 0

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

Profile knives for system Ott

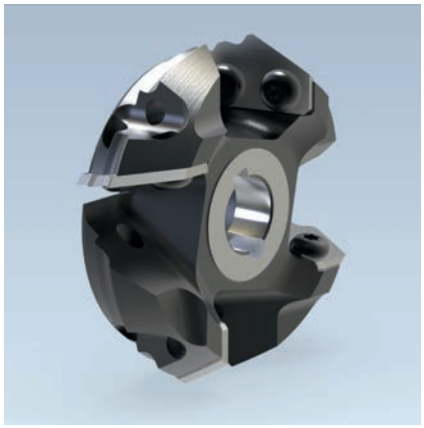
TM 135 0

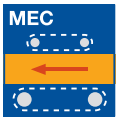
Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x16,5x2	HW	1,0	10	**074540** □	**074540** □
2	Exchange knife	16x17,5x2	HW	1.5	10	**009539** ●	**009539** ●
1	Exchange knife	16x17,5x2	HW	2,0	10	**005132** ●	**005132** ●
1	Exchange knife	16x18,5x2	HW	2.5	10	**074543** □	**074543** □
2	Exchange 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** □

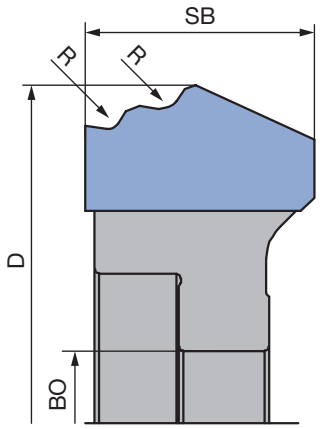


Type 1 Type 2

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



Multi-profile cutterhead / bevel cutterhead

Application:
For a choice of radii or bevels on edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

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

Various profiles - DFC, Homag
WE 500 2

Machine	D mm	SB mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Homag	74.67	25.28	16 DKN	4	1/2		**075092** ●	**075093** ●
Homag	74.67	25.28	16 DKN	4	1,3/2		**075100** ●	**075101** ●
Homag	74.67	25.28	16 DKN	4	1/3		**075094** ●	**075095** ●
Homag	74.67	25.28	16 DKN	4	2/3		**075112** □	**075113** □
Homag	74.67	25.28	16 DKN	4	1/1,5		**075090** ●	**075091** ●
Homag	74.67	25.28	16 DKN	4	1,5/2		**075106** □	**075107** □
Homag	74.67	25.28	16 DKN	4	1,5/3		**075108** □	**075109** □
Homag	74.67	25.28	16 DKN	4	1	15	**075114** □	**075115** □
Homag	74.67	25.28	16 DKN	4	1,3/3		**075102** ●	**075103** ●
Homag	74.67	25.28	16 DKN	4	2	30	**075130** □	**075131** □
Homag	74.67	25.28	16 DKN	4	2	15	**075120** □	**075121** □
Homag	74.67	25.28	16 DKN	4	1/1,3		**075088** □	**075089** □
Homag	74.67	25.28	16 DKN	4	2	45	**075140** □	**075141** □
Homag	74.67	25.28	16 DKN	4	1	45	**075134** □	**075135** □
Homag	74.67	25.28	16 DKN	4	1.3	45	**075136** □	**075137** □
Homag	74.67	25.28	16 DKN	4	1.5	45	**075138** □	**075139** □
Homag	74.67	25.28	16 DKN	4	1.5	30	**075128** □	**075129** □
Homag	74.67	25.28	16 DKN	4	2/2		**075110** □	**075111** □
Homag	74.67	25.28	16 DKN	4	1,3/1,3		**075096** □	**075097** □
Homag	74.67	25.28	16 DKN	4	1,5/1,5		**075104** □	**075105** □
Homag	74.67	25.28	16 DKN	4	1	30	**075124** □	**075125** □
Homag	74.67	25.28	16 DKN	4	1,3/1,5		**075098** □	**075099** □
Homag	74.67	25.28	16 DKN	4	1.3	30	**075126** □	**075127** □
Homag	74.67	25.28	16 DKN	4	3	30	**075132** □	**075133** □
Homag	74.67	25.28	16 DKN	4	3	45	**075142** □	**075143** □
Homag	74.67	25.28	16 DKN	4	1/1		**075086** □	**075087** □

Further radii combinations available at short notice.

Spare knives:

Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	25.67x16.5x2	HW	1/2		10	**075706** ●	**075707** ●
1	Exchange knife	25.67x16.5x2	HW	1,3/2		10	**075714** ●	**075715** ●
1	Exchange knife	25.67x16.5x2	HW	1/3		10	**075708** ●	**075709** ●
1	Exchange knife	25.67x16.5x2	HW	2/3		10	**075726** □	**075727** □
1	Exchange knife	25.67x16.5x2	HW	1/1,5		10	**075704** ●	**075705** ●
1	Exchange knife	25.67x16.5x2	HW	1,5/2		10	**075720** □	**075721** □
1	Exchange knife	25.67x16.5x2	HW	1,5/3		10	**075722** □	**075723** □
1	Exchange knife	25.67x16.5x2	HW	1	15	10	**075728** □	**075729** □
1	Exchange knife	25.67x16.5x2	HW	1,3/3		10	**075716** ●	**075717** ●
1	Exchange knife	25.67x16.5x2	HW	2	30	10	**075744** □	**075745** □
1	Exchange knife	25.67x16.5x2	HW	2	15	10	**075734** □	**075735** □
1	Exchange knife	25.67x16.5x2	HW	1/1,3		10	**075702** □	**075703** □
1	Exchange knife	25.67x16.5x2	HW	2	45	10	**075754** □	**075755** □
1	Exchange knife	25.67x16.5x2	HW	1	45	10	**075748** □	**075749** □
1	Exchange knife	25.67x16.5x2	HW	1.3	45	10	**075750** □	**075751** □
1	Exchange knife	25.67x16.5x2	HW	1.5	45	10	**075752** □	**075753** □
1	Exchange knife	25.67x16.5x2	HW	1.5	30	10	**075742** □	**075743** □
1	Exchange knife	25.67x16.5x2	HW	2/2		10	**075724** □	**075725** □

● available ex stock
□ available at short notice
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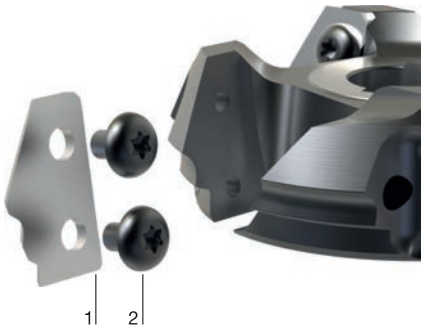
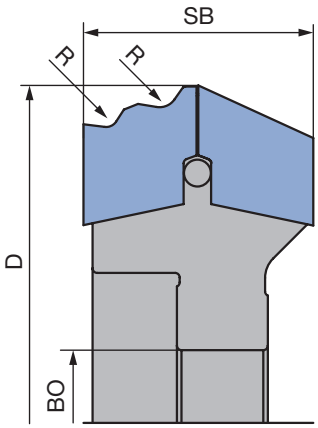
Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	25.67x16.5x2	HW	1,3/1,3		10	**075710** □	**075711** □
1	Exchange knife	25.67x16.5x2	HW	1,5/1,5		10	**075718** □	**075719** □
1	Exchange knife	25.67x16.5x2	HW	1	30	10	**075738** □	**075739** □
1	Exchange knife	25.67x16.5x2	HW	1,3/1,5		10	**075712** □	**075713** □
1	Exchange knife	25.67x16.5x2	HW	1.3	30	10	**075740** □	**075741** □
1	Exchange knife	25.67x16.5x2	HW	3	30	10	**075746** □	**075747** □
1	Exchange knife	25.67x16.5x2	HW	3	45	10	**075756** □	**075757** □
1	Exchange knife	25.67x16.5x2	HW	1/1		10	**075700** □	**075701** □

Further radii combinations available at short notice.

Spare parts:

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



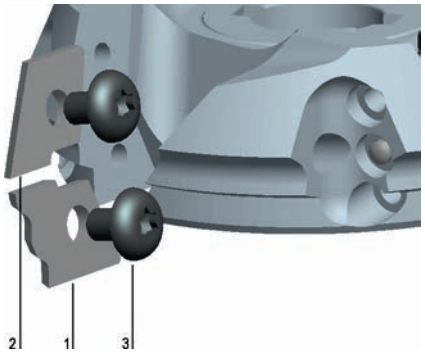


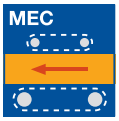
Spare knives - two-part knife design (until 03/2023)
TM 135 0

Type	BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID LH	ID RH
1	Exchange knife	17,9x14,2x2	HW	1/1,5		10	**075365** □	**075366** □
1	Exchange knife	17,9x14,2x2	HW	1/2		10	**075347** ●	**075348** ●
1	Exchange knife	17,9x14,2x2	HW	1/3		10	**075351** ●	**075352** ●
1	Exchange knife	17,9x14,2x2	HW	1,3/2		10	**075349** ●	**075350** ●
1	Exchange knife	17,9x14,2x2	HW	1,3/3		10	**075373** ●	**075374** ●
1	Exchange knife	17,9x14,2x2	HW	1,5/2		10	**075367** ●	**075368** ●
1	Exchange knife	17,9x14,2x2	HW	1,5/3		10	**075369** ●	**075370** ●
1	Exchange knife	17,9x14,2x2	HW	2/3		10	**075353** ●	**075354** ●
1	Exchange knife	17,9x14,2x2	HW	1	15	10	**075371**	**075372**
1	Exchange knife	17,9x14,2x2	HW	2	30	10	**075201** ●	**075202** ●
2	Exchange knife	18,1x13,5x2	HW			10	**075355** ●	**075356** ●

Spare parts:

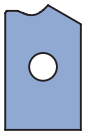
Part-no.	BEZ	ABM mm	ID
3	Oval head screw Torx® 15	M4x6	**006225** ●
	Torx® key	Torx® 15	**005466** ●





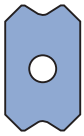
HW

Type 1



Type 2

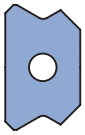
Type 3



Type 4

Type 5

Type 6



Type 7

Type 8

Profile scrapers

Application:
For scraping edgebandings with radii or bevels.

Machine:
Single or double-sided edgebanding machines.

Workpiece material:
Plastic edgebandings.

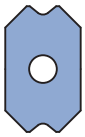
Technical information:
Bevel and radius scraper for scraper holder.

Profile scrapers
TM 130 0, TM 435 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	12.7	12.7	3.18		25	1	HW	10	**074552** ●	
Biesse	12.7	12.7	3.18	1,0		1	HW	10	**074548** ●	
Biesse	12.7	12.7	3.18	1.5		1	HW	10	**074549** ●	
Biesse	12.7	12.7	3.18	2,0		1	HW	10	**074550** ●	
Biesse	12.7	12.7	3.18	3,0		1	HW	10	**074551** ●	
Fravol	12	20	2	1-3		2	TDC	10	**074640** ●	**074639** ●
Holz-Her	12	20	2		45	4	HW	10	**074037** ●	
Holz-Her	12	20	2	1,0		4	HW	10	**074039** ●	
Holz-Her	12	20	2	1.5		4	HW	10	**074074** ●	
Holz-Her	12	20	2	2,0		4	HW	10	**074040** ●	
Holz-Her	12	20	2	2.5		4	HW	10	**074075** ●	
Holz-Her	12	20	2	3,0		4	HW	10	**074041** ●	
Holz-Her ZK701	12	19	2		10	3	HW	10	**074576** ●	**074575** ●
Holz-Her ZK701	12	19	2		45	3	HW	10	**074574**	**074573**
Holz-Her ZK701	12	19	2	1,0		3	HW	10	**074562** ●	**074561** ●
Holz-Her ZK701	12	19	2	1.3		3	HW	10	**074564** ●	**074563** ●
Holz-Her ZK701	12	19	2	1.5		3	HW	10	**074566** ●	**074565** ●
Holz-Her ZK701	12	19	2	2,0		3	HW	10	**074568** ●	**074567** ●
Holz-Her ZK701	12	19	2	2.5		3	HW	10	**074570**	**074569**
Holz-Her ZK701	12	19	2	3,0		3	HW	10	**074572** ●	**074571** ●
Homag	12	20	2		45	4	HW	10	**074037** ●	
Homag	12	20	2	1,0		4	HW	10	**074039** ●	
Homag	12	20	2	1.5		4	HW	10	**074074** ●	
Homag	12	20	2	2,0		4	HW	10	**074040** ●	
Homag	12	20	2	2.5		4	HW	10	**074075** ●	
Homag	12	20	2	3,0		4	HW	10	**074041** ●	
Homag	12	20	2		45	5	HW	10	**073724** ●	
Homag	12	20	2	1,0		5	HW	10	**073725** ●	
Homag	12	20	2	1.5		5	HW	10	**073726** ●	
Homag	12	20	2	2,0		5	HW	10	**073727** ●	
Homag	12	20	2	2.5		5	HW	10	**073728** ●	
Homag	12	20	2	3,0		5	HW	10	**073729** ●	
Homag	20	11.5	2		3	6	HW	10	**073717** ●	
Homag	20	11.5	2	1,0		6	HW	10	**073713** ●	
Homag	20	11.5	2	1.5		6	HW	10	**073714** ●	
Homag	20	11.5	2	2,0		6	HW	10	**073715** ●	
Homag	20	11.5	2	3,0		6	HW	10	**073716** ●	
IMA	12	20	2		45	4	HW	10	**074037** ●	
IMA	12	20	2	1,0		7	HW	10	**074044** ●	
IMA	12	20	2	1.5		7	HW	10	**074076** ●	
IMA	12	20	2	2,0		7	HW	10	**074021** ●	
IMA	12	20	2	2.5		7	HW	10	**074077** ●	
IMA	12	20	2	3,0		7	HW	10	**074022** ●	
Ott	12	13.3	3.3	1,0		8	HW	10	**074653** ●	
Ott	12	13.3	3.3	2,0		8	HW	10	**074654** ●	
SCM	12	20	2	2,0		4	HW	10	**074040** ●	
Stefani	12.7	12.7	3.18		25	1	HW	10	**074552** ●	
Stefani	12.7	12.7	3.18	1,0		1	HW	10	**074548** ●	
Stefani	12.7	12.7	3.18	1.5		1	HW	10	**074549** ●	
Stefani	12.7	12.7	3.18	2,0		1	HW	10	**074550** ●	
Stefani	12.7	12.7	3.18	3,0		1	HW	10	**074551** ●	

Additional scrapers available on request at short notice.

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



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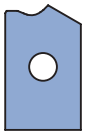
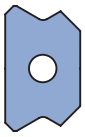


Type 2

Type 3



Type 4

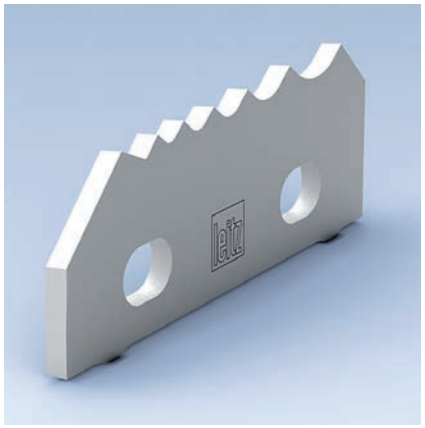
Technical information:
Prevention of stress-whitening and rework through special cutting geometry and quality. Scraper turnblades with different radii for adaption in scraper holder.

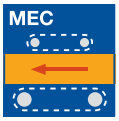
Profile scrapers with anti-stress whitening bevel
TM 435 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	ID	ID left
Brandt	12	20	2		45	1	HW	**074103** ●	
Brandt	12	20	2	1,0		1	HW	**074095** ●	
Brandt	12	20	2	1.3		1	HW	**074096** ●	
Brandt	12	20	2	1.5		1	HW	**074097** ●	
Brandt	12	20	2	2,0		1	HW	**074098** ●	
Brandt	12	20	2	2.5		1	HW	**074099** □	
Brandt	12	20	2	3,0		1	HW	**074100** ●	
EBM	12	20	2		45	1	HW	**074103** ●	
EBM	12	20	2	1,0		1	HW	**074095** ●	
EBM	12	20	2	1.3		1	HW	**074096** ●	
EBM	12	20	2	1.5		1	HW	**074097** ●	
EBM	12	20	2	2,0		1	HW	**074098** ●	
EBM	12	20	2	2.5		1	HW	**074099** □	
EBM	12	20	2	3,0		1	HW	**074100** ●	
Fravol	15.44	20	2	1-3		2	TDC	**074642** ●	**074641** ●
Hebrock	12	20	2	1,0		1	HW	**074095** ●	
Hebrock	12	20	2	1.3		1	HW	**074096** ●	
Hebrock	12	20	2	1.5		1	HW	**074097** ●	
Hebrock	12	20	2	2,0		1	HW	**074098** ●	
Hebrock	12	20	2	2.5		1	HW	**074099** □	
Hebrock	12	20	2	3,0		1	HW	**074100** ●	
Holz-Her	12	20	2		45	1	HW	**074103** ●	
Holz-Her	12	20	2	1,0		1	HW	**074095** ●	
Holz-Her	12	20	2	1.3		1	HW	**074096** ●	
Holz-Her	12	20	2	1.5		1	HW	**074097** ●	
Holz-Her	12	20	2	2,0		1	HW	**074098** ●	
Holz-Her	12	20	2	2.5		1	HW	**074099** □	
Holz-Her	12	20	2	3,0		1	HW	**074100** ●	
Homag	12	20	2		45	1	HW	**074103** ●	
Homag	12	20	2	1,0		1	HW	**074095** ●	
Homag	12	20	2	1.3		1	HW	**074096** ●	
Homag	12	20	2	1.5		1	HW	**074097** ●	
Homag	12	20	2	2,0		1	HW	**074098** ●	
Homag	12	20	2	2.5		1	HW	**074099** □	
Homag	12	20	2	3,0		1	HW	**074100** ●	
Homag	20	11.5	2	1,0		3	HW	**073719** ●	
Homag	20	11.5	2	1.5		3	HW	**073720** ●	
Homag	20	11.5	2	2,0		3	HW	**073721** ●	
Homag	20	11.5	2	3,0		3	HW	**073723** ●	
IMA	12	20	2		45	1	HW	**074103** ●	
IMA	12	20	2	1,0		4	HW	**074090** ●	
IMA	12	20	2	1.3		4	HW	**074101** □	
IMA	12	20	2	1.5		4	HW	**074091** ●	
IMA	12	20	2	2,0		4	HW	**074092** ●	
IMA	12	20	2	2.5		4	HW	**074093** □	
IMA	12	20	2	3,0		4	HW	**074094** ●	

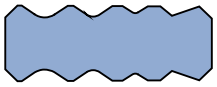
Spare parts:

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

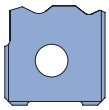




HW



Type 1



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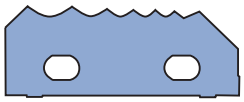
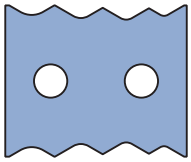


Type 3



Type 4

Multi-profile scrapers

Application:
For scraping edgebandings with radii or bevels.

Machine:
Single or double-sided edgebanding machines.

Workpiece material:
Plastic edgebandings.

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

Multi-profile scrapers
TM 135 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	34	12.7	3	1/2/3	Fase	1	HW		**074082** ●	
Brandt	13.5	13.38	2	1/3		2	HW	2	**075362** ●	**075361** ●
Brandt	13.5	13.38	2	1/2		2	HW	2	**075358** ●	**075357** ●
Brandt	13.5	13.38	2	1/1,5		2	HW	2	**075376** ●	**075375** ●
Brandt	13.5	13.38	2	1,3/3		2	HW	2	**075380** ●	**075379** ●
Brandt	13.5	13.38	2	1,3/2		2	HW	2	**075360** ●	**075359** ●
Brandt	13.5	13.38	2	1,5/2		2	HW	2	**075378** ●	**075377** ●
Brandt	13.5	13.38	2	2/3		2	HW	2	**075364** ●	**075363** ●
Brandt	13.5	13.38	2	2	30	2	HW	2	**075398**	**075397**
Homag	13.5	13.38	2	1/3		2	HW	2	**075362** ●	**075361** ●
Homag	13.5	13.38	2	1/2		2	HW	2	**075358** ●	**075357** ●
Homag	13.5	13.38	2	1/1,5		2	HW	2	**075376** ●	**075375** ●
Homag	13.5	13.38	2	1,3/3		2	HW	2	**075380** ●	**075379** ●
Homag	13.5	13.38	2	1,3/2		2	HW	2	**075360** ●	**075359** ●
Homag	13.5	13.38	2	1,5/2		2	HW	2	**075378** ●	**075377** ●
Homag	13.5	13.38	2	2/3		2	HW	2	**075364** ●	**075363** ●
Homag	13.5	13.38	2	2	30	2	HW	2	**075398**	**075397**
Homag	45.8	17.95	2	1/1,5/2/3/5	20	3	HW		**074050** ●	**074049** ●
IMA	24	20	2	1/1,5/2/3		4	HW		**074106** ●	
IMA	24	20	2	1/2/3		4	HW		**074107** ●	
Stefani	34	12.7	3	1/2/3	Fase	1	HW		**074080** ●	**074081** ●

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

Multi-profile scraper with anti stress-whitening bevel
TM 135 0

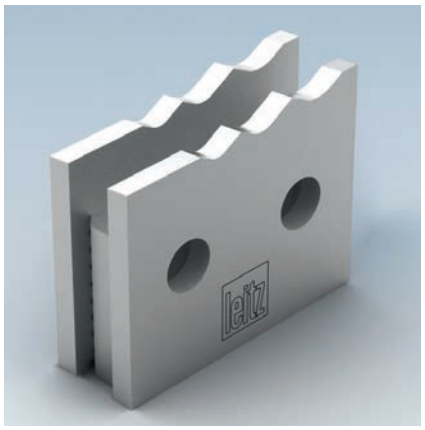
Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	ID	ID left
Homag	45.8	17.074	2	1/1,5/2/2,5/3	20	3	HW	**073105** ●	**073104** ●

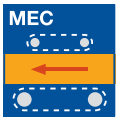
Further radii combinations with anti-stress whitening bevel available at short time.

Spare parts:

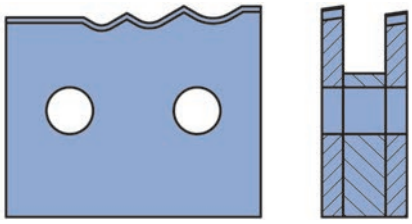
BEZ	ABM mm	ID
Torx® key	Torx® 15	**005466** ●
Oval head screw Torx® 15	M4x6	**006225** ●

● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

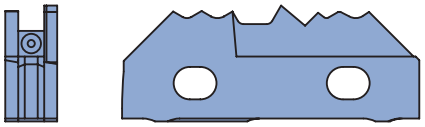




HW



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



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

Multi-profile scrapers

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

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

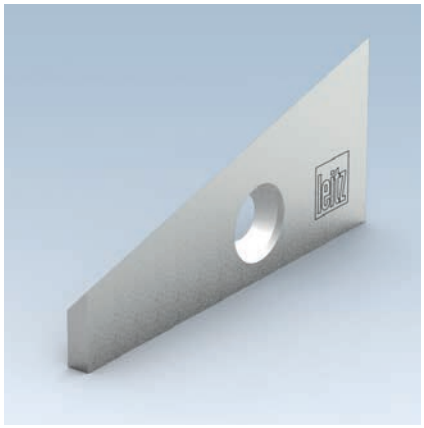
Workpiece material:
Plastic edgebander as PP, ABS, PMMA etc.

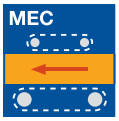
Technical information:
Duo multi-profile scraper with different radii and bevels for 4 profiles in total. Staggered cut on two consecutively arranged scrapers with special micro geometry for high edge quality, colour fastness, high gloss level and without stress-whitening. Especially in conjunction with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

Duo multi-profile scraper
TM 135 0, TM 435 0

Machine	SB mm	H mm	DIK mm	R mm	FAW °	Type	QAL	ID	ID left
Homag	45.8	19.94	8	1,3/2,0 (Duo) 0,6/1,5	5	2	HW	**073731**	**073730**
IMA	24	19.8	8	1/2/3	45	1	HW	**074089** ●	**074088** ●
IMA	23.7	19.8	8	1,3/1,5/2	45	1	HW	**074085** ●	**074084** ●

Further radii combinations available at short notice.



HW

Flat scrapers

Application:
For scraping edgebandings and glue.

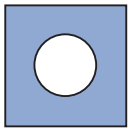
Machine:
Single or double-sided edgebanding machines.

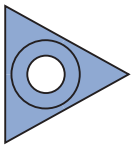
Workpiece material:
Plastic edgebandings.

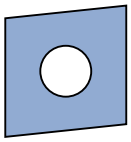
Technical information:
Different profile flat scrapers.

Flat scraper knives
TC 105 0, TM 135 0, TM 405 0, TM 440 0, TM 480 0

Machine	SB mm	H mm	DIK mm	FAW °	Type	QAL	VE PCS	ID	ID left
Biesse	16	16	4.7		1	HW		**074556** ●	
Biesse	22.9	22.9	2.5		2	HW		**074555** ●	
Brandt	15	14.3	2.5	6	3	HW		**074501** ●	**074500** ●
EBM	36	30	3		4	HW		**074635**	**074634**
Fravol	20	12	1.5		5	HW		**074638** ●	
Hebrock	36	30	3		4	HW		**074635**	**074634**
Holz-Her	14	14	2		1	HW		**009546** ●	
Homag	14.3	14.3	2.5		1	HW	10	**005426** ●	
Homag	15	14.3	2.5	6	3	HW		**074501** ●	**074500** ●
Homag	32	55	4.5	15	6	HW		**074048** ●	**074047** ●
IMA	14.3	14.3	2.5		1	HW		**074305** ●	
IMA	55	25	3	15	7	HW		**074024** ●	**074023** ●
IMA BAZ	11	14.3	2.5		5	HW		**074306** ●	
Ott	15	14.3	2.5	6	3	HW		**074501** ●	**074500** ●
SCM	14	14	2		1	HW-F	10	**005099** ●	


Type 1


Type 2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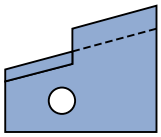
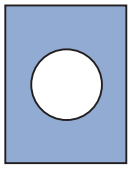

Type 4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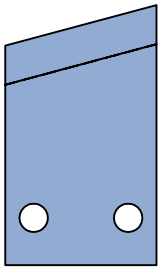
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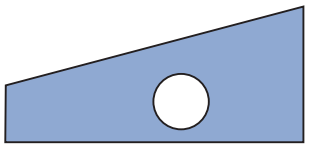
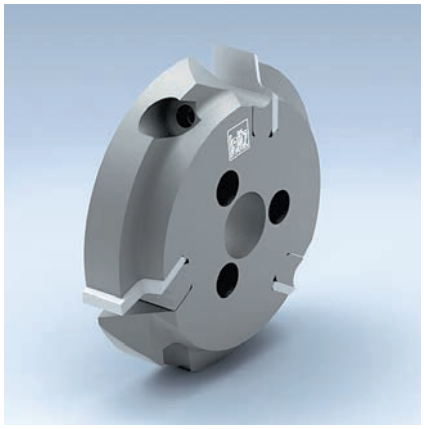
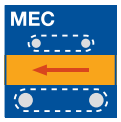
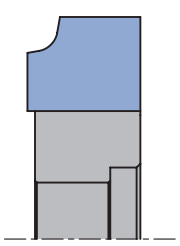

Type 7

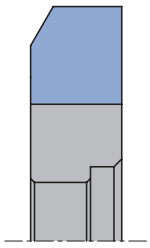
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org

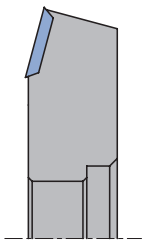


HW


Type 1


Type 2


Type 3

Profile cutterhead / bevel cutterhead for stationary machines

Application:
To round/bevel edgebandings.

Machine:
Homag BAZ.

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

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

Various radii / bevels - Homag
WE 500 2

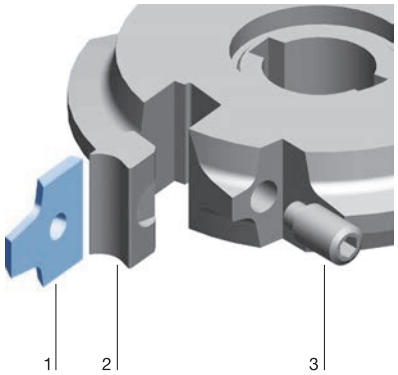
D mm	D_0 mm	BO mm	NLA mm	Z	QAL	R mm	FAW °	Type	n_{max} min^{-1}	ID LH	ID RH
59	50	15	3/4,2/25	3	HW	1,0		1	18,000	**073001** □	**073000** □
59	50	15	3/4,2/25	3	HW	1.5		1	18,000	**073003** □	**073002** □
59	50	15	3/4,2/25	3	HW	2,0		1	18,000	**073005** □	**073004** □
59	50	15	3/4,2/25	3	HW	3,0		1	18,000	**073009** □	**073008** □
60	50	15	3/4,2/25	3	HW		15	2	18,000	**073037** □	**073036** □
60	50	15	3/4,2/25	3	HW		30	2	18,000	**073039** □	**073038** □
60	50	15	3/4,2/25	3	HW		45	2	18,000	**073041** □	**073040** □
62	50	15	3/4,2/25	3	HW		15	3	18,000	**073101** □	**073100** □

Type 3 for special thin edgebandings.
Spare knives:

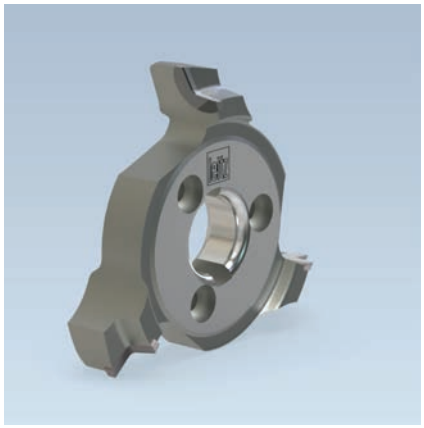
Part-no.	SB mm	H mm	DIK mm	QAL	R mm	FAW °	Type	ID LH	ID RH
1	13	15	2	HW	1,0		1	**073501** ●	**073500** ●
1	13	15	2	HW	1.5		1	**073503** ●	**073502** ●
1	13	15	2	HW	2,0		1	**073505** ●	**073504** ●
1	13	15	2	HW	3,0		1	**073509** ●	**073508** ●
1	12	16	2	HW		15	2	**073537** ●	**073536** ●
1	12	16	2	HW		30	2	**073539**	**073538**
1	12	16	2	HW		45	2	**073541** ●	**073540** ●
1	14	14	2	HW-F			3	**005099** ●	**005099** ●

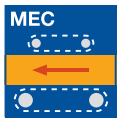
Spare parts:

Part-no.	BEZ	ABM mm	ID
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	43x12x6	**005350** ●

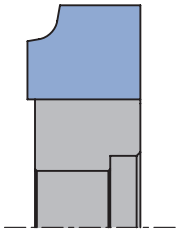


● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org





DP



Profile cutter / bevel cutter for stationary machines

Application:
To round/bevel edgebandings.

Machine:
Homag BAZ.

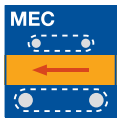
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

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

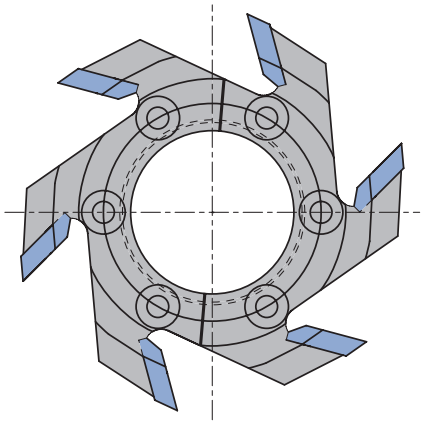
Radii cutter DP - Homag
WF 501 2 DP

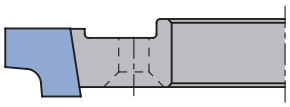
D mm	D_0 mm	BO mm	NLA mm	Z	QAL	R mm	n_{max} min^{-1}	ID LH	ID RH
57	50	15	3/4,2/25	3	DP	2,0	18,000	**073103** ●	**073102** ●
57	50	15	3/4,2/25	3	DP	3,0	18,000	**091522** ●	**091523** ●

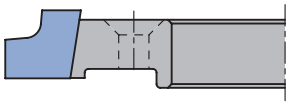
● available ex stock
□ available at short notice
Instruction manual visit www.leitz.org



HW







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.

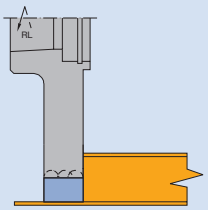
Various radii / bevels - IMA
WF 501 2

D mm	D_0 mm	SB mm	BO mm	NLA mm	Z	QAL	R mm	FAW °	n_{max} min^{-1}	ID LH	ID RH
64.4	55	5.8	30	6/5/40	6	HW	1.5		18,000	**074062** □	**074063** □
64.4	55	5.8	30	6/5/40	6	HW	2,0		18,000	**074064** □	**074065** □
64.4	55	5.8	30	6/5/40	6	HW	3,0		18,000	**074066** □	**074067** □
70	60	9	30	6/5/40	6	HW	1.5		18,000	**074056** □	**074057** □
70	60	9	30	6/5/40	6	HW	2,0		18,000	**074058** □	**074059** □
70	60	9	30	6/5/40	6	HW	3,0		18,000	**074060** □	**074061** □
70	60	9	30	6/5/40	6	HW		15	18,000	**074068**	**074069**
70	60	9	30	6/5/40	6	HW		30	18,000	**074070**	**074071**
70	60	9	30	6/5/40	6	HW		45	18,000	**074072**	**074073**

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

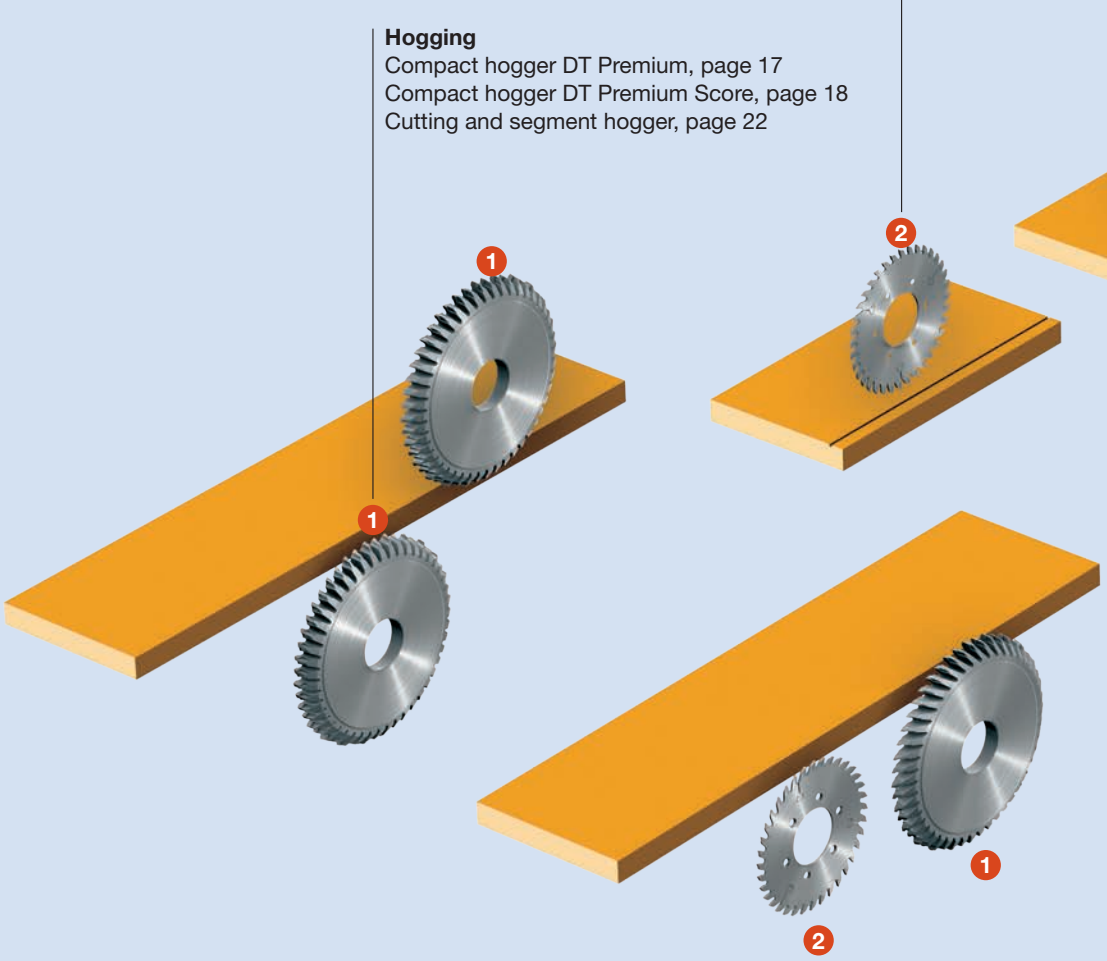
Rebating
Rebating cutter, page 67

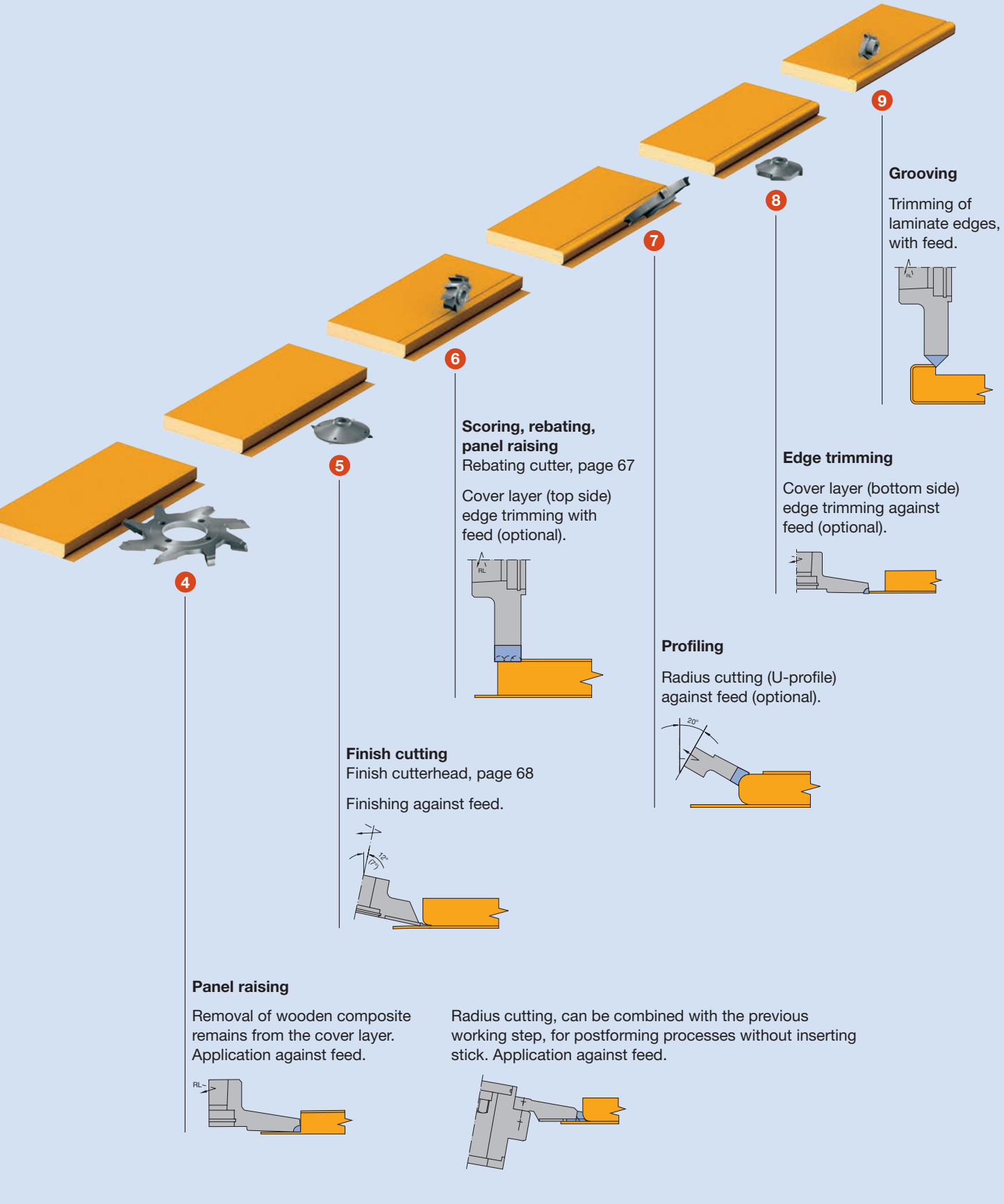
Milling off the wooden composite board to uncover the cover layer, application mostly with feed.



Scoring

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




4
5
6
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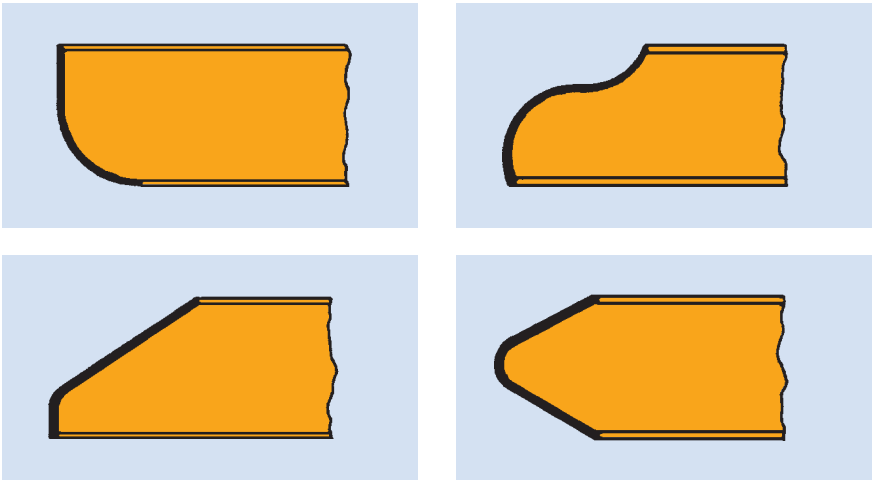
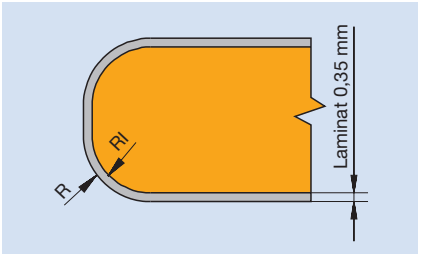
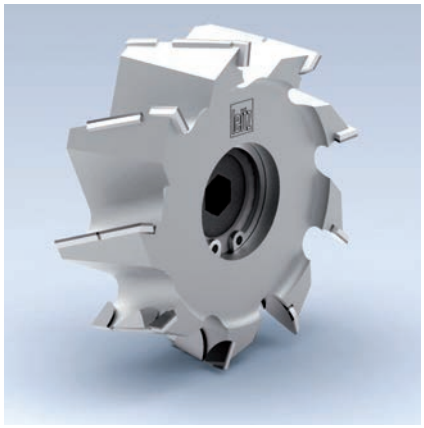
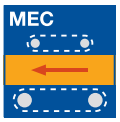
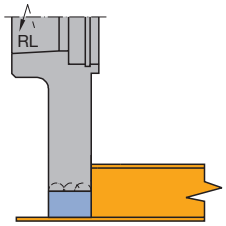
9
Panel raising
Removal of wooden composite remains from the cover layer. Application against feed.
RL
Finish cutting
Finish cutterhead, page 68
Finishing against feed.
12°
Scoring, rebating, panel raising
Rebating cutter, page 67
Cover layer (top side) edge trimming with feed (optional).
RL
Radius cutting, can be combined with the previous working step, for postforming processes without inserting stick. Application against feed.
Profiling
Radius cutting (U-profile) against feed (optional).
20°
Edge trimming
Cover layer (bottom side) edge trimming against feed (optional).
Grooving
Trimming of laminate edges, with feed.
RL

Working processes	Production of workpieces with narrow edges for profiling and coating with edging material.
Workpiece material	Chipboard and fibre materials (e.g. MDF boards).
Machines	Single or double-sided soft forming machines.
Procedure	Sizing panel by scoring hogging or double hogging, protection milling, if required. Scoring and removing the coating on the workpiece surface by horizontal spindle. Profiling the narrow edge with vertical, horizontal or inclined spindles. Cutting the edgebanding on the sized side to a precise dimension with the tracing spindle. Edge trimming of the banding on the side banded first with tracing spindle. Scraping, if required.
Important order data	– Profile – Coating thickness – Coating material – Machine side – Number of sides to be coated – Expected profile production volume Given the diversity of products, standard tools and special tools are used in soft forming according to requirements.
Profile examples	
Working process	Production of workpieces with profiled narrow edges with jointless HPL, CPL or veneer surface coating material wrapped around the narrow face.
Workpiece material	Chipboard and fibre materials (e.g. MDF).
Machines	Single or double-sided post forming machines.
Important ordering information	 – Radius and internal radius – Coating thickness – Material thickness – Type of coating – Post forming with or without inlay rod – Machine side R = External radius, e.g. R9 RI = Internal radius, e.g. R8,65





DP



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

Rebating cutter

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

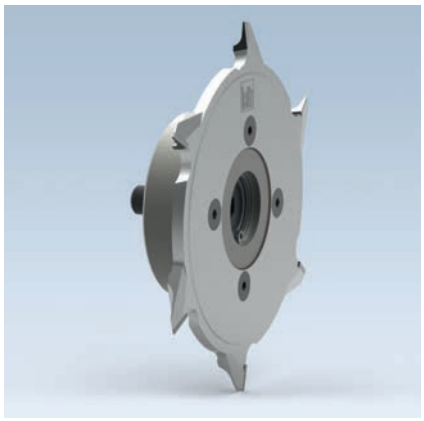
Machine:
Postforming machines.

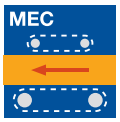
Workpiece material:
HPL, CPL or veneer coated chip and fibre boards (particle board, MDF etc.).

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.

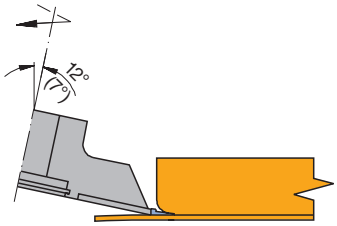
Diamaster PRO
WF 499 2

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





DP



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

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

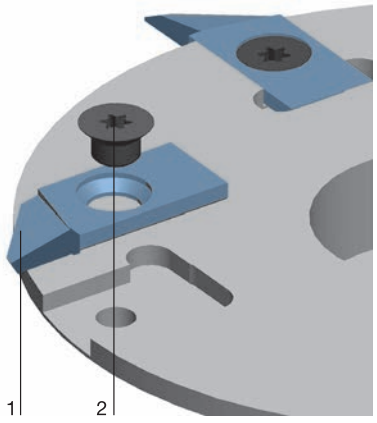
Machine	D mm	SB mm	BO mm	Z	QAL	n_{max} min^{-1}	Spindle angle °	ID LH	ID RH
Homag, IMA	125	5.1	HSK 25 R	6	DP	12000	7	**192666**	**192667**

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 mm	QAL	ID LH	ID RH
Knife	12x31x2.5x0.5. SB2.5	DP	**008208** ●	**008204** ●

Spare knives for 7° and 12° inclined spindles.



● available ex stock
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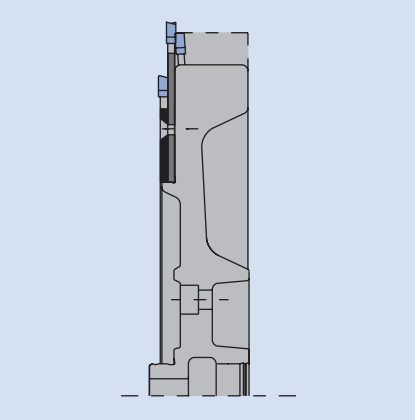
Instruction manual visit www.leitz.org

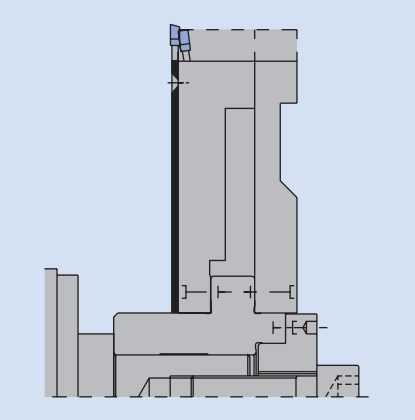
Segment hogger

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.

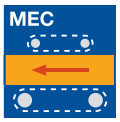
Designs

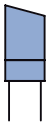


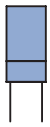
Toolset for finish-production unit with sizing and finish cut

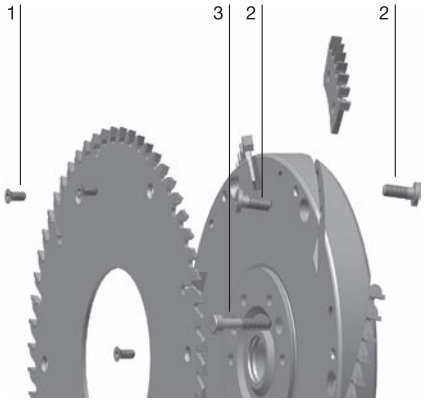


Toolset for sizing unit mounted on flanged sleeve









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 mm	SB mm	BO mm	$Z/ZF_{Sawblade}$	QAL	ID LH	ID 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 mm	Z	ZF	QAL	BEM	ID
	Basic hogger	300x28,0x30	6x7	FZ	HW		**064440** ●
	Basic hogger	300x28,0x30	6x7	FZ	HW		**064441** ●
	Basic hogger	350x36,5x80	6x10	FZ	HW		**064442** □
	Basic hogger	350x36,5x80	6x10	FZ	HW		**064443** □
	Extension cutter	300x28,0x30	6x7	FZ	HW		**064444** ●
	Extension cutter	300x28,0x30	6x7	FZ	HW		**064445** ●
	Extension cutter	350x20,2x80	6x10	FZ	HW		**064446**
	Extension cutter	350x20,2x80	6x10	FZ	HW		**064447**
	Hogging segment	D 300/340	7	FZ	HW		**064970** ●
	Hogging segment	D 300/340	7	FZ	HW		**064971** ●
	Hogging segment	D 350	10	FZ	HW		**064962** ●
	Hogging segment	D 350	10	FZ	HW		**064963** ●
1	Countersink screw, Torx® 20	M6x12				Torx® 20	**006084** ●
2	Screw with ISK	M8x17				for D = 250, 350, 305, 355	**006237** ●
3	Cylindrical screw with ISK	M8x60				for D = 305	**005878** ●
3	Cylindrical screw with ISK	M8x35				for D = 305, 350	**005874** ●
3	Cylindrical screw with ISK	M8x25				for D = 355	**005947** ●

Hogging sawblade
WK 801 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
305	4.4	120	60	ES	HW	**061844** ●	**061845** ●
355	4.4	80	72	ES	HW	**061846** ●	**061847** ●

● available ex stock
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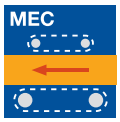
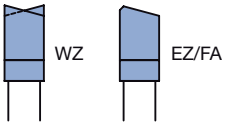
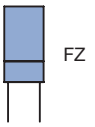
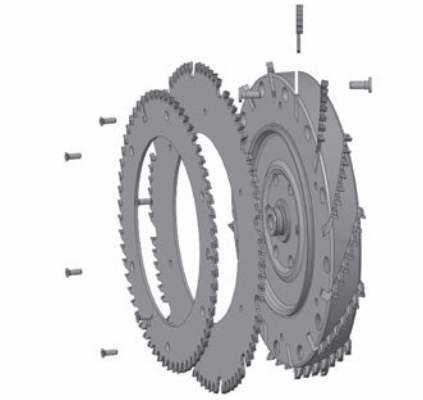








Segment hogger for splitting unit

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

Machine:
Sizing station in production lines.

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

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

Hogger for splitting unit
SZ 300 2

Machine	D mm	SB mm	BO mm	Z/ZF$_{Sawblade}$	QAL	ID LH	ID RH
Siempelkamp	350	42.1	30	60 ES/FA 72 WZ	HW	**064704**	**064705**

Spare parts:

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

Technical information:
D 300 mm finish cut and D 350 mm trimming sawblade.

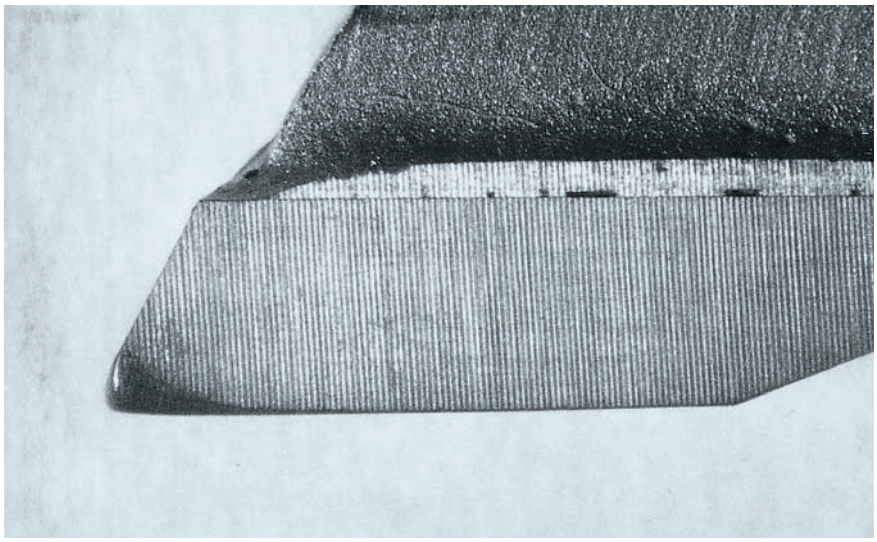
Hogging sawblade
WK 802 2, WK 850 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
300	4.4	200	60	ES/FA	HW	**061848** ●	**061849** ●
350	4.4	200	72	WZ	HW	**061850** ●	**061850** ●

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

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

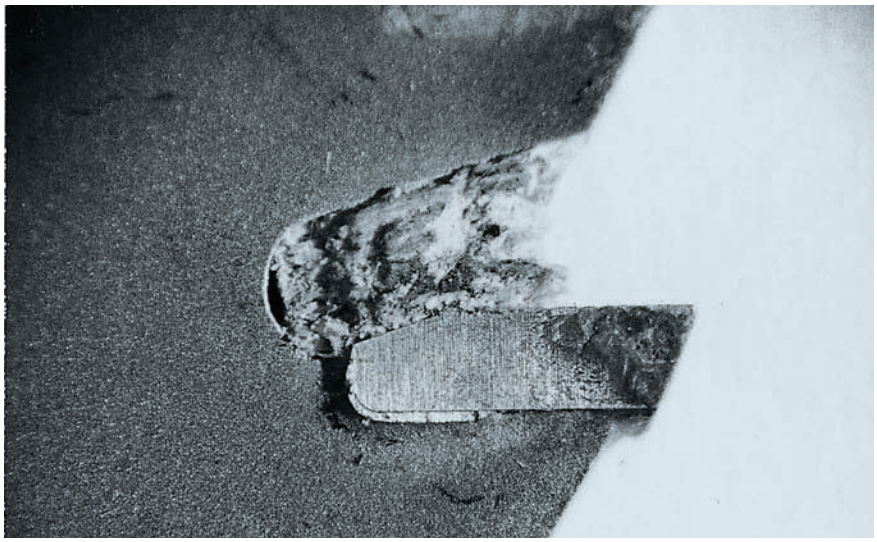
The surface quality determines the size of the cutting edge abrasion. An extremely worn sawblade tooth requires additional sharpening and reduces the number of possible resharpenings.



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.

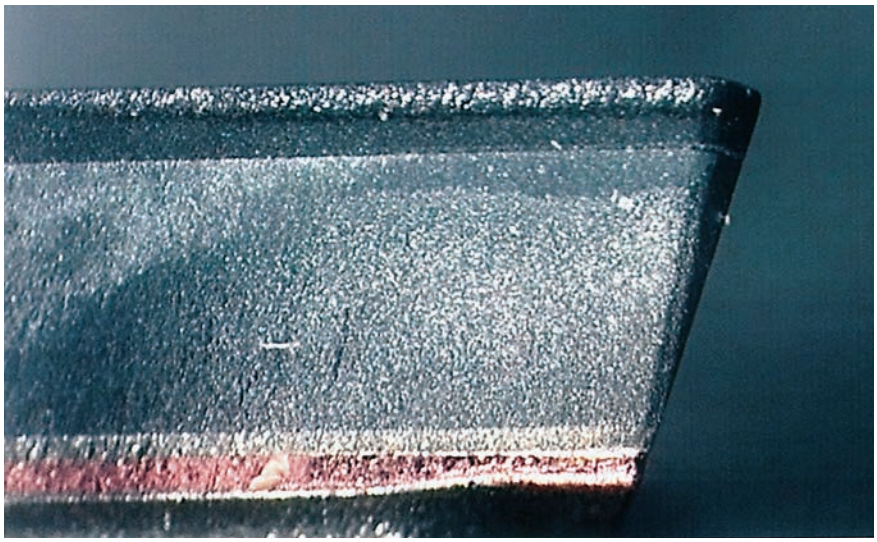
The hogging width must always be smaller than the cutting width of the hogging tool.

Destruction of saw tooth through overstress.

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

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

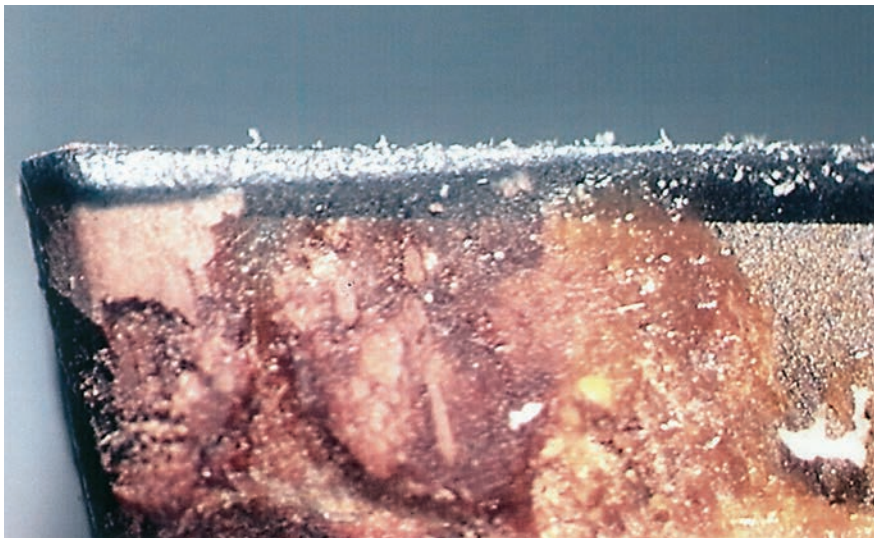
The area of wear should be approx. 0.2 to max. 0.3 mm.



Wear to cutting edges after machining MDF.

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

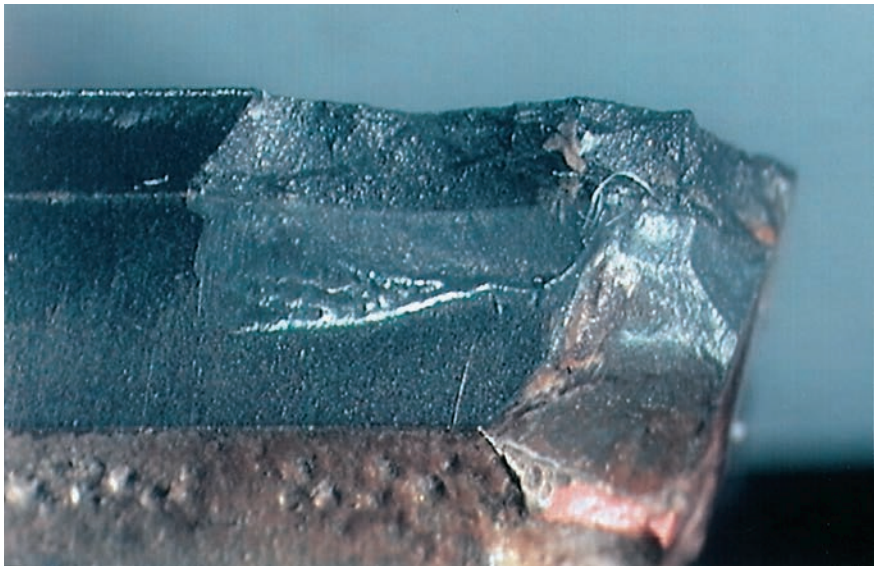
This leads to higher cutting forces and power consumption, low surface and middle layer quality and a considerably reduced tool life.



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

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

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



Cutting edge destruction from metallic particles.

Enquiry/order form special tools – panel processing

Customer details: Customer number: (if known) ☐☐☐☐☐☐☐☐

☐ Enquiry ☐ Order

Delivery date: (not binding) ☐☐ CW

Company:

Street:

Post code/place:

Country:

Phone/fax:

Contact person:

Signature:

Date:

Enquiry/order no.:

Tool ID: (if known)

No. of pieces:

Workpiece material:

Type:

Moisture content (of solid wood) %

Direction of machining

☐ along grain ☐ across grain

Cutting quality:

☐ Pre-hogging

Coating: ☐ Yes ☐ No

Type (of wood derived material):

Hogging width: mm

Material thickness: mm

☐ Finish hogging

Machine:

Manufacturer:

Type:

Model:

Power: kW (HP) motor spindle (see drawing):

RPM: min^{-1}

Feed: m min^{-1}

Hogging motor:

☐ Against feed

☐ With feed

☐ Application scoring/hogging

☐ Application hogging/hogging

Tool:

Tool type (see selection):

☐ Hogging set in cutter design

☐ Hogging set with segments

☐ Compact hogging set

☐ Other

Adaptor:

☐ Mechanical

☐ Quick change

☐ Hydraulic

Dimensions:

Diameter mm

Cutting width mm

Bore mm

No. of teeth:

Hogging sawblade

Hogger

Cutting material:

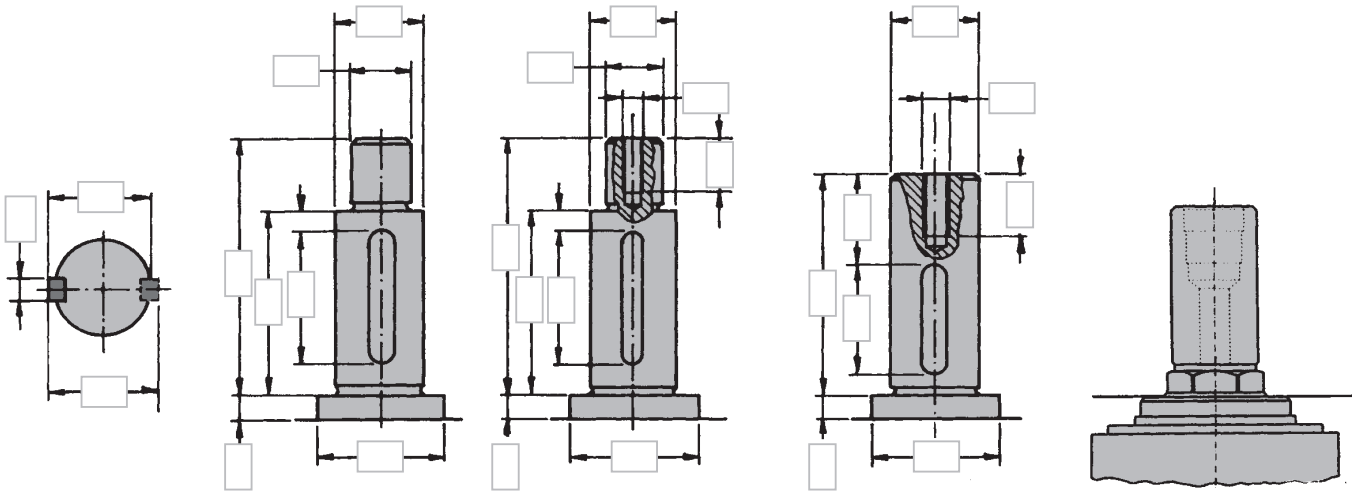
☐ HW (TC)

☐ DP (DIA)

Please state existing data on tool, machine and workpiece material.

Hogging motor/spindle details:

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



Standard motor

High-precision motor
D40-6 KT (Hydro sleeve)

Sketch for application plan, motor spindle etc.

Key to pictograms


Scoring hogging

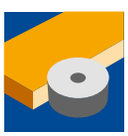

Hogging


Double hogging


End trimming


Edge trimming

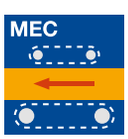

Grooving, horizontal and vertical


Jointing


Rebating


Profiling


Profiling joints



Mechanical feed


Tipped tool

Light alloy body


Interchangeable knives


Mechanical knife clamping, reversible


Resharpenable cutting face


Resharpenable clearance face

Low noise

Optimised chip flow

Tungsten carbide

Polycrystalline diamond (PCD)

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