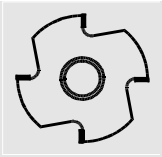
Cutters with Bore Page

Edge Trimming

Grooving

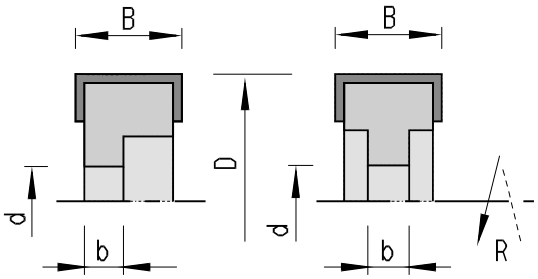
Jointing / Rabbeting / Chamfering / Rounding



Cutters with Bore Page

Profiling

Jointing



For jointing and flush cutting of edge bands

- for solid wood, veneer and plastic edge bands
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

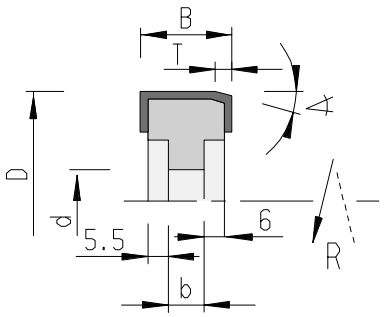
- sense of rotation acc. to DIN-EN 50144

120.100

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No. L	Ident.-No. R
50	12	10	16	5x2,3	4	Sudhoff, EBM, Ney		167258
50	12	10	16	5x2,3	2	Homag/Homburg		164066
50	15	10	16	5x2,3	4	EBM		179139
50	15	10	16	5x2,3	2	IMA, Raimann		164067
61	12	10	16	5x2,3	3	Homag		167899
61	20	11	16	5x2,3	3	Homag		167900
70	12	10	16	5x2,3	6	Brandt/Homag		164073
70	12	10	16	5x2,3	4	Brandt/Homag		164068
70	20	11	16	5x2,3	2	Reich		182077
70	20	11	16	5x2,3	4	Homag/Homburg		164071
70	20	20	16	5x2,3	4	Ott		164069
70	20	12,5	20	2/6x3,5	6	IMA/IDM	164134	164080
70	20	12,5	20	6x3,5	4	Brandt/Homag	164133	164079
70	20	11	20	6x3,5	4	Holz-Her		164070
80	40	25	30	8x3,3	4	Holz-Her		164072

turnover knives	B mm	H mm	S	Art.-No.	Ident.-No.
	12	12	1,5	150515	003080
	15	12	1,5	150515	003081
	20	12	1,5	150515	003082
	40	12	1,5	150515	164078

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 10	167258 164066 167899 164073 164067 164068 179139	925300	164526
clamping strip	B = 18	167900 164071 182077 164069 164134 164133 164070 164079 164080	925300	164076
clamping strip	B = 39	164072	925300	164077
setscrew	DIN 915 M6x10	167258 164066 164067 179139	995161	180002
setscrew			995161	180214
hex head wrench	SW 3x100		985730	166090
hex socket head wrench	DIN 911 SW 3		985730	009672



For jointing and flush cutting of edge bands

- on Holz-Her edgebanders
- for solid wood, veneer and plastic edge bands
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06
- n max 18.000 min-1
- MEC

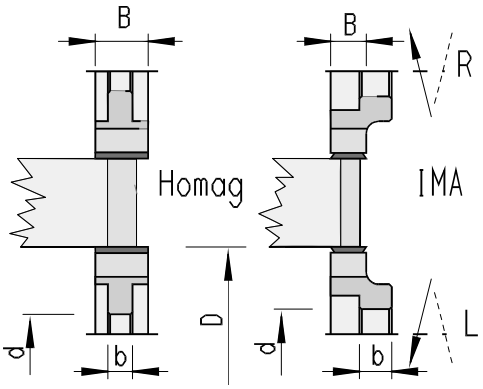
- sense of rotation acc. to DIN-EN 50144

120.100

Ø D mm	B mm	T mm	chamfer a. in degr.	b mm	Ø d mm	Z	Ident.-No. L	Ident.-No. R
70	29,5	5	15	17	20	4	164462	164463

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
for left hand rotation	29,5	12	1,5	150515	160618
for right hand rotation	29,5	12	1,5	150515	160118

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B = 27,5	925300	164185
setscrew		995161	180214
hex head wrench	SW 3x100	985730	166090



For jointing and flush cutting of edge bands

- on Homag and IMA edgebanders
- for solid wood, veneer and plastic edge bands
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

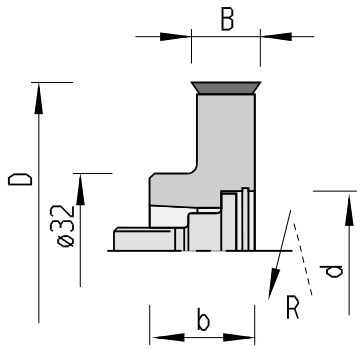
- sense of rotation acc. to DIN-EN 50144

120.101

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No. L	Ident.-No. R
70	14,3	10	16	5x2,3	4	Homag		170247
70	14,3	13	20	6x3,5	4	IMA	172717	172718 #
70	20,0	10	16	5x2,3	4	Homag		168510

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	14,3	14,3	2,5	150518	170248
	20,0	14,3	2,5	150518	168509

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
Torx countersunk screw	M5x10,8 T15	170247 172717 172718 168510	995125	180840
Torx wrench	T15x100		985730	180470



For flush cutting and chamfering of edge bands "HSK 25R"

- on HOMAG- and IMA-edgebanders
- for solid wood, veneer and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges parallel to cutter axis, with 4 cutting edges

- cutting material: HW
  HL Solid 15
- n max 18.000 min -1
- MEC

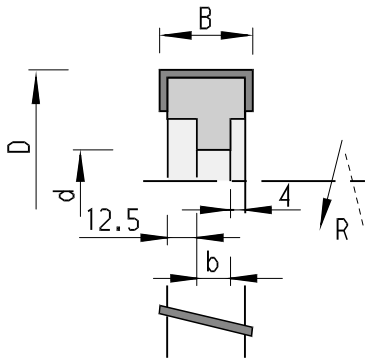
- sense of rotation acc. to DIN-EN 50144

120.101

Ø D mm	B mm	b mm	Ø d mm	Z	Ident.-No. L	Ident.-No. R
70	14,3	23	HSK25R	4	177592	177591

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	14,3	14,3	2,5	150518	170248

spare parts	dimensions	Art.-No.	Ident.-No.
Torx wrench	T 15x100	985730	180470
Torx countersunk screw	M5x10,8 T15	995125	180840
screw for HSK25R	M10x1,25x32 SW 8	995190	177780
shim ring	DIN 988 18x25x1,0	995440	177781
locking ring	DIN 472 25x1,2	995460	177782



For jointing and flush cutting of edge bands

- on Brandt edgebanders
- for solid wood, veneer and plastic edge bands
- optimum tool balance
- cutting edges with shear angle

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

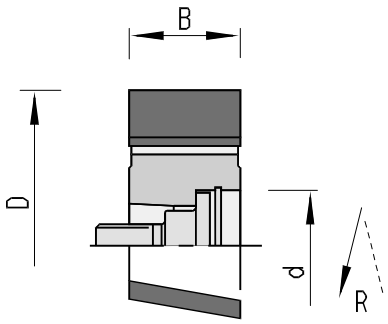
- sense of rotation see drawing

120.110

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No. L	Ident.-No. R
70	29,5	11	16	5 x 2,3	4	Brandt	170190	170189

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	30	12	1,5	150515	003083

spare parts and clamping tools	dimensions	for Ident.-No.		Art.-No.	Ident.-No.
clamping strip	B = 26,6	170190	170189	925300	167885
setscrew	DIN 915 M8x2	170190	170189	995161	001622
hex head wrench	SW 4x100			985730	166091



For flush cutting and chamfering of edge bands "HSK 25R"

- on HOMAG- and IMA-edgebanders
- for solid wood, veneer and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges with shear angle

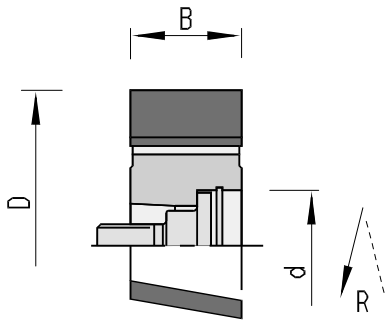
- cutting material: HW
- n max 24.000 min -1
- MEC

- sense of rotation acc. to DIN-EN 50144

122.110

Ø D mm	B mm	Ø d mm	Z	Ident.-No. L	R
70	25	HSK25R	4	177590	177589
70	35	HSK25R	4	178035	178034

spare parts	dimensions	Art.-No.	Ident.-No.
screw for HSK25R	M10x1,25x32 SW 8	995190	177780
shim ring	DIN 988 18x25x1,0	995440	177781
locking ring	DIN 472 25x1,2	995460	177782



For flush cutting and chamfering of edge bands "HSK 25R"

- on HOMAG-edgebanders
- for solid wood, veneer and plastic edges
- improved chip disposal thanks to internal chip evacuation
  advantages:
  - less chips remain inside of the machine
  - avoidance of malfunctions due to chips
  - suction power can be reduced: noice reduced
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges with shear angle

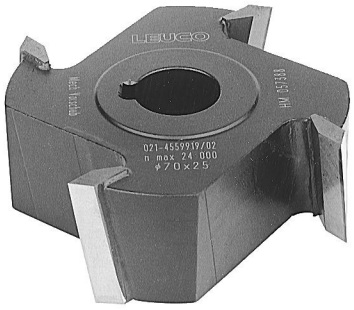
- cutting material: HW
- n max 24.000 min -1
- MEC

- sense of rotation acc. to DIN-EN 50144

122.110

Ø D mm	B mm	Ø d mm	Z	Ident.-No. L	R
70	25	HSK25R	4	180765	180766

spare parts	dimensions	Art.-No.	Ident.-No.
screw for HSK25R	M10x1,25x32 SW 8	995190	177780
shim ring	DIN 988 18x25x1,0	995440	177781
locking ring	DIN 472 25x1,2	995460	177782



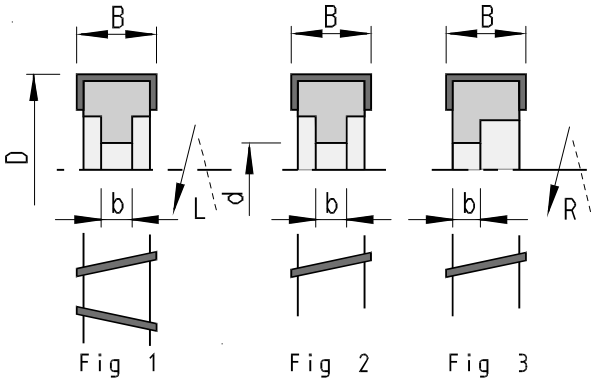


Fig 1 Fig 2 Fig 3

For jointing and flush cutting of edge bands

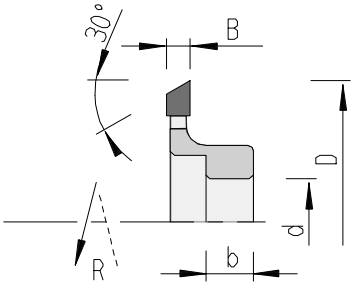
- on edgebanders
- for solid wood, veneer and plastic edges
- cutting edges with shear angle

- cutting material: HW
- n max 18.000 min-1
- MEC

- sense of rotation acc. to DIN-EN 50144

122.110

figure	Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	shear a. in degr.	mach.	Ident.-No. L	Ident.-No. R
Fig.1	55	20	10	16	5x2,3	4	5	Raimann		160642 s
Fig.3	70	25	10,5	16	5x2,3	4	10		057387	057388
Fig.2	70	25	10,5	16	5x2,3	4	10	Homag	180796	180795
Fig.3	70	23	12,5	20	6x3,5	4	10	IMA	772982 s	772981 s
Fig.3	70	25	12,5	20	6x3,5	4	10	IMA	006291	006290
Fig.1	70	35	20	20	6x2,8	4	10			160645
Fig.2	100	25	15	30		4	15		160647	160109



For flush cutting and chamfering of edges

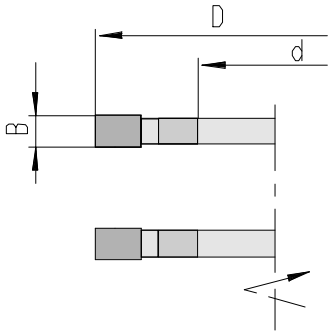
- on edgebanders
- for solid wood, veneer and plastic edges
- cutting edges parallel to cutter axis

- cutting material: HW
- n max 18.000 min-1
- MEC

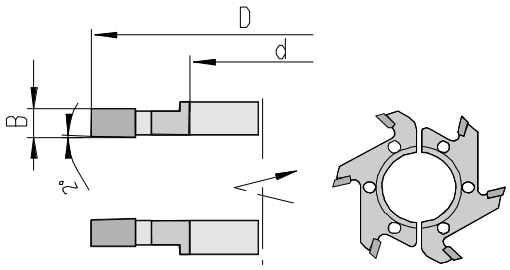
- sense of rotation see drawing

122.100

figure	Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No. L	Ident.-No. R
	73	6	12	20	6x3,5	12	IMA	171240	171239



Type A



Type B

For for flush cutting and jointing of edge bands

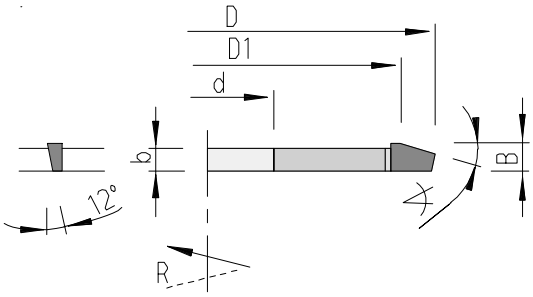
- on edge banders
- for solid wood, veneer and plastic edges
- Type A :
  - one part version
  - countersunk both sides for application on top and bottom
  - application on IMA machines model BIMA with Combiform
  - flush cutting unit 6120, 6121
- Type B :
  - two part version
  - countersunk both sides
  - application on IMA machines model BIMA with glueing device
  - flush cutting unit 6135
- cutting edges parallel to cutter axis

- cutting material: HW
- n max 18 000 min-1
- MEC

- sense of rotation see drawing

122.110

Ø D mm	B mm	b mm	Ø d mm	Z	mach.	type	Ident.-No. top	Ident.-No. bottom
70	6	3,5	30	6	IMA (BIMA)	A	658554 s	658554 s
70	6	6	30	6	IMA (BIMA)	B	716658 s	716657 s



For flush cutting and chamfering of edges

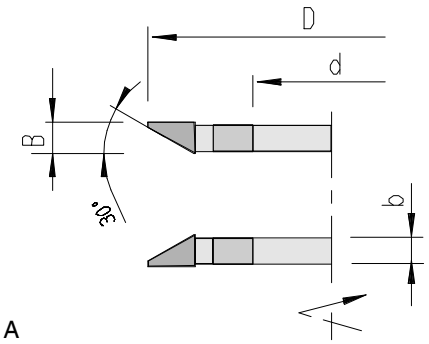
- on Brandt edgebanders
- for solid wood, veneer and plastic edges
- cutting edges with shear angle

- cutting material: HW
- n = 8.100 - 13.800 min-1
- MAN

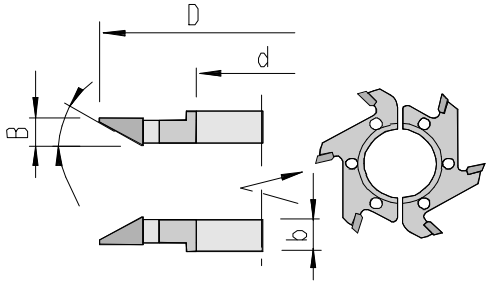
- sense of rotation acc. to DIN-EN 50144

122.115

Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	Z	chamfer a. in degr.	shear a. in degr.	mach.	Ident.-No. L	Ident.-No. R
66	60	4	3	16	6	15	12	Brandt	819482 s	819481 s
96		5,8	5	40	12	16	12	Brandt	164658 s	164657 s



Type A



Type B

For chamfering and flush cutting of edge bands

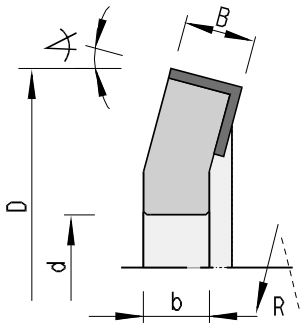
- for solid wood, veneer and plastic edge bands
- optimal tool balance
- Type A:
  - one part version
  - application on IMA machines model BIMA with glueing device; and Combiform
  - flush cutting unit 6120, 6121
- Type B:
  - two part version
  - application on IMA machines model BIMA with glueing device
  - flush cutting unit 6135
- cutting edges with shear angle

- cutting material: HW
- n max 18.000 min-1
- MEC

- sense of rotation see drawing

122.110

Ø D mm	B mm	b mm	Ø d mm	Z	angle in degr.	mach.	type	Ident.-No. top	Ident.-No. bottom
70	6	3,5	30	6	30	IMA (BIMA)	A	658797 s	658796 s
70	9	9	30	6	30	IMA (BIMA)	B	180164	180163
70	9	9	30	6	2	IMA (BIMA)	B	180161 s	180162 s



For chamfering and flush cutting of edge bands

- on Homag and Holz-Her edgebanders
- for solid wood, veneer and plastic edge bands
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

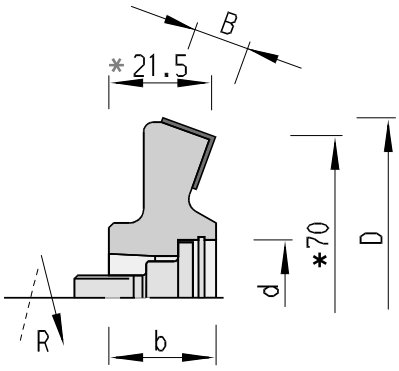
- sense of rotation acc. to DIN-EN 50144

120.120

Ø D mm	B mm	b mm	Ø d mm	Z	chamfer a. in degr.		Ident.-No. L	Ident.-No. R
65	12	11	16	3	15	Homag	167735	167734

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	12	12	1,5	150515	003080

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B = 10	925300	164526
setscrew	DIN 915 M6x12	995161	180214
hex head wrench	SW 3x100	985730	166090



For flush cutting and chamfering of edge bands "HSK25R"

- on Homag and IMA edgebanders
- for solid wood, veneer and plastic edge bands
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges with shear angle, 4 cutting edges

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

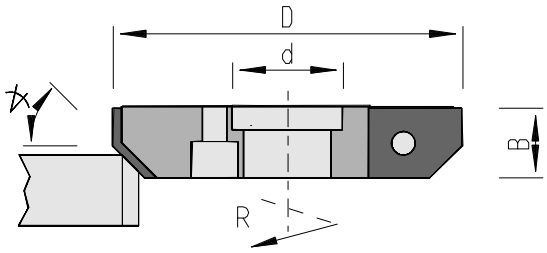
- sense of rotation acc. to DIN-EN 50144

120.120

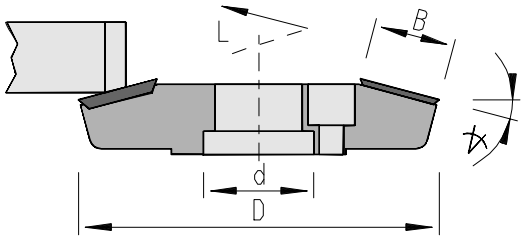
Ø D mm	B mm	b mm	Ø d mm	Z	chamfer a. in degr.	Ident.-No. L	Ident.-No. R
77	12	23	HSK25R	4	20	177594	177593

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	12	12	1,5	150515	003080

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
screw for HSK25R	M10x1,25x32 SW 8	995190	177780
shim ring	DIN 988 18x25x1,0	995440	177781
locking ring	DIN 472 25x1,2	995460	177782
clamping strip	B = 10	925300	164526
setscrew	DIN 915 M6x12	995161	180214
hex head wrench	SW 3x100	985730	166090



type 1



type 2

For chamfering and flush cutting of edge bands

- on HOMAG BAZ (working center)

- Type 1: Art.-No. 120.102
  for solid wood and plastic edge bands
- Type 2: Art.-No. 120.101
  especially for thin edge bands
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18 000 min -1
- MEC

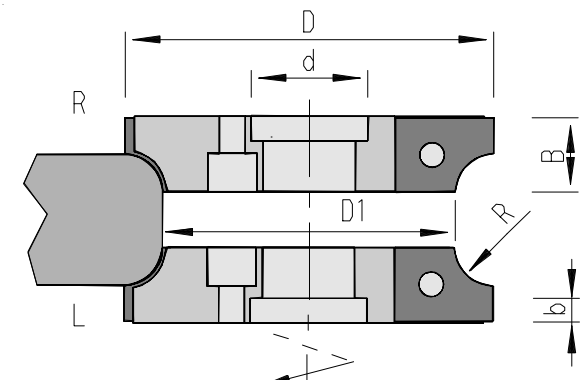
- sense of rotation acc. to DIN - EN 50144

120.102 / 120.101

Ø D mm	B mm	Ø d mm	Z	chamfer a. in degr.	type	Ident.-No. L	Ident.-No. R
60	12	19	3	5	Type 1	179207	179206
60	12	19	3	15	type 1	178634 #	178633 s
60	13,5	19	3	30	type 1	178632	178631
60	12	19	3	45	type 1	178630	178629
62	14	19	3	15	type 2	178640	178639

turnover knives	B mm	H mm	S mm	chamfer a. in degr.	Art.-No.	Ident.-No. L	Ident.-No. R
	12	16	2	5	151545	179174	179173
	12	16	2	15	151545	177042	177045
	13,5	16	2	30	151545	177043	177046
	12	16	2	45	151545	177823	177822
spur	14	14	2		150559		003079

spare parts and clamping tools	dimensions	for type	Art.-No.	Ident.-No.
clamping strip	12x10x7	type 1	925300	178759
clamping magnet		type 1	997800	016613
setscrew	DIN 915 M6x12	type 1	995161	180214
hex head wrench	SW 3x100	type 1	985730	166090
Torx countersunk screw	M5x6 T20	type 2	995125	176199
Torx wrench	T20x100	type 2	985730	166092



For rounding of edge bands

- on Homag BAZ (working center)
- for solid wood and plastic edge bands
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18 000 min -1
- MEC

- sense of rotation acc. to DIN - EN 50144

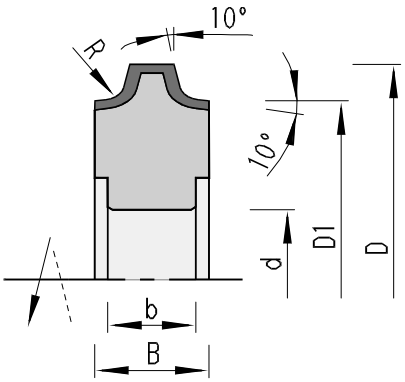
- same cutter head body for radius 1,5 - 3 mm and for 4 - 5 mm

120.102

R mm	Ø D mm	Ø D1 mm	Ø d mm	B mm	b mm	Z	Ident.-No. L	Ident.-No. R
2	59	50	19	13	4	3	180749 &	180748 &
	59	50	19	13	4	3	180751 &	180750 &
4	63	50	19	14	4	3	178795 s	178794 s
5	63	50	19	15	4	3	178797 s	178796 s

turnover knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No. L	Ident.-No. R
	1,5	13	15	2	151546	181954	181953
	2	13	15	2	151546	181956	181955
	3	13	15	2	151546	181957	181958
	4	14	17	2	151545	177036	177040
	5	15	17	2	151545	177037	177041

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B=12	925300	178759
setscrew	DIN 915 M6x12	995161	180214
hex head wrench	SW 3x100	985730	166090
magnetic adjusting gauge	1,0 mm	997800	166094
clamping magnet	0,0 mm	997800	016613



For rounding of edge bands

- on edgebanders according to table
- for solid wood and plastic edges
- for right and left hand rotation
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

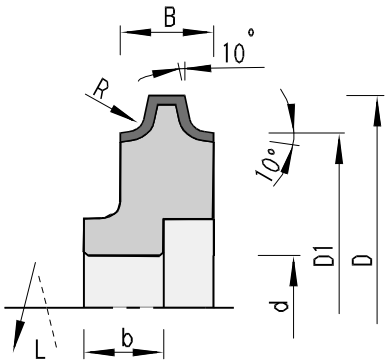
120.102

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No.
2	57	50	12	12	16	5x2,3	2	Holz-Her	170338
3	57	50	12	12	16	5x2,3	2	Holz-Her	170339 #
2	58	50	12	10	16	5x2,3	4	Brandt	177030
3	58	50	12	10	16	5x2,3	4	Brandt	177031
45 degre	57	50	12	12	16	5x2,3	2	Holz-Her	171189 &
2	62	50	16	10	16	5x2,3	2	Holz-Her	179997
3	62	50	16	10	16	5x2,3	2	Holz-Her	169241
5	62	50	16	10	16	5x2,3	2	Holz-Her	169243 &
45 degre	62	50	16	10	16	5x2,3	2	Holz-Her	173379 &
2	73	61	16	11	16	5x2,3	3	Homag	171128
3	73	61	16	11	16	5x2,3	3	Homag	171129
4	73	61	16	11	16	5x2,3	3	Homag	171130 &
5	73	61	16	11	16	5x2,3	3	Homag	171131 &
45 degre	73	61	16	11	16	5x2,3	3	Homag	173380 &
6	81	61	24	11	16	5x2,3	3	Homag	170254 &
8	81	61	24	11	16	5x2,3	3	Homag	170256 &

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	Ident.-No.
9	81	61	24	11	16	5x2,3	3	Homag	170257 &
2	78	70	16	11	16	5x2,3	4	Brandt	182086 &
2	82	70	16	11	16	5x2,3	4	Brandt	170192 &
3	82	70	16	11	16	5x2,3	4	Brandt	170193 &
4	82	70	16	11	16	5x2,3	4	Brandt	170194 &
5	82	70	16	11	16	5x2,3	4	Brandt	170195 &
45 degre	82	70	16	11	16	5x2,3	4	Brandt	172728 &
2	73	61	16	11	20	6x3,5	3	Holz-Her	171132 &
3	73	61	16	11	20	6x3,5	3	Holz-Her	171133 &
4	73	61	16	11	20	6x3,5	3	Holz-Her	171134 &
5	73	61	16	11	20	6x3,5	3	Holz-Her	171135 &
45 degre	73	61	16	11	20	6x3,5	3	Holz-Her	173381 &
2	82	70	16	11	20	6x3,5	4	IMA Wilmsmeyer	166882 &
3	82	70	16	11	20	6x3,5	4	IMA Wilmsmeyer	166881 &
4	82	70	16	11	20	6x3,5	4	IMA Wilmsmeyer	166880 &
5	82	70	16	11	20	6x3,5	4	IMA Wilmsmeyer	166879 &
45 degre	82	70	16	11	20	6x3,5	4	IMA Wilmsmeyer	172729 &

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
for Ø D = 62 / 73 / 82	1,5	16	17,5	2	151545	176583
for Ø D = 58	2	12	13	2	151545	177033
for Ø D = 57	2	12	12	1,5	151545	170340
for Ø D = 81	2	16	15,5	2	151545	182087
for Ø D = 62 / 73 / 82	2	16	17,5	2	151545	163489
for Ø D = 58	3	12	13	2	151545	177032
for Ø D = 57	3	12	12	1,5	151545	170341
for Ø D = 62 / 73 / 82	3	16	17,5	2	151545	163490
for Ø D = 62 / 73 / 82	4	16	17,5	2	151545	163491
for Ø D = 62 / 73 / 82	5	16	17,5	2	151545	163492
for Ø D = 81	6	24	22	2	151545	170258
for Ø D = 81	8	24	22	2	151545	170260
for Ø D = 81	9	24	22	2	151545	170261
for Ø D = 57		12	12	1,5	151545	171190
for Ø D = 62 / 73 / 82	chamfer	16	17,5	2	151545	169292

spare parts and clamping tools	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
clamping strip	B = 10.5	177030	177031		925300	175640
clamping strip	B = 12	170338	170339	171189	925300	170342
clamping strip		179997 169243 171129 173380 171134	169241 173379 171130 171132 171135	 171128 171131 171133 173381	925300	169246
clamping strip	B = 15,6	170192 170195 166881 172729	170193 172728 166880 182086	170194 166882 166879	925300	163488
clamping strip	B = 24	170254 170257	170255	170256	925300	170262
setscrew	DIN 915 M5x12	177030	177031		995161	050565
setscrew	DIN 915 M6x12	170338 179997 169243 171129 173380 170194 171132 171135 166881 182086	170339 169241 173379 171130 170192 170195 171133 173381 166880	171189 172729 171128 171131 170193 172728 171134 166882 166879	995161	180214
setscrew	DIN 915 M8x12	170254 170257	170255	170256	995161	180001
clamping magnet					997800	016613
hex socket head wrench	DIN 911 SW 2,5				985730	009671
hex socket head wrench	DIN 911 SW 3				985730	009672



For rounding of edge bands

- on IMA profiling unit
- on IMA length processing unit
- for solid wood and plastic edges
- for right and left hand rotation
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

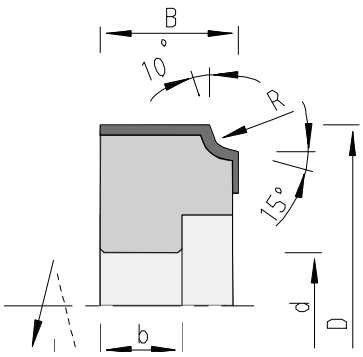
- sense of rotation see drawing

120.102

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
2	82	70	16	13	20	6 x 3,5	4	168373 &	168374 &
3	82	70	16	13	20	6 x 3,5	4	168353 &	168354 &
4	82	70	16	13	20	6 x 3,5	4	168375 &	168376 &
5	82	70	16	13	20	6 x 3,5	4	168377 &	168378 &

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
	chamfer	16	17,5	2	151545	169292
	2	16	17,5	2	151545	163489
	3	16	17,5	2	151545	163490
	4	16	17,5	2	151545	163491
	5	16	17,5	2	151545	163492

spare parts and clamping tools		dimensions			Art.-No.	Ident.-No.
clamping strip	B = 15,6	168373 168354 168377	168374 168375 168376	168353 168376	925300	163488
setscrew	DIN 915 M6x12				995161	180214
hex socket head wrench	DIN 911 SW 3				985730	009672



For rounding of edge bands

- on edgebanders IMA "compact"
- for solid wood and plastic edges
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

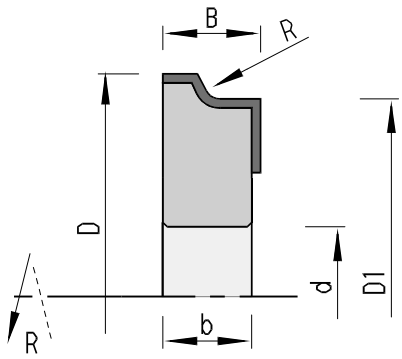
- sense of rotation see drawing

120.102

R mm	Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
3	70	20	12,5	20	6 x 3	4	168359	168360

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
for right hand rotation	3	20	16	2	151555	168356
for left hand rotation	3	20	16	2	151555	168355

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 18	168359	925300	168357
clamping strip	B = 18	168360	925300	168358
setscrew	DIN 915 M6x12		995161	180214
hex socket head wrench	DIN 911 SW 3		985730	009672



For rounding and flush cutting of edge bands

- on edgebanders
  rows 1-3 on Brandt, EBM and Reich machines
  row 4 only for Brandt machines
- for solid wood and plastic edges
- optimum tool balance
- Ident.-No. 173392 and 173393 for Brandt machines
- rows 1-3: cutting edges parallel to cutter axis
  from row 4: cutting edges with shear angle for optimum quality of cut on solid wood edges

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

- sense of rotation acc. to DIN - EN 50144

- same cutter head body for R2 - 3 Ø 56

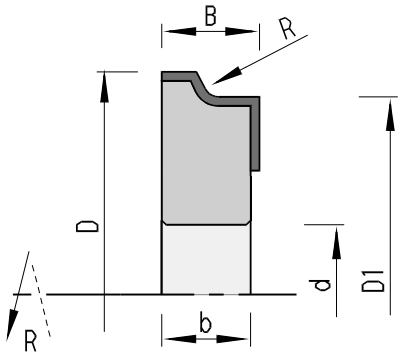
120.102

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
2,0	56	50	12,0	11	16	5 x 2,3	4	172138	172137
3,0	56	50	12,0	11	16	5 x 2,3	4	172140	172139
2,0	56	50	16,0	11	16	5 x 2,3	4	178215	178214
3,0	56	50	16,0	11	16	5 x 2,3	4		178216 #
2,0	78	70	18,5	10	16	5 x 2,3	4	180441	180440
3,0	78	70	18,5	10	16	5 x 2,3	4	173389	173388

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
for right hand rotation	2	12,0	14,5	2	151545	172141
for left hand rotation	2	12,0	14,5	2	151545	172142
for right hand rotation	2	16,1	14	2	151545	178218
for left hand rotation	2	16,1	14	2	151545	178219
for right hand rotation	2,5	12,0	14,5	2	151545	171223
for left hand rotation	2,5	12,0	14,5	2	151545	171224
for right hand rotation	3	12,0	14,5	2	151545	172143

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
for left hand rotation	3	12,0	14,5	2	151545	172144
for right hand rotation	3	16,1	14	2	151545	178220
for left hand rotation	3	16,1	14	2	151545	178221
for right hand rotation	2	19,6	15,2	2	151545	173816
for left hand rotation	2	19,6	15,2	2	151545	173817
for right hand rotation	3	19,6	15,2	2	151545	173392
for left hand rotation	3	19,6	15,2	2	151545	173393

spare parts and clamping tools	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
clamping strip	B = 10 mm	172138 172139	172137	172140	925300	171221
clamping strip	B = 15 mm	178214	178215	178216	925300	178213 o
clamping strip	B = 17 mm	173389 180440	173388	180441	925300	167971
setscrew	DIN 913 M5x10	172138 172139	172137	172140	995161	180028
setscrew	DIN 915 M6x10	173389 180440	173388	180441	995161	180002
setscrew	DIN 915 M6x12	178214	178215	178216	995161	180214
hex socket head wrench	DIN 911 SW 2,5				985730	009671
hex socket head wrench	DIN 911 SW 3				985730	009672



For rounding and flush cutting of edge bands

- on edgebanders Brandt, EBM and Reich machines
- for solid wood and plastic edges
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

- sense of rotation acc. to DIN - EN 50144

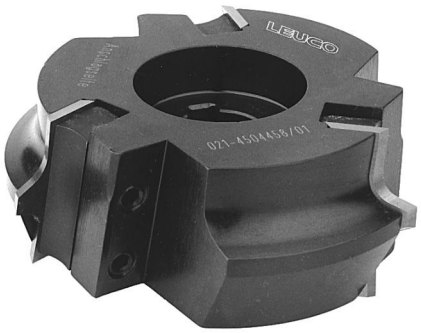
- same cutter head body for R2 - R3

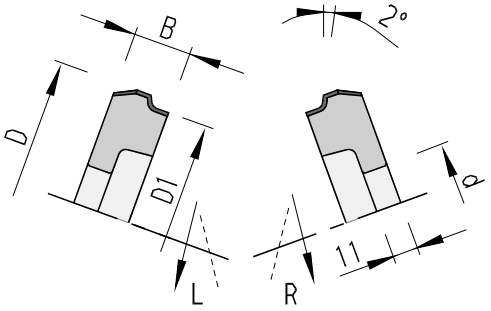
120.102

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
2	56	50	15,0	11	16	5 x 2,3	3	179995	179996
2,5	56	50	15,0	11	16	5 x 2,3	3	177325	177326
3	56	50	15,0	11	16	5 x 2,3	3	177327	177328

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
left hand rotation	2	15,0	14,5	2	151545	177317
right hand rotation	2	15,0	14,5	2	151545	177318
left hand rotation	2,5	15,0	14,5	2	151545	177319
right hand rotation	2,5	15,0	14,5	2	151545	177320
left hand rotation	3	15,0	14,5	2	151545	177321
right hand rotation	3	15,0	14,5	2	151545	177322

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B=13	925300	177332
setscrew	DIN 915 M6x12	995161	180214
clamping magnet	type 2420	997800	016613
hex socket head wrench	DIN 911 SW 3	985730	009672





For rounding of edge bands

- on HOMAG edgebanders during the softforming process
- for solid wood and plastic edges
- optimum tool balance
- cutting edges with shear angle

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

- sense of rotation see drawing

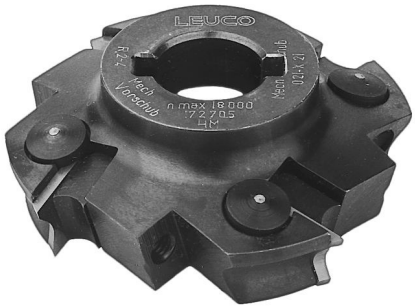
- same cutter head body for R2 - R5
  R5 - R8

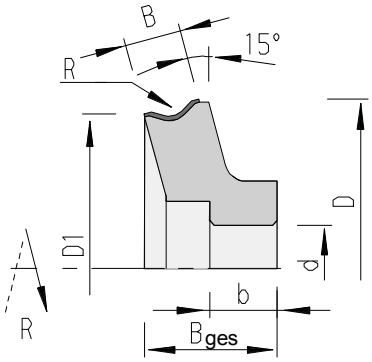
120.102

R mm	Ø D mm	Ø D1 mm	B mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
2	75	66	20,5	16	5x2,3	3	163079 &	163080 &
3	75	66	20,5	16	5x2,3	3	163081 &	163082 &
5	80	66	30,0	16	5x2,3	3	163085 &	163086 &
6	80	66	30,0	16	5x2,3	3	163087 &	163088 &
7	80	66	30,0	16	5x2,3	3	163089 &	163090 &
8	80	66	30,0	16	5x2,3	3	163091 &	163092 &

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
	2	20,5	15	2	151545	163062
	3	20,8	15	2	151545	163063
	5	30,0	17	2	151545	163065
	6	30,5	17	2	151545	163066
	7	30,0	17	2	151545	163067
	8	30,5	17	2	151545	163068

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 18	163079 163080 163081 163082 163095 163096 163099 163100	925300	163077
clamping strip	B = 27.6	163085 163086 163087 163088 163089 163090 163091 163092	925300	163078
setscrew	DIN 915 M6x12		995161	180214
hex head wrench	SW 3x100		985730	166090
hex socket head wrench	DIN 911 SW 3		985730	009672





For rounding of edge bands

- on IMA edgebanders
- for solid wood and plastic edges
- optimum tool balance
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- n max 18.000 min-1
- MEC

- sense of rotation see drawing

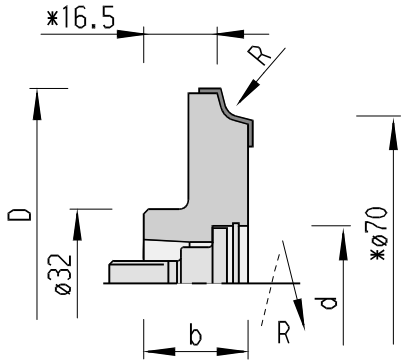
- same cutter head body for R2 - R4

120.102

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Bges mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
4	77,6	70	13	13	13	20	6 x 3,5	4	172712 &	172711 &
3	77,6	70	13	13	13	20	6 x 3,5	4	172710 &	172709 &
2	77,6	70	13	13	13	20	6 x 3,5	4	172708 &	172707 &

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
	4	13	16	2	151555	172715
	3	13	16	2	151555	172714
	2	13	16	2	151555	172713

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 12	172707 172708 172709 172710 172711 172712	925300	162095
setscrew	DIN 915 M6x12		995161	180214
hex socket head wrench	DIN 911 SW 3		985730	009672



For rounding of edge bands " HSK 25R"

- on Homag edgebanders
- for solid wood and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- MEC

- sense of rotation acc. to DIN - EN 50144

- same cutter head body for
  R1,5 - R3

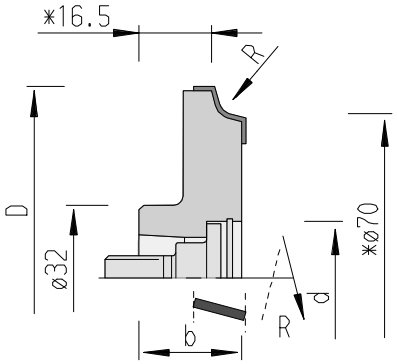
* basic dimensions

120.102

R mm	Ø D mm	b mm	Ø d mm	Z	n max min-1	Ident.-No. L	Ident.-No. R
1,5	79	23	HSK 25R	4	18000	177734 &	177733 &
2	79	23	HSK 25R	4	18000	177736 &	177735 &
2,5	79	23	HSK 25R	4	18000	177738 &	177737 &
3	79	23	HSK 25R	4	18000	177740	177739

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No. L	Ident.-No. R
	1,5	12	17	2	151521	177606	177605
	2	12	17	2	151521	177608	177607
	2,5	12	17	2	151521	177610	177609
	3	12	17	2	151521	177612	177611

spare parts and clamping tools	dimensions		Art.-No.	Ident.-No.
clamping strip	12x11x7	for MK R = 1.5 - 3	925300	177724
screw for HSK25R	M10x1,25x32 SW 8		995190	177780
shim ring	DIN 988 18x25x1,0		995440	177781
locking ring	DIN 472 25x1,2		995460	177782
setscrew	DIN 915 M8x10		995161	001617
hex socket head wrench	DIN 911 SW 3		985730	009672



For rounding of edge bands " HSK 25R"

- on IMA edgebanders
- for solid wood and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- cutting edges with shear angle

- cutting material: HW
  HL Board 06
- MEC

- sense of rotation acc. to DIN - EN 50144

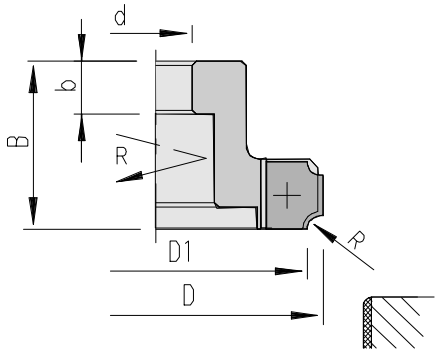
* basic dimensions

120.112

R mm	Ø D mm	b mm	Ø d mm	Z	n max min-1	Ident.-No. L	Ident.-No. R
2	80	23	HSK 25R	4	18000	180170 &	180169 &
3	80	23	HSK 25R	4	18000	180172	180171

profile knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No. L	Ident.-No. R
	2	12	18	2	151586	180174	180173
	3	12	18	2	151586	180176	180175

spare parts and clamping tools	dimensions		Art.-No.	Ident.-No.
clamping strip	12x11x7	left	925300	180255
clamping strip	12x11x7	right	925300	180256
screw for HSK25R	M10x1,25x32 SW 8		995190	177780
shim ring	DIN 988 18x25x1,0		995440	177781
locking ring	DIN 472 25x1,2		995460	177782
setscrew	DIN 915 M6x16		995161	001617
hex socket head wrench	DIN 911 SW 3		985730	009672



For rounding and flush cutting of edge bands

- on edge banders
- for solid wood, veneer and plastic edges
- optimal tool balance
- on part version
- application on EBM and Hebrock machines
  model: form part radius cutter FRF 130
- cutting edges with shear angle

- cutting material: HW
- n max 18.000 min-1
- MAN

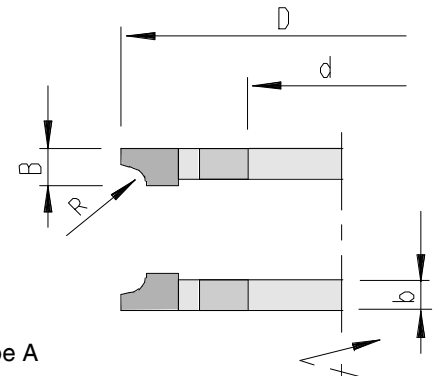
- sense of rotation acc. to DIN - EN 50144

120.115

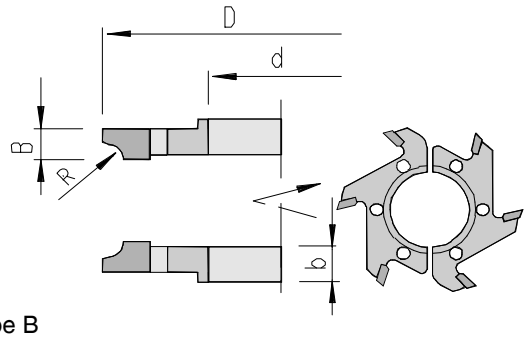
R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	Z	Ident.-No. L	Ident.-No. R
3	74	67	16	12	16	6	783001 s	783003 s

turnover knives	R mm	B mm	H mm	S mm	Art.-No.	Ident.-No.
	2	16	13,5	2	151586	180151
	3	16	13,5	2	151586	180152

spare parts	dimensions	Art.-No.	Ident.-No.
clamping strip		925300	168344
clamping magnet		997800	016613
setscrew	DIN 915 M8x12	995161	180001



Type A



Type B

For rounding and flush cutting of edge bands

- for solid wood, veneer and plastic edges
- optimum tool blance

- Type A:
  - one part version
  - application on IMA machines model BIMA with glueing device and Combiform
  - flush cutting unit 6120, 6121

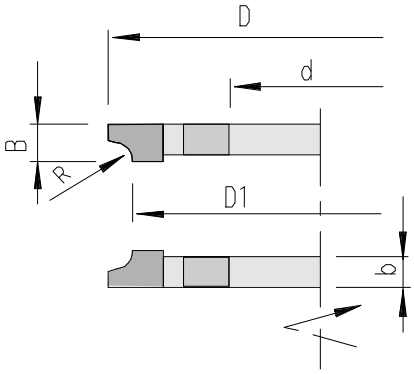
- Type B:
  - two part verion
  - application on IMA machines model BIMA with glueing device
  - flush cutting unit 6135
- cutting edges with shear angle

- cutting material: HW
- n max 18.000 min-1
- MEC

- sense of rotation see drawing

122.110

R mm	Ø D mm	B mm	b mm	Ø d mm	Z	Mach.	Type	Ident.-No. top	Ident.-No. bottom
1	70	6	3,5	30	6	IMA (BIMA)	A	833942 s	833941 s
2	70	6	3,5	30	6	IMA (BIMA)	A	827928 s	827927 s
2,5	70	6	3,5	30	6	IMA (BIMA)	A	658556 s	658555 s
3	70	6	3,5	30	6	IMA (BIMA)	A	823139 s	823140 s
4	70	8	3,5	30	6	IMA (BIMA)	A	827930 s	827929 s
5	70	8	3,5	30	6	IMA (BIMA)	A	827242 s	827236 s
6	70	10	3,5	30	6	IMA (BIMA)	A	827249 s	827248 s
10	74	12	3,5	30	6	IMA (BIMA)	A	720378 s	833943 s
2	70	6	6	30	6	IMA (BIMA)	B	180155	180156
2	70	9	9	30	6	IMA (BIMA)	B	180157	180158
2,5	70	6	6	30	6	IMA (BIMA)	B	708379 s	708378 s
2,5	70	7,6	6	30	6	IMA (BIMA)	B	710972 s	710971 s
3	70	6	6	30	6	IMA (BIMA)	B	180165	180166
3	70	9	9	30	6	IMA (BIMA)	B	180167	180168
4	72	7,5	6	30	6	IMA (BIMA)	B	713621 s	713620 s
5	74	8	6	30	6	IMA (BIMA)	B	711046 s	711045 s



For rounding and flush cutting of edge bands

- for solid wood, veneer and plastic edges
- optimum tool balance
- one part version
- application on Brandt machines model

- D = 96 Brandt spare part No. 2 001-80-510-540
- D = 66 Brandt spare part No. 2 001-80-480-500

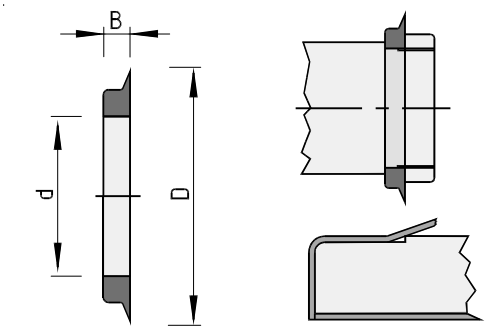
- cutting edges with shear angle

- cutting material: HW
- n max 18.000 min-1
- MEC

- sense of rotation see drawing

122.115

R mm	Ø D mm	Ø D1 mm	B mm	b mm	Ø d mm	Z	Ident.-No. L	Ident.-No. R
2	96	86	8,0	6	40	6	820051 s	820052 s
2,5	96	86	8,0	6	40	6	820053 s	820054 s
3	96	86	8,0	6	40	6	820055 s	820056 s
3,5	96	86	8,0	6	40	6	820057 s	820058 s
2	66	60	6,0	6	16	6	819471 s	819472 s
2,5	66	60	6,0	6	16	6	819473 s	819474 s
3	66	60	6,0	6	16	6	819475 s	819476 s

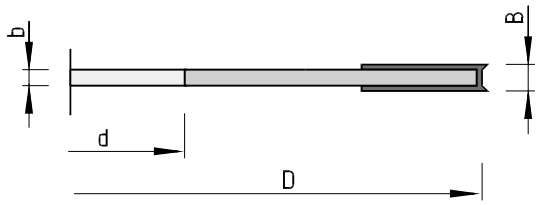


For cutting of softforming inlay profiles

- on HOMAG machines
- LEUCODUR solid carbide circular knife

164.507

Ø D mm	B mm	Ø d mm	Ident.-No.
40	3	25	172757



For chip-free grooving of LAMELLO wood joints

- for solid wood with and across the grain
- for panel materials
- Ident.-No. 164838 for LAMELLO machines n max.= 14.000 min-1
- Ident.-No. 167253 and 165922 for shapers

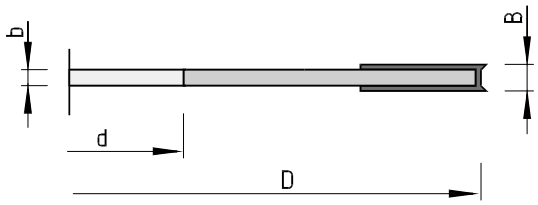
- cutting material: HW
- n = 6.500-11.000 min-1
- MAN "BG - TEST"

120.455

Ø D mm	B mm	b mm	Ø d mm	Ø dmax mm	Z	NL	MAN BG - TEST	mach.	Ident.-No.
100	4	4	22		4 + 4	4/4,5/36	038 - 048	Lamello	164838
125	4	3	30	40	4 + 4		038 - 055		167253
125	5	4	30	40	4 + 4		MAN		165922

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	1,2	150559	163701
spur for B = 4	18	18	1,95	150508	163699
spur for B = 5	18	18	2,5	150508	165906

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
Torx countersunk screw	M4x0,5x3,2 T9	164838 167253	995125	163925
Torx countersunk screw	M4x0,5x4,2 T9	165922	995125	165908
nut for spur	M4x0,5x1,6	165922 167253	995290	163704
nut for TOK	M 4x0,5x2,2	164838 167253	995290	163703
nut for TOK	M 4x0.5x2.75	165922	995290	165907
Torx wrench	T9		985730	164344



For chip-free grooving on table shapers

- for solid wood with and across the grain
- for panel materials

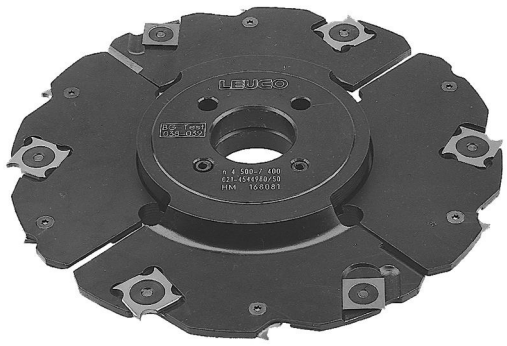
- cutting material: HW
- Ø 125 mm: n = 6.100-10.500 min-1
- Ø 150 mm: n = 5.200- 8.800 min-1
- MAN

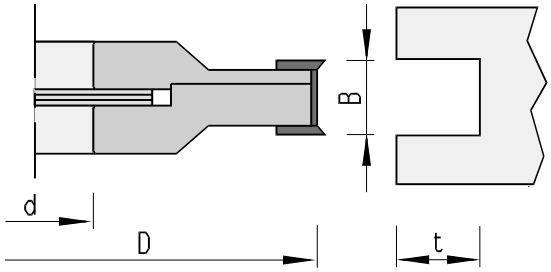
120.455

Ø D mm	B/b mm	Ø d mm	Ø dmax mm	Z	Ident.-No.
125	8	30	50	4 + 8	171159
150	8	30	50	4 + 8	171161
125	10	30	50	4 + 8	171160
150	10	30	50	4 + 8	171162

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	2	150559	003079
raker for B = 8 mm	7,5	12	1,5	150515	052543
raker for B = 10 mm	9,6	12	1,5	150515	171163

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 7,2	171159 171161	925300	168074
clamping strip	B = 8	171160 171162	925300	167255
Torx countersunk screw	M5x6 T20	171159 171160 171161 171162	995125	176199
hexagonal screw driver	SW 2,5x100		985730	168010
Torx wrench	T20x100		985730	166092
adjusting gauge	0,3 mm		985200	055883





For chip-free grooving on stationary machines

- for solid wood with and across the grain
- in uncoated and laminated panel materials
- application on shapers, molders and double-end tenoners
- cutting width 4 - 7.5 mm two-piece
- cutting width 4 - 15 mm three-piece
- cutting width adjustable with shims in .1 mm increments
- single cutter heads and shims secured against rotation with pins

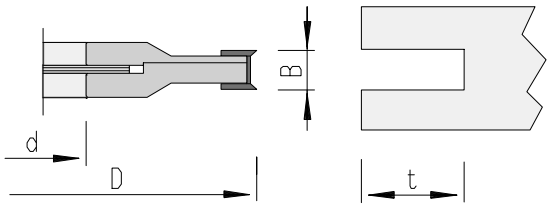
- cutting material: HW
- Ø 130 mm: n = 6.000 - 10.000 min-1
  Ø 160 mm: n = 5.000 - 8.000 min-1
  Ø 180 mm: n = 4.500 - 7.400 min-1
- MAN "BG - TEST"

121.455

Ø D mm	B mm	Ø d mm	DKN mm	Z	t(max)	MAN BG - TEST	Ident.-No.
130	4 - 7,5	30		4 + 4	25	038-039	166509
160	4 - 7,5	30		8 + 4	37	MAN	198425 s
160	4 7,5	30		2		MAN	198426 s
180	4 - 7,5	30		8 + 4	35	038-039	168081
180	4 - 7,5	35	10 x 4	8 + 4	35	038-039	168083
180	4 - 7,5	40	12 x 5	8 + 4	35	038-039	168085
180	4 - 7,5	50		8 + 4	30	038-039	168087
180	4 - 15	30		8 + 2 + 4	35	038-039	168080
180	4 - 15	35	10 x 4	8 + 2 + 4	35	038-039	168082
180	4 - 15	40	12 x 5	8 + 2 + 4	35	038-039	168084

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	1,2	150559	163701
raker	7,5	12	1,5	150515	052543
raker	18	18	1,95	150508	163699

spare parts and clamping tools	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
clamping strip	B = 7,2	168080 198426	168082	168084	925300	168074
setscrew	DIN 915 M5x12	168080 198426	168082	168084	995161	050565
counter key					925200	010751
clamping key					925100	010750
Torx countersunk screw	M4x0,5x3,2 T9	166509 168082 168085	168080 168083 168087	168081 168084 198425	995125	163925
nut for spur	M4x0,5x1,6	166509 168082 168085	168080 168083 168087	168081 168084 198425	995290	163704
nut for TOK	M 4x0,5x2,2	166509 168082 168085	168080 168083 168087	168081 168084 198425	995290	163703
spacers	50x3,5x30	166509			955521	166367
spacers	66x3,5x30	198425 168080	198426	168081	955521	168075
spacers	70x3,5x35	168083	168082		955521	168076
spacers	70x3,5x40	168085	168084		955521	168077
spacers	90x3,5x50	168087			955521	168078
hexagonal screw driver	SW 2,5x100				985730	168010
Torx wrench	T9				985730	164344



For chip-free grooving on stationary machines

- for solid wood with and across the grain
- in uncoated and laminated panel materials
- application on shapers, molders and double-end tenoners
- cutting width 8 - 15 mm + 12,6 - 24 mm two-piece
- cutting width adjustable with shims in 0.1 mm increments
- single cutter heads and spacers secured against rotation with pins

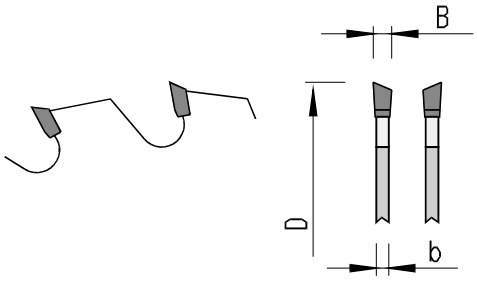
- cutting material: HW
- n = 4.500 - 7.400 min-1
- MAN

121.455

Ø D mm	B mm	Ø d mm	DKN mm	Z	t(max) mm	Ident.-No.
180	8,0 - 15	30		4 + 4	35	178725
180	8,0 - 15	35	10 x 4	4 + 4	35	178726 #
180	8,0 - 15	40	12 x 5	4 + 4	35	178727
180	12,6 - 24	30		4 + 4	40	178729
180	12,6 - 24	35	10 x 4	4 + 4	40	178730 #
180	12,6 - 24	40	12 x 5	4 + 4	40	178731

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	2	150559	003079
raker	7,5	12	1,5	150515	052543
raker	12	12	1,5	150515	003080

spare parts and clamping tools	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
clamping strip	B = 7,2	178725	178726	178727	925300	168074
clamping strip	B = 10	178729	178730	178731	925300	164526
					925100	870829
Torx countersunk screw	M6x0,5x4,9 T20	for spur			995125	178222
setscrew	DIN 915 M5x20				995161	178741
setscrew	DIN 915 M6x20				995161	178742
setscrew					995161	001617
spacers	66x7x30				955521	167282
spacers	70x7x35				955521	167283
spacers	70x7x40				955521	167284
spacers	66x11,5x30				955521	167278
spacers	70x11,5x30				955521	167279
spacers	70x11,5x40				955521	167280
hexagonal screw driver	SW 2,5x100				985730	168010
hex head wrench	SW 3x100				985730	166090
Torx wrench	T20x100				985730	166092
wrench with spinner handle					985730	171188
adjusting gauge	0,3 mm				985200	055883



For chip-free grooving of LAMELLO wood joints

- for solid wood with and across the grain
- in panel materials
- application on LAMELLO and ELU machines for biscuit joints

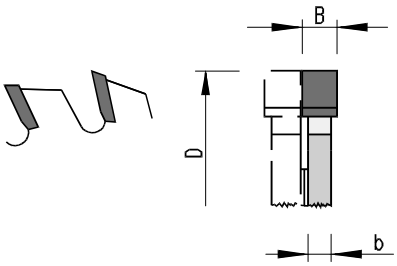
- cutting material: HW
- MAN "BG - TEST"

109.085

Ø D mm	B mm	b mm	Ø d mm	Z	NL	MAN BG - TEST	mach.	n = min-1	Ident.-No.
100	3,95	3,45	22	6 WS	4/4,5/36	038-078	Lamello	7600-13000	189095

109.025

Ø D mm	B mm	b mm	Ø d mm	Z	MAN BG - TEST	mach.	n = min-1	Ident.-No.
102	3,85	3	22	12 WS	038-078	ELU DS 140	7500-13100	188358



For chip-free grooving on stationary machines

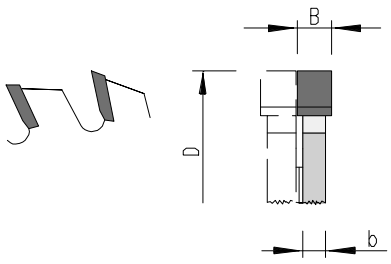
- in solid wood with the grain
- in solid wood across the grain with feed
- in uncoated and laminated panel materials with feed
- application on molders and double-end tenoners
- for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
  Groove width calculation for tool sets:
  sum of all "b" + HW overlap left and right + shim thickness

- cutting material: HW
- MEC

109.010

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	n max min-1	Ident.-No.
150	4	3	30		12	12700	160802
150	5	4	30		12	12700	001434
150	5	4	35	10x4	12	12700	001435 &
150	6	4	30		12	12700	161617
150	7	5	30		12	12700	161619
150	8	5	30		12	12700	161620
150	10	6	30		12	12700	161622
150	10	6	35	10x4	12	12700	161623 &
150	1,5	0,8	35	10x4	18	12700	001447
150	1,8	1	35	10x4	18	12700	001448
150	2	1,2	35	10x4	18	12700	001449
150	2,2	1,2	35	10x4	18	12700	001450
150	2,5	1,5	35	10x4	18	12700	001451
150	3	2	35	10x4	18	12700	001452
150	4	3	35	10x4	18	12700	001453

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	n max min-1	Ident.-No.
150	5	4	35	10x4	18	12700	001454
150	6	4	35	10x4	18	12700	161627
150	8	5	35	10x4	18	12700	161628
150	4	3	30		24	12700	169689
150	5	4	30		24	12700	169688
150	6	4	30		24	12700	169687
150	4	3	30		48 WS	12700	160804
180	4	3	30		12	10300	001442
180	5	4	30		12	10300	001443
180	6	4	30		12	10300	161624
180	8	5	30		12	10300	161625
180	10	6	30		12	10300	161626
180	4	3	30		18	10300	169685
180	5	4	30		18	10300	169684
180	8	5	30		18	10300	169683
180	10	6	30		18	10300	169682
196	6	5	30		12 WS	9600	163836



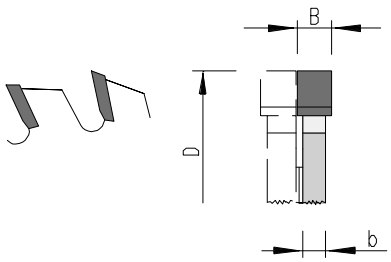
For grooving on double end tenoners

- for solid wood, panel boards and MDF materials
- cutting width 7,0-10,0 mm possible with body thickness of 5,0 mm
- cutting width 4,0-6,5 mm possible with body thickness of 3,0 mm
- Ident.-No. will be changed when entering the order in the SAP
- short delivery time
- rework possible:
  -enlargement of bore
  -produce pin holes and keyways
  -chose cutting width and tooth geometry

- cutting material: HW
- MEC

109.010

Ø D mm	B mm	b mm	Ø d mm	Z	Ident.-No.
220	4	3	30	30	1521934 s
220	4,5	3	30	30	1521935 s
220	5	3	30	30	1521936 s
220	5,5	3	30	30	1521937 s
220	6	3	30	30	1521938 s
220	6,5	3	30	30	1521939 s
220	7	5	30	30	1521941 s
220	7,5	5	30	30	1521942 s
220	8	5	30	30	1521943 s
220	8,5	5	30	30	1521944 s
220	9	5	30	30	1521945 s
220	9,5	5	30	30	1521946 s
220	10	5	30	30	1521947 s



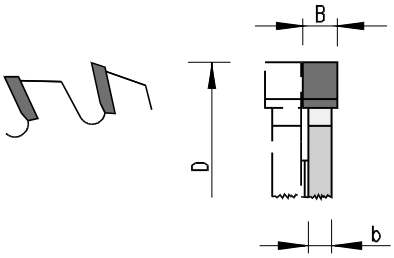
For grooving on double end tenoners

- for solid wood, panel boards and MDF materials
- cutting width 4,0-6,5 mm possible with body thickness of 2,8 mm
- cutting width 7-10 mm possible with body thickness of 5,0 mm
- Ident.-No. will be changed when entering the order in the SAP
- short delivery time
- rework possible:
  -enlargement of bore
  -produce pin holes and keyways
  -chose cutting width and tooth geometry

- cutting material: HW
- MEC

109.010

Ø D mm	B mm	b mm	Ø d mm	Z	Ident.-No.
200	4	2,8	30	24	1527332 s
200	4,5	2,8	30	24	1527333 s
200	5	2,8	30	24	1527334 s
200	5,5	2,8	30	24	1527335 s
200	6	2,8	30	24	1527336 s
200	6,5	2,8	30	24	1527337 s
200	7	5	30	24	1527339 s
200	7,5	5	30	24	1527340 s
200	8	5	30	24	1527341 s
200	8,5	5	30	24	1527342 s
200	9	5	30	24	1527343 s
200	9,5	5	30	24	1527344 s
200	10	5	30	24	1527345 s



For chip-free grooving on shapers

- in solid wood with the grain
- in uncoated and laminated panel materials with feed (only with MEC)
- application on shapers against feed
- for Z = 12 and Z = 18 other groove widths are possible when tools are assembled as a set
  Groove width calculation for tool sets:
  sum of all "b" + HW overlap left and right
  + shim thickness

- cutting material: HW
- MAN "BG - TEST"

109.015

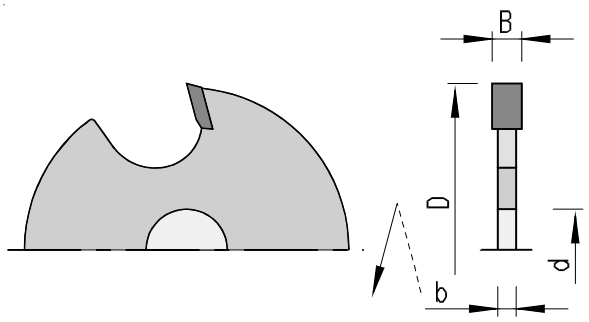
Ø D mm	B mm	b mm	Ø d mm	Z	n = min-1	MAN BG - TEST	Ident.-No.
125	1,5	0,8	30	12	6100-10500	038-038	188359
125	1,8	1	30	12	6100-10500	038-038	188360
125	2	1,2	30	12	6100-10500	038-038	188361
125	2,2	1,2	30	12	6100-10500	038-038	188362
125	2,5	1,4	30	12	6100-10500	038-038	188363
125	3	2	30	12	6100-10500	038-038	188364
125	3,5	2,5	30	12	6100-10500	038-038	188365
125	4	2,5	30	12	6100-10500	038-038	188366
125	4,5	3	30	12	6100-10500	038-038	188367
125	5	4	30	12	6100-10500	038-038	188368
125	6	4	30	12	6100-10500	038-038	188369
125	7	5	30	12	6100-10500	038-038	188370
125	8	5	30	12	6100-10500	038-038	188371
125	10	6	30	12	6100-10500	038-038	188372
150	1,5	0,8	30	12	5200-8800	038-038	188373

Ø D mm	B mm	b mm	Ø d mm	Z	n = min-1	MAN BG - TEST	Ident.-No.
150	2	1,2	30	12	5200-8800	038-038	188375
150	2,2	1,2	30	12	5200-8800	038-038	188376
150	2,5	1,5	30	12	5200-8800	038-038	188377
150	3	2	30	12	5200-8800	038-038	188378
150	3,5	2,5	30	12	5200-8800	038-038	188379
150	4	3	30	12	5200-8800	038-038	188380
150	4,5	3,5	30	12	5200-8800	038-038	188381
150	5	4	30	12	5200-8800	038-038	188382
150	6	4	30	12	5200-8800	038-038	188383
150	7	5	30	12	5200-8800	038-038	188384
150	8	5	30	12	5200-8800	038-038	188385
150	9	6	30	12	5200-8800	038-038	188386
150	10	6	30	12	5200-8800	038-038	188387

For grooving in solid woods and panel materials with portable routers

- 2 flat tooth cutting edges, brazed
- clamping elements: cutter arbor

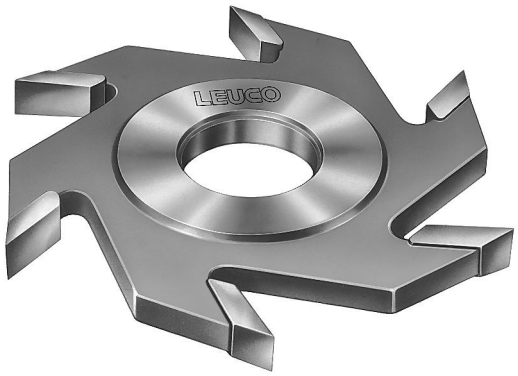
- cutting material: HW
- n max 18.000 min-1
- MAN

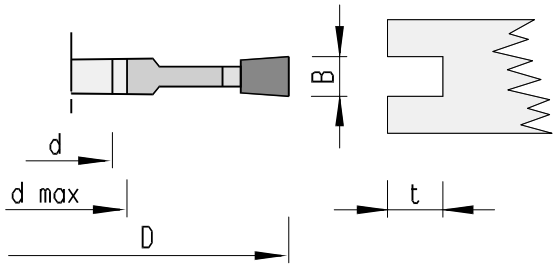


109.015

Ø D mm	Ø d mm	B mm	b mm	Z	Ident.-No.
40	8	1,8	1,0	2	001367
40	8	2	1,2	2	001370
40	8	2,5	1,5	2	001374
40	8	3	2,0	2	001377
40	8	3,5	2,5	2	001380
40	8	4	3,0	2	001383

accessories	dimensions	Art.-No.	Ident.-No.
Arbor	8x8	997200	160363





For chip-free grooving on stationary machines

- in solid wood with the grain
- in uncoated and laminated panel materials with feed
- application on molders and double-end tenoners
- cutting width = hub width

- cutting material: HW
- n max = 10.000 min-1
- MEC

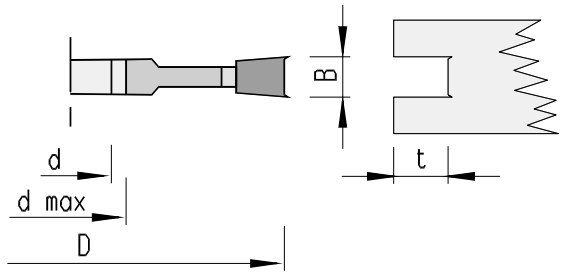
122.405

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	t(max) mm	Ident.-No.
140	8	30	50	6	33	198051 s
140	10	30	50	6	33	198052 s

For chip-free grooving on stationary machines

- in solid wood with and across the grain
- in uncoated and laminated panel materials with feed
- application on shapers against feed
- application on molders
- cutting width = hub width

- cutting material: HW or HS
- n = 5.400 - 9.000 min-1
- MAN

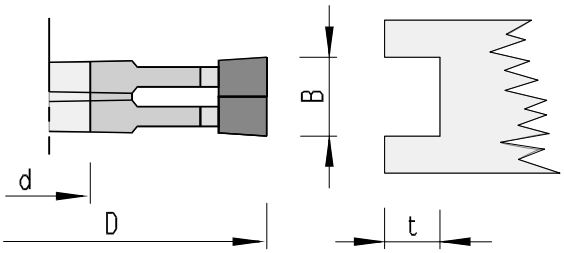


HW 122.455

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	t(max)	Ident.-No.
140	4	30	50	4 + 4	33	198032 s
140	5	30	50	4 + 4	33	198033 s
140	6	30	50	4 + 4	33	198034 s
140	8	30	50	4 + 4	33	198035 s
140	10	30	50	4 + 4	33	198036 s

HS 322.455

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	t(max)	Ident.-No.
140	8	30	50	4 + 4	33	198038 s
140	10	30	50	4 + 4	33	198039 s



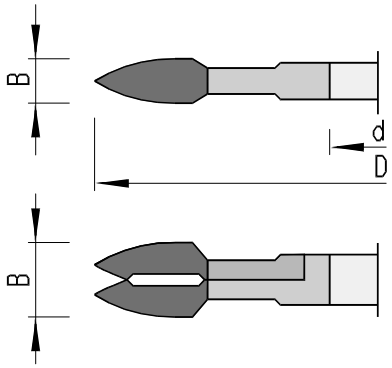
For chip-free grooving on stationary machines

- in solid wood with the grain
- in uncoated and laminated panel materials with feed
- application of shapers against feed
- application on molders and double-end tenoners
- cutting width adjustable with shims in 0.1 mm increments

- cutting material: HW
- MAN

123.455

Ø D mm	B mm	Ø d mm	KN mm	Z	t(max) mm	n = min-1	BG-Test	Ident.-No.
120	1,8 - 3,4	30		4 + 4	18	6400-10000	038-026	006188
120	2,2 - 4	30		4 + 4	18	6400-10000	MAN	006189
140	2,2 - 4	30		4 + 4	20	5400-9000	MAN	171136 #
150	4,0 - 7,5	30		4 + 4	37	5200-9000	MAN	006190
150	4,0 - 7,5	35	10x4	4 + 4	30	5200-9000	MAN	006195
150	7,5 - 14,5	30		4 + 4	37	5200-9000	MAN	006191
200	5,2 - 10	30		8 + 8	40	3800-7200	038-026	160018 #
250	5,2 - 10	30		8 + 8	40	3000-5500	MAN	006192 #



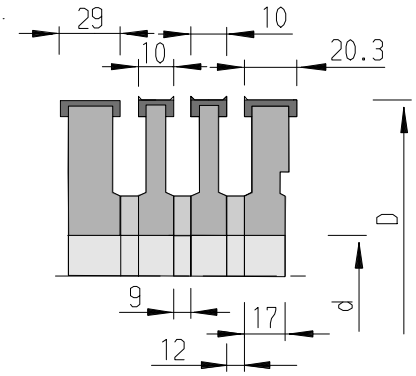
For cutting out defects in solid woods

- for use on Mini-Spot machines
- for patch sizes 1-4
- cutting edges with alternating shear angle

- cutting material: HW
- n = 12 000 min-1
- MAN

122.415

Ø D mm	B mm	Ø d mm	Z	NL	for patch size	Ident.-No.
100	8	22	4	4/4,3/36	1 - 3	180469
100	14	22	4		DUO	70176331 o
100	15	22	4		4	70176420 o



For cutting of guide grooves in solid wood

- for WEINIG molders with groove bed section
- in solid wood with the grain
- single tools with spur
  180536 without spur

- cutting material: HW
- n max 10.000 min-1
- MEC

- Note:
  replacement parts for old cutter head sets:
  cutter head width = 9mm can be replaced with new cutter head width = 10mm when spacer width = 10 mm is replaced with spacer width = 9 mm
  cutter head width = 10.5mm can be replaced with cutter head width = 10mm

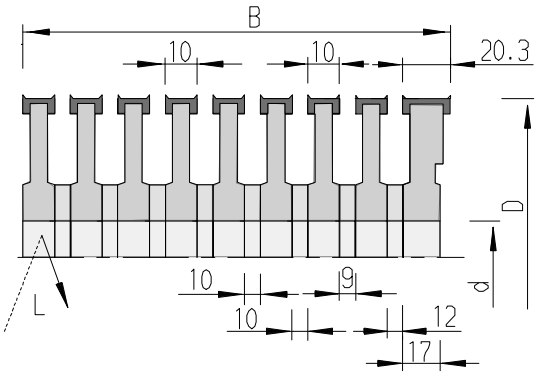
120.450

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
140	10	40	2 + 2	176066
140	20,3	40	2 + 2	176067
140	29	40	2	180536 s
140	10	50	2 + 2	176069
140	20,3	50	2 + 2	176070

spacers	Ø D mm	B mm	Ø d mm	Art.-No.	Ident.-No.
spacer	70	9	40	955520	177308
spacer	70	10	40	955520	162004
spacer	70	12	40	955520	162706
spacer	70	10	50	955520	163886
spacer	70	12	50	955520	163887

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	2	150559	003079
raker	9,6	12	1,5	150515	171163
turnover knife	20	12	1,5	150515	003082
turnover knife	29,5	12	1,5	150515	180825

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 7,2	176066 176069	925300	168074
setscrew	DIN 915 M5x12	176066 176069	995161	050565
Torx countersunk screw	M5x6 T20	176066 176069	995125	176199
adjusting gauge	0,7 mm	176066 176069	985200	056096
clamping strip	B = 17 mm	176067 176070	925300	167971
setscrew	DIN 915 M8x16	176067 176070 180536	995161	164422
Torx countersunk screw	M5x10,8 T15	176067 176070	995125	180840
adjusting gauge	1,0	176067 176070 180536	985200	011103 o
clamping strip	B = 27,5	180536	925300	164185
hexagonal screw driver	SW 2,5x100		985730	168010
hex head wrench	SW 4x100		985730	166091
Torx wrench	T15x100		985730	180470
screwdriver	8 mm		985730	053874



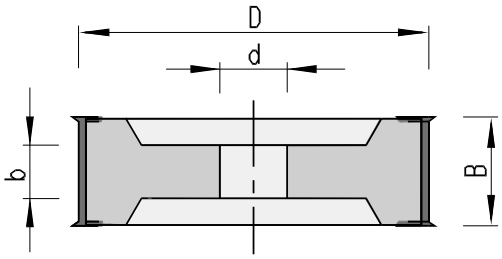
For cutting of guide grooves on molders

- for WEINIG molders with groove bed section
- in solid wood with the grain
- complete tool sets for specific wood widths "B"

- cutting material: HW
- n max = 10.000 min-1
- MEC

121.450

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
140	80	35	2 +2	176071 &
140	100	35	2 +2	176072 &
140	120	35	2 +2	176073 &
140	140	35	2 +2	176074 &
140	170	35	2 +2	176075 &
140	80	40	2 +2	176076 &
140	100	40	2 +2	176077 &
140	120	40	2 +2	176078 &
140	140	40	2 +2	176079 &
140	170	40	2 +2	176080 &
140	80	50	2 +2	176081 &
140	100	50	2 +2	176082 &
140	120	50	2 +2	176083 &
140	140	50	2 +2	176084 &
140	170	50	2 +2	176085 &



For jointing and rabbeting on stationary machines

- in solid wood with the grain
- in uncoated panel materials
- aplication on molders and double-end tenoners
- cutting edges parallel to cutter axis

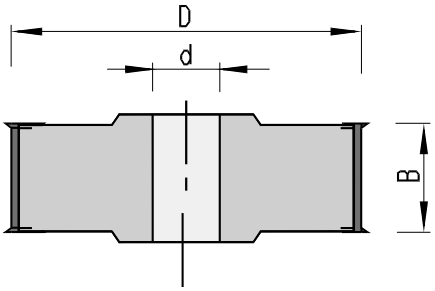
- cutting material: HW
  HL Board 05
- n max. = 8.000 min-1
- MEC

120.250

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No.
180	50	20	35	10 x 4	4 + 4	167060
180	50	20	40	12 x 5	4 + 4	167061

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	2	150559	003079
turnover knife	50	12	1,5	150515	003085

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B = 48	925300	166984
setscrew	DIN 915 M6x12	995161	180214
Torx countersunk screw	M5x10,8 T15	995125	180840
hex head wrench	SW 3x100	985730	166090
Torx wrench	T15x100	985730	180470
adjusting gauge	1,0	985200	011103 o



For jointing and rabbeting on stationary machines

- in solid wood with the grain
- in uncoated panel materials
- application on shapers
- cutting edges parallel to cutter axis

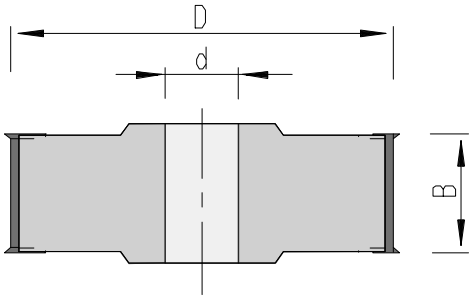
- cutting material: HW
  HL Board 05
- MAN

120.255

Ø D mm	B mm	Ø d mm	DKN mm	Z	n = min-1	Ident.-No.
85	50	30		2 + 4	9000-15000	167038
100	30	30		2 + 4	8000-15000	167039
100	50	30		2 + 4	8000-15000	167040
125	30	30		2 + 4	6500-12000	167041
125	50	30		2 + 4	6500-12000	167043
125	50	35	10 x 4	2 + 4	6500-12000	167044 &
125	50	30		4 + 4	6500-12000	167046
125	50	35	10 x 4	4 + 4	6500-12000	167047 &
125	50	40	12 x 5	4 + 4	6500-12000	167048

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
spur	14	14	2	150559	003079
turnover knife	30	12	1,5	150515	003083
turnover knife	50	12	1,5	150515	003085

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 27,5	167039 167041	925300	164185
clamping strip	B = 48	167038 167040 167043 167044 167046 167047 167048	925300	166984
setscrew	DIN 915 M6x12	167038 167040	995161	180214
setscrew	DIN 915 M6x16	167039 167041 167043 167044 167046 167047 167048	995161	001617
Torx countersunk screw	M5x10,8 T15		995125	180840
hex head wrench	SW 3x100		985730	166090
Torx wrench	T15x100		985730	180470
adjusting gauge	1,0		985200	011103 o



For jointing and rabbeting

- in panel materials with and without veneer or with plastic coating, condensed woods, glued woods and highly abrasive hard woods
- application on table shapers
- for chip-free jointing of panel materials coated on both sides
- body made of high-quality light-metal alloy
- face shear angles from above and below

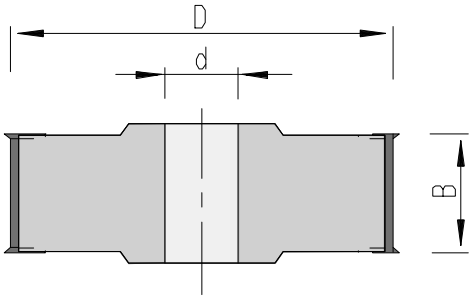
- cutting material: HW
  HL Board 05
- MAN

120.265

Ø D mm	B mm	Ø d mm	Z	n = min-1	Ident.-No.
140	60	30	4 + 4	5400-9400	179180

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
turnover knife	50	12	1,5	150515	003085
spur	14	14	2	150559	003079

spare parts and clamping tools		dimensions		Ident.-No.
clamping strip		6x11x48	925300	180346
clamping part		M8	925100	180357
clamping setscrew		M8x26 SW4	995161	180340
countersunk screw	for spur	M5x11 T15	995125	180633
hex head wrench		SW 4x100	985730	166091
wrench with spinner handle		T15x80	985730	171188



For rabbeting of high-quality cutting edges

- for veneered or coated materials
- application on table shapers
- maximum profile depth 30 mm
- body made of aluminum
- cutting edges parallel to cutter axis

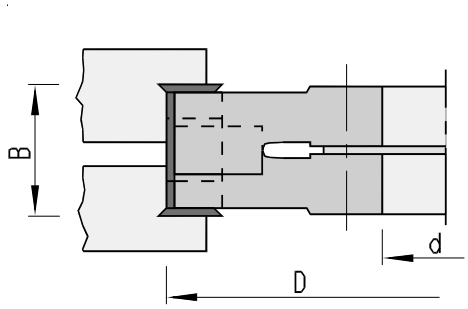
- cutting material: HW
  HL Board 05
- MAN

120.265

Ø D mm	B mm	Ø d mm	Z	n = min-1	Ident.-No.
125	44	30	2 + 2	6100-10500	179181

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
turnover knife	49,6	11,8	1,5	151567	179330
spur	14	14	2	150559	003079

spare parts and clamping tools		dimensions		Ident.-No.
clamping strip		6x11x48	925300	180632
clamping part		M8	925100	180357
clamping setscrew		M8x26 SW4	995161	180340
countersunk screw	for spur	M5x11 T15	995125	180633
hex head wrench		SW 4x100	985730	166091
wrench with spinner handle		T15x80	985730	171188



For rabbeting and grooving on stationary machines

- in solid wood with the grain
- in uncoated panel materials
- application on shapers
- rabbeting depth to 43 mm possible
- cutting width adjustable with shims in .1 mm increments
- cutting edges parallel to cutter axis

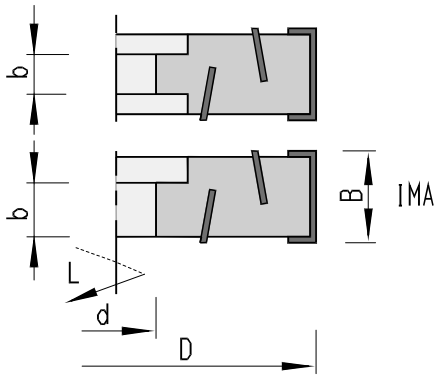
- cutting material: HW
  HL Board 05
- MAN

121.255

Ø D mm	B mm	Ø d mm	Z	n = min-1	Ident.-No.
160	26,4 - 40,0	30	4 + 4	4800-8200	168005
160	36,4 - 60,0	30	4 + 4	4800-8200	168007

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
turnover knife	20	12	1,5	150515	003082
turnover knife	30	12	1,5	150515	003083
spur	14	14	2	150559	003079

spare parts	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 17 mm	168005	925300	167971
clamping strip	B = 26,6	168007	925300	167885
adjusting gauge	1,0		985200	011103 o
Torx countersunk screw	M5x10,8 T15		995125	180840
setscrew	DIN 915 M8x20		995161	001625
Torx wrench	T15x100		985730	180470
hex head wrench	SW 4x100		985730	166091



For chip-free jointing of plastic laminated panel materials

- cutting edges with opposing shear angle for chip-free edges
- cutting material: HW
  HL Board 05

- Art.-No. 120.210:
  application on double-end tenoners and edgebanders

- MEC

- Art.-No. 120.215:
  application on shapers

- MAN

120.210

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	n max min-1	Ident.-No.
100	34	35	30	8x3	2 x 3		15000	171971
100	56	40,5	30	8x3	2 x 3	IMA	15000	L 173594
100	56	40,5	30	8x3	2 x 3	IMA	15000	R 173593
100	56	56	30	8x3	2 x 3	Brandt	15000	173636
150	35	35	30	8x3	2 x 3		10000	171191
180	56	25	35	10x4	2 x 3		8000	177002

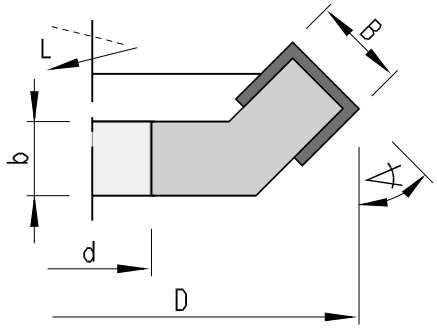
120.215

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	n = min-1	Ident.-No.
100	34	35	30	8x3	2 x 3	7700-13400	171972
125	56	56	30	8x3	2 x 3	6500-10000	177004
150	56	56	30	8x3	2 x 3	5200-8900	177006

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	20	12	1,5	150515	003082
	30	12	1,5	150515	003083

spare parts for clamping by clamping stri	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
clamping strip	B = 17 mm	171191	191971	171972	925300	167971
clamping strip	B = 27,5	173593	173594	173636	925300	164185
setscrew	DIN 915 M8x12	171191	171971	171972	995161	180001
setscrew	DIN 915 M6x12	173593	173594	173636	995161	180214
hex head wrench	SW 3x100				985730	166090
hex head wrench	SW 4x100				985730	166091
magnetic adjusting gauge	1,0	173593	173594	173636	997800	166094

spare parts for radial clamping	dimensions	for Ident.-No.			Art.-No.	Ident.-No.
pressure jaw	28x11x6	177002 177006	177003	177004	925300	180344
clamping part	12x8,5/M6L	177002 177006	177003	177004	925100	180356
clamping setscrew	M6/M6Lx18				995161	180338
wrench with spinner handle	T15x80				985730	171188



For chamfering of solid wood and panel materials on stationary machines

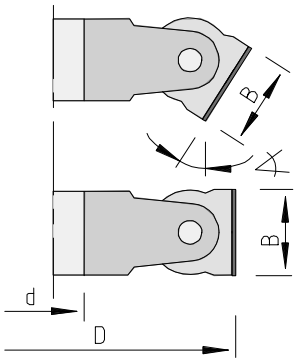
- application on shapers
- cutting edges parallel to cutter axis
- cutting material: HW
  HL Board 05
- MAN
- sense of rotation acc. to DIN - EN 50144

120.325

Ø D mm	B mm	b mm	Ø d mm	Z	chamfer a. in degr.	n = min-1	Ident.-No. L	Ident.-No. R
140	12	12	30	2	45	5500-10000	164970	164969

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	12	12	1,5	150515	003080

spare parts and clamping tools	dimensions	for Ident.-No.		Art.-No.	Ident.-No.
clamping strip	B = 10	164969	164970	925300	162106
setscrew	DIN 915 M8x20	164969	164970	995161	001625
hex head wrench	SW 4x100			985730	166091



For chamfering, jointing and rabbeting with adjustable chamfer angle

- rabbeting with additional spur
- in solid woods and panel materials veneered and plastic coated
- application on table shapers, molding machines and double-end tenoners
- pivot range up to 60 degree
  -D=120 adjustable from 5 degree to 5 degree,
  -D=150 adjustable from 1 degree to 1 degree
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 05
- MAN

120.305

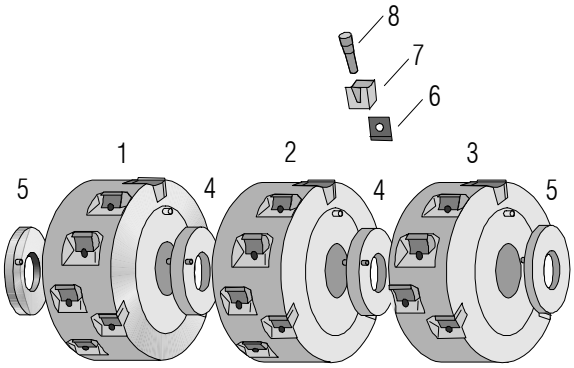
Ø D mm	B mm	Ø d mm	Z	n max min-1	Ident.-No.
120	40	30	2	6400-11000	179184
150	50	30	2	5200-9000	179185
150	50	40	2	5200-9000	180903
160	50	50	2	4800-8000	180904

scoring disc 120.255

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
150	8	30	2	179182

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
turnover knife	40	12	1,5	150515	164078
turnover knife	50	12	1,5	150515	003085
spur	14	14	2	150559	003079

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B=40	925300	76930125 o
clamping strip	B=50	925300	76930124 o
spur screw	M5x7	995115	76930310 o
setscrew	DIN 915 M6x16	995161	001617



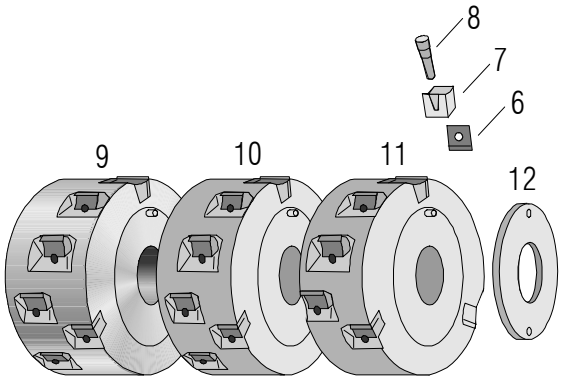
For rough-planing and copying shaping with reduced cutting pressure

- for soft, hard and exotic woods
- for engineered and high-density woods e.g. for manufacturing of skis
- application on profilers and molders
- spiral knife arrangement ensures low cutting pressures
- clamping elements are nickel-plated to prevent pitch build-up
- modular system allows for variation of the cutting width
  consistent spiral cutting edge arrangement
- bore adjustable from 30 - 50 mm with precision reducing bushings
- pins secure cutter heads against rotation

- cutting material: HW
  HL Board 05
- MEC

120.700

Ø D mm	B mm	Ø dmax mm	Z	n max min-1	No.	Ident.-No.
125	40	50	3 x 4	12000	3	875519 o
125	50	50	3 x 5	12000	2	875518 o
125	60	50	3 x 6	12000	1	875517 o
140	40	50	3 x 4	10000	3	875522 o
140	50	50	3 x 5	10000	2	875521 o
140	60	50	3 x 6	10000	1	875520 o
160	40	50	3 x 4	8000	3	875525 o
160	50	50	3 x 5	8000	2	875524 o
160	60	50	3 x 6	8000	1	875523 o



For rough-planing and profiling with lowest cutting pressure

- for soft, hard and exotic woods
- for engineered and high-density woods e.g. for manufacturing of skis
- application on profilers and molders
- spiral knife arrangement ensures low cutting pressures
- clamping elements are nickel-plated to prevent pitch build-up
- modular system allows for variation of the cutting width
  consistent spiral cutting edge arrangement
- pins secure cutter heads against rotation

- cutting material: HW
  HL Board 05
- MEC

120.700

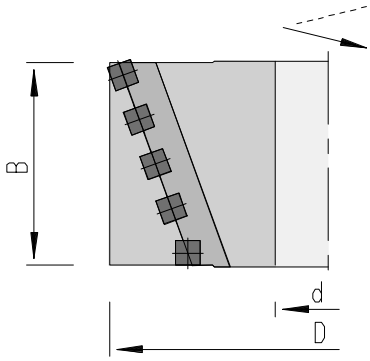
Ø D mm	B mm	Ø d mm	Z	n max min-1	No.	Ident.-No.
100	40	50	3 x 4	12000	11	877077 o
100	40	40	3 x 4	12000	11	877074 o
100	40	35	3 x 4	12000	11	877071 o
100	40	30	3 x 4	12000	11	877068 o
100	50	50	3 x 5	12000	10	877076 o
100	50	40	3 x 5	12000	10	877073 o
100	50	35	3 x 5	12000	10	877070 o
100	50	30	3 x 5	12000	10	877067 o
100	60	50	3 x 6	12000	9	877075 o
100	60	40	3 x 6	12000	9	877072 o
100	60	35	3 x 6	12000	9	877069 o
100	60	30	3 x 6	12000	9	877066 o

	Ø D mm	B mm	Ø d mm	No.	Ident.-No.
end plate	68	5	30	12	876215 o
end plate	68	5	35	12	876216 o
end plate	68	5	40	12	876217 o
end plate	68	5	50	12	876218 o
cover	74	11,3	30	5	875516 o
boring ring	74	21,6	30	4	875512 o
cover	74	11,3	35	5	875515 o
boring ring	74	21,6	35	4	875511 o
cover	74	11,3	40	5	875514 o
boring ring	74	21,6	40	4	875510 o
cover	74	11,3	50	5	875513 o
boring ring	74	21,6	50	4	875509 o

150.514

turnover knife	B mm	H mm	S mm	No.	Ident.-No.
	12	12	1,5	6	003080

spare parts and clamping tools	dimensions	No.	Art.-No.	Ident.-No.
clamping strip	B = 10	7	925300	872530 o
conical screw	M 6	8	995111	178286
hex head wrench	SW 5x150		985730	168703



For machining of solid wood and panel materials

- for jointing, planing, rough-cutting, finish cutting
- for use on moulders and stationary milling centers
- with four-sided turnover knives, with rounded edges
- for finished cut
- spiral cutting layout of turnover knives and cut division
- easy hogging, low cutting pressure and low noise level
- constant diameter
- aluminum body

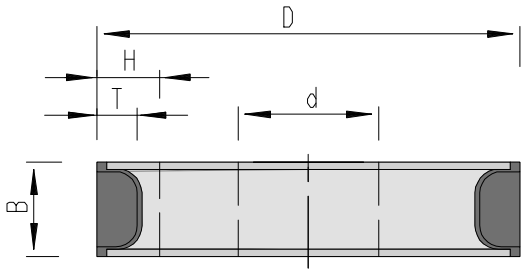
- cutting material: HW
- MEC

120.700

Ø D mm	B mm	Ø d mm	Z	tipping TOK	n max min-1	Ident.-No
125	100	40	2 + 2	20	12000	182091 o
125	130	40	2 + 2	26	12000	182092 o
125	170	40	2 + 2	34	12000	182093 o
125	230	40	2 + 2	46	12000	182094 o
125	240	40	2 + 2	48	12000	182095 o

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
TOK (with rounded edges)	15	15	2,5	150518	180454

spare parts and clammping tools	dimensions	Art.-No.	Ident.-No.
Torx countersunk screw	M5x15,5 T20	995125	182112
Torx wrench	T20x100	985730	166092



For profiling of solid woods and panel materials

- application on shapers
- profile knife can be profiled per customer specifications
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- n = 6.200 - 10.700 min-1
- MAN "BG - TEST" 038-062

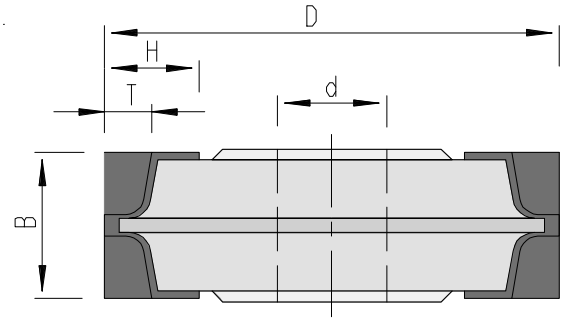
- included in delivery: cutter head with clamping elements, without profile knives, support and deflector plates

120.607

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	T(max) mm	drawing foil	Ident.-No.
125	40	30	35	2	13	SP 1	167263
125	60	30	35	2	15	SP 2	167264

blanks	B mm	H mm	LEUCODUR	drawing foil	Art.-No.	Ident.-No.
support plate	40,6	28,2	HL Board 06	SP 1	152526	179112
SP-blank	40,6	28,2	HL Solid 60	SP1	152529	177367
support plate	60,8	30,2	HL Board 06	SP 2	152526	179113
SP-blank	60,8	30,2	HL Solid 60	SP2	152529	177368
support plate	40,0	28		SP 1	925402	178007
support plate	60,0	30		SP 2	925402	178008
deflector plate	40,0	28		SP 1	925407	167267
deflector plate	60,0	30		SP 2	925407	167268

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 36	167263	925300	166737
clamping strip	B = 58	167264	925300	166738
setscrew	M8x24		995191	167269
hex head wrench	SW 4x100		985730	166091



For profiling of solid woods and panel materials

- application on shapers
- profile knife can be profiled per customer specifications
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- n = 6.200 - 10.700 min-1
- MAN "BG - TEST" 038-066

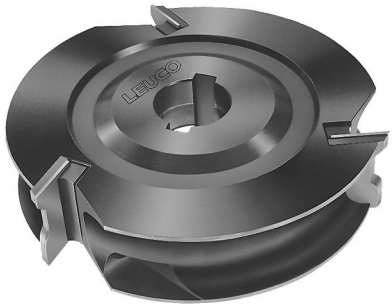
- included in delivery: cutter head with clamping elements, without profile knives, support and deflector plates

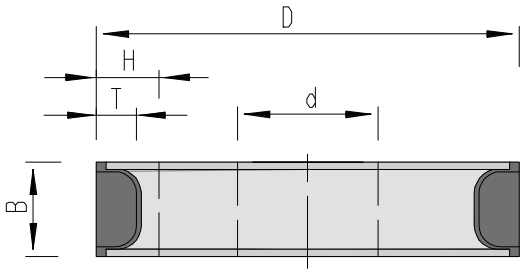
120.607

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	T(max) mm	drawing foil	Ident.-No.
125	40	30	35	2	13	SP 3	167897

blanks	B mm	H mm	LEUCODUR	drawing foil	Art.-No.	Ident.-No.
SP-blank	40,6	28,2	HL Board 06	SP3	152526	179112
SP-blank	40,6	28,2	HL Solid 60	SP3	152529	177367
support plate	40,0	28		SP 3	925402	178011
deflector plate	40,0	28		SP 3	925407	167898

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 36	167897	925300	166737
setscrew	M8x24		995191	167269
hex head wrench	SW 4x100		985730	166091





For profiling of solid woods and panel materials

- application on molders and double-end tenoners
- fits LEUCO S-System Ø 160 mm
  Ident.-No. 168411 and 168412
- profile knife can be profiled per customer specifications
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- MEC

- included in delivery: cutter head with clamping elements, without profile knives and support plates

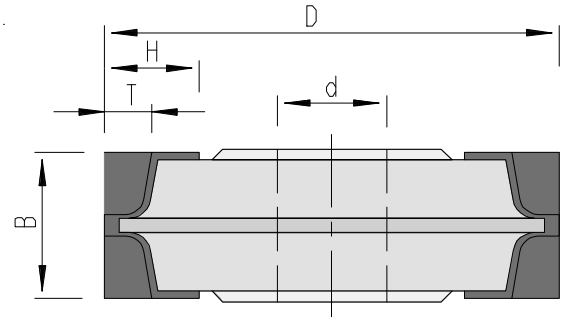
120.602

Ø D mm	B mm	Ø d mm	Ø dmax mm	DKN mm	Z	T(max) mm	n max min-1	drawing foil	Ident.-No.
125	40	30	35	8x3	2	13	12000	SP 7	167439
125	40	31,7	35		2	13	12000	SP 7	167440
125	60	30	35	8x3	2	15	12000	SP 5	167441
125	60	31,7	35		2	15	12000	SP 5	167442
150	40	30	60	8x3	3	13	10000	SP 7	166971
150	40	31,7	60		3	13	10000	SP 7	176184
150	40	35	60	10x4	3	13	10000	SP 7	166972
150	40	40	60	12x5	3	13	10000	SP 7	166973
150	60	30	60	8x3	3	15	10000	SP 5	166975
150	60	40	60	12x5	3	15	10000	SP 5	166977
150	60	50	60		3	15	10000	SP 5	166978 &
150	60	31,7	35		3	25	7200	SP 4	176230
165	40	30	60	8x3	3	20	8500	SP 33	176088
180	40	35	60	10x4	3	13	8000	SP 7	166720
180	40	40	60	12x5	3	13	8000	SP 7	166721
180	40	50	60		3	13	8000	SP 7	166722 &

Ø D mm	B mm	Ø d mm	Ø dmax mm	DKN mm	Z	T(max) mm	n max min-1	drawing foil	Ident.-No. L	Ident.-No. R
180	60	35	60	10x4	3	15	8000	SP 5		166723
180	60	40	60	12x5	3	15	8000	SP 5		166724
180	60	31,7	60		3	25	6000	SP 4		168127
180	60	50	60		3	25	6000	SP 4		168131
180	80	40	60	12x5	3	25	6000	SP 6		167993

blanks	B mm	H mm	LEUCODUR	drawing foil	Art.-No.	Ident.-No.
SP-blank	40,6	28	HL Board 06	SP 7	152526	179112
SP-blank	40,6	28	HL Solid 60	SP 7	152529	177367
SP-blank	60,8	30	HL Board 06	SP 5	152526	179113
SP-blank	60,8	30	HL Solid 60	SP 5	152529	177368
SP-blank	40,6	40	HL Board 06	SP 33	152526	179115
SP-blank	40,6	40	HL Solid 60	SP 33	152529	178844
SP-blank	60,6	45	HL Board 06	SP 4	152526	179999
SP-blank	60,6	45	HL Solid 60	SP 4	152529	178845
SP-blank	80,6	45	HL Board 06	SP 6	152526	180016
SP-blank	80,6	45	HL Solid 60	SP 6	152529	180017
support plate	40,0	28		SP 7	925402	178007
support plate	40,0	40		SP 33	925402	178006
support plate	60,0	30		SP 5	925402	178008
support plate	60,0	45		SP 4	925402	178009
support plate	80,0	45		SP 6	925402	178013

spare parts and clamping tools	dimensions	for drawing foil	Art.-No.	Ident.-No.
clamping strip	B = 36	SP 7	925300	166737
clamping strip	B = 36	SP 33	925300	176096
clamping strip	B = 56	SP 4	925300	167055
clamping strip	B = 58	SP 5	925300	166738
clamping strip	B = 76	SP 6	925300	167989
setscrew	DIN 915 M8x2		995161	001625
hex head wrench	SW 4x100		985730	166091



For profiling of solid woods and panel materials

- application on molders and double-end tenoners
- profile knife can be profiled per customer specifications
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- MEC

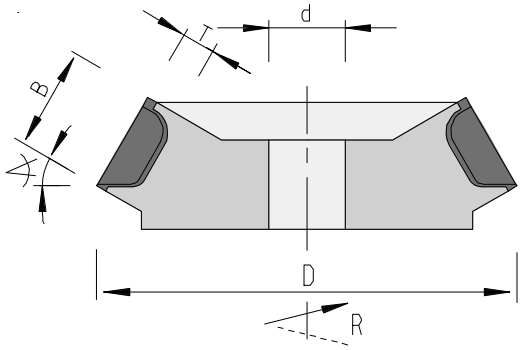
- included in delivery: cutter head with clamping elements, without profile knives and support plates

120.602

Ø D mm	B mm	Ø d mm	Ø dmax mm	DKN mm	Z	T(max) mm	n max min-1	drawing foil	Ident.-No.
150	40	30	60	8x3	3	13	10000	SP 9	167858 #
150	40	40	60	12x5	3	13	10000	SP 9	167860 #

blanks	B mm	H mm	LEUCODUR	drawing foil	Art.-No.	Ident.-No.
SP-blank	40,6	28,2	HL Board 06	SP 9	152526	179112
SP-blank	40,6	28,2	HL Solid 60	SP 9	152529	177367
support plate	40,0	28		SP 9	925402	178011

spare parts and clamping tools	dimensions	for drawing foil	Art.-No.	Ident.-No.
clamping strip	B = 36	SP 9	925300	166737
setscrew	DIN 915 M8x20		995161	001625
hex head wrench	SW 4x100		985730	166091



For profiling of solid woods and panel materials

- application on molders and double-end tenoners
- profile knife can be profiled per customer specifications
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- MEC

- sense of rotation acc. to DIN - EN 50144

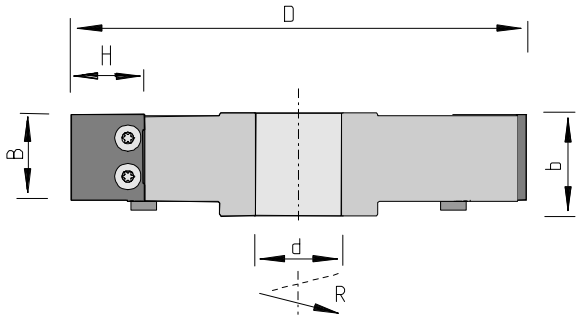
- included in delivery: cutter head with clamping elements, without profile knives and support plates

120.622

Ø D mm	B mm	Ø d mm	Ø dmax mm	DKN mm	Z	T(max) mm	angle in degr.	n max min-1	drawing foil	Ident.-No. L	Ident.-No. R
125	40	30		8x3	3	13	15	12000	SP 12		168246 #
165	40	30	40	8x3	3	13	30	9000	SP 13	167967	167968
180	40	35	60	10x4	3	13	30	8000	SP 13		166727
180	40	40	60	12x5	3	13	30	8000	SP 13	166728	166729

blanks	B mm	H mm	LEUCODUR	drawing foil	Art.-No.	Ident.-No.
support plate	40,6	28,2	HL Board 06	SP 12/13	152526	179112
SP-blank	40,6	28,2	HL Solid 60	SP 12/13	152529	177367
support plate	40,0	28		SP 12/13	925402	178007

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
clamping strip	B = 36	166728 167967	925300	166736
clamping strip	B = 36	166727 166729 167968 168246	925300	166737
setscrew	DIN 915 M8x20		995161	001625
hex head wrench	SW 4x100		985730	166091



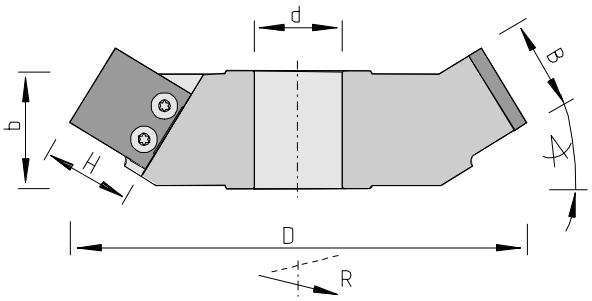
For profiling of wood materials and solid woods

- on table shapers, molders, double end tenoners, machining centers
- special aluminum cutterhead body is custom profiled within a short lead time
- keyway or double keyway on request with surcharge
- prices for profile knives see Special Price List
- profiling area see drawing and/or foil
- secure clamping -- BG-proved
- for optimum quality of cut available in TOPLINE design
- cutting edges parallel to cutter axis, alternatively with shear angle: 10% surcharge

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- MAN
- sense of rotation acc. to DIN-EN 50144

120.603

Ø D mm	B mm	H mm	b mm	Ø d mm	Ø dmax mm	Z	n min-1	drawing EP-No.	drawing foil	Ident.-No. not profiled
125	30	30	36	30	30	2	7700-10480	50	EP 382	179087 s
125	30	30	36	30	30	3	7700-10480	50	EP 382	179050 s
125	40	30	46	30	30	2	7700-9480	51	EP 384	179088 s
125	40	30	46	30	30	3	7700-9480	51	EP 384	179051 s
125	50	33	56	30	30	2	7700-8420	52	EP 386	179089 s
125	50	33	56	30	30	3	7700-8420	52	EP 386	179052 s
150	30	30	36	30	50	2	6200-9620	53	EP 382	179090 s
150	30	30	36	30	50	3	6200-9620	53	EP 382	179053 s
150	40	30	46	30	50	2	6200-8420	54	EP 384	179091 s
150	40	30	46	30	50	3	6200-8420	54	EP 384	179054 s
150	50	33	56	30	50	2	6200-7300	55	EP 386	179092 s
150	50	33	56	30	50	3	6200-7300	55	EP 386	179055 s
180	30	30	36	30	50	2	4800-8600	56	EP 382	179093 s
180	30	30	36	30	50	3	4800-8600	56	EP 382	179094 s
180	30	30	36	30	50	4	4800-8600	56	EP 382	179056 s
180	40	30	46	30	50	2	4800-7520	57	EP 384	179095 s
180	40	30	46	30	50	3	4800-7520	57	EP 384	179096 s
180	40	30	46	30	50	4	4800-7520	57	EP 384	179057 s
180	50	33	56	30	50	2	5200-6500	58	EP 386	179097 s
180	50	33	56	30	50	3	5200-6500	58	EP 386	179098 s
180	50	33	56	30	50	4	5200-6500	58	EP 386	179058 s



For profiling of wood materials and solid woods

- on table shapers, molders, double end tenoners, machining centers
- special aluminum cutterhead body is custom profiled within a short lead time
- keyway or double keyway on request with surcharge
- prices for profile knives see Special Price List
- profiling area see drawing and/or foil
- secure clamping -- BG-proved
- for optimum quality of cut available in TOPLINE design
- cutting edges with shear angle

- cutting material: HW
  HL Board 06 for panel materials and hardwoods
  HL Solid 60 for softwoods
- MAN
- sense of rotation acc. to DIN - EN 50144

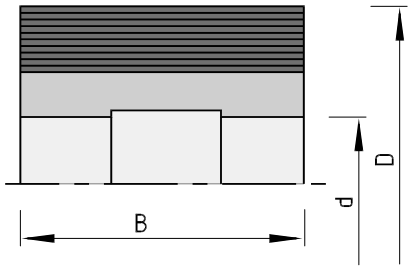
120.613

Ø D mm	B mm	H mm	b mm	Ø d mm	Ø dmax mm	Z	n min-1	crank angle in degr.	drawing EP-No.	drawing foil	Ident.-No. not profiled L	Ident.-No. not profiled R
150	40	30	49	30	30	2	6300-7460	30	59	EP 390	179349 s	179099 s
150	40	30	49	30	30	3	6300-7460	30	59	EP 390	179350 s	179059 s
160	50	33	56	30	30	2	5800-6450	30	60	EP 392	179351 s	179100 s
160	50	33	56	30	30	3	5800-6450	30	60	EP 392	179352 s	179060 s
180	40	30	50	30	50	2	5000-6580	30	61	EP 390	179353 s	179101 s
180	40	30	50	30	50	3	5000-6580	30	61	EP 390	179354 s	179102 s
180	40	30	50	30	50	4	5000-6580	30	61	EP 390	179355 s	179061 s
180	50	33	57	30	50	2	5000-5700	30	62	EP 392	179356 s	179103 s
180	50	33	57	30	50	3	5000-5700	30	62	EP 392	179357 s	179104 s
180	50	33	57	30	50	4	5000-5700	30	62	EP 392	179358 s	179062 s
165	40	30	46	30	30	2	5300-6920	45	63	EP 396	179359 s	179105 s
165	40	30	46	30	30	3	5300-6920	45	63	EP 396	179360 s	179063 s
165	50	33	53	30	30	2	4600-6040	45	64	EP 398	179361 s	179106 s
165	50	33	53	30	30	3	4600-6040	45	64	EP 398	179362 s	179064 s
195	40	30	46	30	50	2	5300-6160	45	65	EP 396	179363 s	179107 s
195	40	30	46	30	50	3	5300-6160	45	65	EP 396	179364 s	179108 s
195	40	30	46	30	50	4	5300-6160	45	65	EP 396	179365 s	179065 s
195	50	33	53	30	50	2	4600-5320	45	66	EP 398	179366 s	179109 s
195	50	33	53	30	50	3	4600-5320	45	66	EP 398	179367 s	179110 s
195	50	33	53	30	50	4	4600-5320	45	66	EP 398	179368 s	179066 s

151.486 / 151.489

blanks for Ident.-No.	B mm	H mm	drawing foil	Ident.-No. HL Board 06	HL Solid 60
179087 179050 179090 179053 179093 179094 179056	30,2	30,4	EP 382	178528	179528
179088 179051 179091 179054 179095 179096 179057	40,1	30,4	EP 384	178534	179534
179099 179059 179101 179102 179061			EP 390		
179105 179063 179107 179108 179065			EP 396		
179089 179052 179092 179055 179097 179098 179058	49,9	33	EP 386	178540	179540
179100 179060 179103 179104 179062			EP 392		
179106 179064 179109 179110 179066			EP 398		

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
Torx special screw	M4,5x4,6x9 T15	995195	178239
wrench with spinner handle	T15x80	985730	171188
wrench	T15x140	985730	179145



For profiling of solid woods on molding machines

- precise serration (60 degrees, 1.6 mm pitch) ensures tight knife clamping
- adjustable knives
- knives are sharpened in the cutter head which ensures high profile accuracy and surface quality
- 25 degree hook angle
- profile depth and cutting circle Ø see table

- RPM Ø122 n max = 9.000 min-1
  Ø137 n max = 8.000 min-1
- MEC

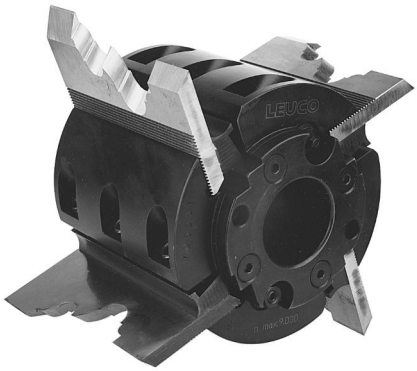
- Supply includes cutterhead and wedges
  For blanks see chapter Turnover knives, Profile knives, Knives

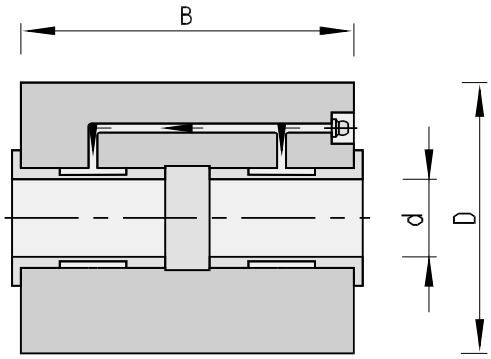
320.600

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
122	40	40	4	179208
122	60	40	4	179209
122	80	40	4	179210
122	100	40	4	179211
122	130	40	4	179212
122	150	40	4	179213
122	180	40	4	179214
122	230	40	4	179215
137	60	50	4	179216
137	80	50	4	179217
137	100	50	4	179218
137	150	50	4	179219
137	180	50	4	179220

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B = 40	925300	179221 o
clamping strip	B = 60	925300	179222 o
clamping strip	B = 80	925300	179223 o
clamping strip	B = 100	925300	179224 o
clamping strip	B = 130	925300	179225 o
clamping strip	B = 150	925300	179226 o
clamping strip	B = 180	925300	179227 o
clamping strip	B = 230	925300	179228 o
dummy pieces	B = 40	925900	179229 o
dummy pieces	B = 60	925900	179230 o
dummy pieces	B = 80	925900	179231 o
dummy pieces	B = 100	925900	179232 o
dummy pieces	B = 130	925900	179233 o
dummy pieces	B = 150	925900	179234 o
dummy pieces	B = 180	925900	179235 o
dummy pieces	B = 230	925900	179236 o
Gewindestift	DIN 915 M10x20	995161	815807
hex head wrench	SW 5x150	985730	168703

Maximum Diameter							
Knife Height H [mm]	HS 50	HW 50	ST 55	HS 60	HW 60	HS 70	ST 70
Knife Thickness Di [mm]	8	10	10	8	10	8	10
Profile Depth T [mm]	12	10	15	20	18	30	27
Dmax at D=122	161	161	171	181	181	201	201
D=137	176	176	186	196	196	216	216





For precise profiling of solid woods

- on Hydro profile molders
- dual-chamber Hydro clamping ensures precise concentricity tolerance (system Weinig)
- results in high radial running accuracy and low operating vibration
- for high feed rates and optimum quality of cut
- precise serration (60 degrees, 1.6 mm pitch) ensure tight clamping

- knife thickness 8-10 mm adjustable
- profile depth and cutting circle diameter see table

- RPM : - D=137: n max = 9.000 min-1
  - D=150: n max = 8.000 min-1
  - D=163-215: n max = 6.000 min-1
- MEC

- Supply includes cutterhead and wedges
  For blanks see chapter Turnover knives, Profile knives, Knives

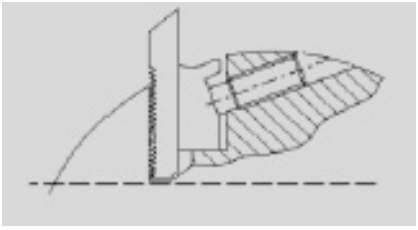
320.600

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
137	60	40	4	176342 o
137	100	40	4	176343 o
137	130	40	4	176344 o
137	150	40	4	176345 o
137	180	40	4	176346 o
137	230	40	4	176347 o
150	60	50	4	176348 o
150	100	50	4	176350 o
150	130	50	4	176352 o
150	150	50	4	176354 o
150	180	50	4	176356 o
150	230	50	4	176358 o
150	260	50	4	176360 o
150	310	50	4	176362 o
150	60	50	6	176349 o
150	100	50	6	176351 o
150	130	50	6	176353 o
150	150	50	6	176355 o
150	180	50	6	176357 o

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
150	230	50	6	176359 o
150	260	50	6	176361 o
150	310	50	6	176363 o
163	60	50	8	176364 o
163	100	50	8	176365 o
163	130	50	8	176366 o
163	150	50	8	176367 o
163	180	50	8	176368 o
163	230	50	8	176369 o
163	260	50	8	176370 o
163	310	50	8	176371 o
195	60	50	10	176372 o
195	100	50	10	176373 o
195	130	50	10	176374 o
195	150	50	10	176375 o
215	60	50	12	176380 o
215	100	50	12	176381 o
215	130	50	12	176382 o
215	150	50	12	176383 o

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
setscrew	DIN 915 M12x25	995161	181466
hex head wrench	SW 6x200	985730	167817
grease gun		993270	163706
grease cartridge		993270	163707

Maximum Diameter							
Knife Height H [mm]	HS 50	HW 50	ST 55	HS 60	HW 60	HS 70	ST 70
Knife Thickness Di [mm]	8	10	10	8	10	8	10
Profile Depth T [mm]	12	10	15	20	18	30	27
Dmax at							
D=137	174	174	184	194	194	214	214
D=150	189	189	199	209	209	229	229
D=163	202	202	212	222	222	242	242



For profiling on moulders "Weinig Powermat"

- fixed-shape knife clamping by highly precise serration 60 degrees, partition 1,6mm
- adjustable knife
- highest profile precision and surface quality by means of grinding the knives in the cutterhead
- hook angle 20 degrees (special 12 degrees)
- possibility of sideways stop in the cutterhead
- control of adjusting range of the knives through lunettes

- nmax 12000 min-1
- MEC
- picture shows sense of rotation right (acc. to DIN right)

- delivery: cutterhead with clamping strip blanks see chapter Turnover Knives, Knives, Inserts

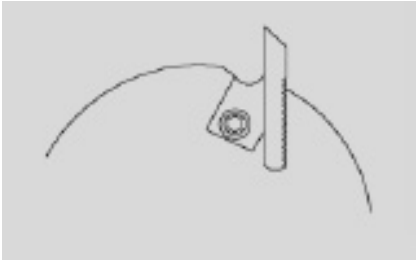
profile cutterhead with clamping strip suitable for knives s=5,8,10 mm **320.608**

Ø D	B mm	shank	Z	Ident.-No. L	R
90	40	Weinig-HSK	2	182312 o	182314 o
90	60	Weinig-HSK	2	181766 o	181775 o
90	80	Weinig-HSK	2	181767 o	181776 o
90	100	Weinig-HSK	2	181768 o	181777 o
90	130	Weinig-HSK	2	181769 o	181778 o
90	150	Weinig-HSK	2	181770 o	181779 o
90	170	Weinig-HSK	2	181771 o	181780 o
90	190	Weinig-HSK	2	182313 o	181781 o
90	210	Weinig-HSK	2	181773 o	181782 o
90	240	Weinig-HSK	2	181774 o	181783 o

profile cutterhead with clamping strip suitable for knives s=5,8,10 mm

Ø D	B mm	shank	Z	Ident.-No. L	R
90	40	Weinig-HSK	4	182315 o	182316 o
90	60	Weinig-HSK	4	181784 o	182317 o
90	80	Weinig-HSK	4	181785 o	181794 o
90	100	Weinig-HSK	4	181786 o	181795 o
90	130	Weinig-HSK	4	181787 o	181796 o
90	150	Weinig-HSK	4	181788 o	181797 o
90	170	Weinig-HSK	4	181789 o	181798 o
90	190	Weinig-HSK	4	181790 o	181799 o
90	210	Weinig-HSK	4	181791 o	181800 o
90	240	Weinig-HSK	4	181792 o	182318 o

Profile Cutterhead with Weinig HSK



For profiling on moulders "Weinig Powermat"

- quick knife change by Centrolock clamping bar
- clamping by means of front screw
- fixed-shape knife clamping by highly precise serration 60 degrees, partition 1,6mm
- adjustable knife
- highest profile precision and surface quality by means of grinding the knives in the cutterhead
- hook angle 20 degrees (special 12 degrees)

- nmax 12000 min-1
- MEC

- picture shows sense of rotation left (acc. to DIN left)

- delivery: cutterhead with clamping strip blanks see chapter Turnover Knives, Knives, Inserts

for HS-knives (s=8mm)

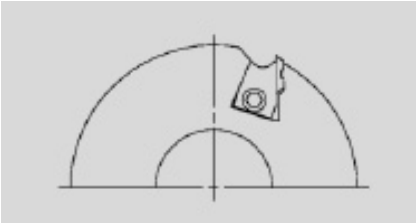
320.608

Ø D	B mm	shank	Z	Ident.-No. L	R
90	60	Weinig-HSK	2	181748 o	181757 o
90	80	Weinig-HSK	2	181749 o	181758 o
90	100	Weinig-HSK	2	181750 o	181759 o
90	130	Weinig-HSK	2	181751 o	181760 o
90	150	Weinig-HSK	2	181752 o	181761 o
90	170	Weinig-HSK	2	181753 o	181762 o
90	190	Weinig-HSK	2	181754 o	181763 o
90	210	Weinig-HSK	2	181755 o	181764 o
90	240	Weinig-HSK	2	181756 o	181765 o

for HW-knives resp. Set Profiler (s=10mm)

Ø D	B mm	shank	Z	Ident.-No. L	R
90	60	Weinig-HSK	2	181899 o	181908 o
90	80	Weinig-HSK	2	181900 o	181909 o
90	100	Weinig-HSK	2	181901 o	181910 o
90	130	Weinig-HSK	2	181902 o	181911 o
90	150	Weinig-HSK	2	181903 o	181912 o
90	170	Weinig-HSK	2	181904 o	181913 o
90	190	Weinig-HSK	2	181905 o	181914 o
90	210	Weinig-HSK	2	181906 o	181915 o
90	240	Weinig-HSK	2	181907 o	181916 o

Planing Cutterhead with Weinig HSK



For planing on moulders "Weinig Powermat"

- quick knife change by Centrolock clamping bar
- clamping by means of front screw
- delivery: Planing Cutterhead tipped with HS Turnover Knives

- cutting material: HS or HW
  HS for soft woods
  HW for hard woods, glued timber and MDF

- nmax. 12000 min-1
- MEC

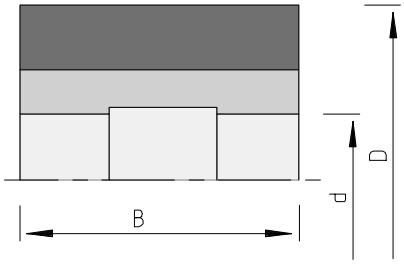
- picture shows sense of rotation left (acc. to DIN left)

- Turnover Knives see chapter Turnover Knives, Knives, Inserts

320.208

Ø D	B mm	shank	Z	Ident.-No. L	R
100	60	Weinig-HSK	2	181728 o	181737 o
100	80	Weinig-HSK	2	181729 o	181738 o
100	100	Weinig-HSK	2	181730 o	181739 o
100	130	Weinig-HSK	2	181731 o	181740 o
100	150	Weinig-HSK	2	181732 o	181741 o
100	170	Weinig-HSK	2	181733 o	181742 o
100	190	Weinig-HSK	2	181734 o	181743 o
100	210	Weinig-HSK	2	181735 o	181744 o
100	240	Weinig-HSK	2	181736 o	181745 o

accessories	Art.-No	Ident.-No.
hammer for releasing the knives	985740	181746 o
HSK-Mounting Device	985202	181747 o



For planing of solid wood

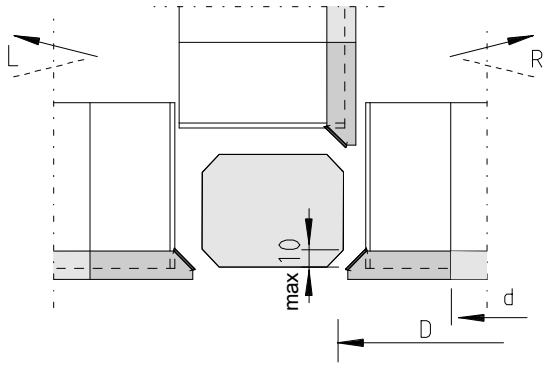
- on multi spindle plunging machines
- tipped with HS knives (18%) 30x3
- for the adjustment of the planing knives 2 adjustment rings are needed

- cutting material:HS, ST or HW
  HS for soft wood
  ST for soft and hard wood
  HW for hard wood and exotic wood
- RPM n max. 9000 min-1
- MEC

320.200

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
125	80	40	4	179204
125	100	40	4	181195
125	130	40	4	179194
125	150	40	4	179195
125	180	40	4	179196
125	230	40	4	181190

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
clamping strip	B=80	925300	179205 o
clamping strip	B=100	925300	181191 o
clamping strip	B=130	925300	179198 o
clamping strip	B=150	925300	179199 o
clamping strip	B=180	925300	179200 o
clamping strip	B=230	925300	181192 o
adjustment ring	125x40	985200	179201 o
setscrew	DIN 915 M10x25	995161	168108
hex socket head wrench	DIN 911 SW 5	985730	009674



For chamfering of solid wood (in hard- and soft woods)

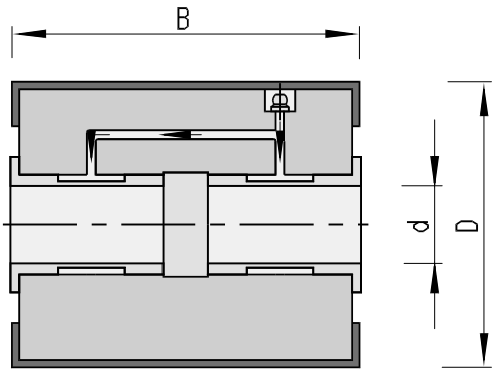
- on molders
- in combination with planing heads on vertical and horizontal spindles this tool offers the possibility of simultaneous planing and chamfering of different wood cross-sections without changing tools.
- Recommendation: run 4th chamfer on universal spindle
- cutting material: HW
- n = 9000 min-1
- MEC
- sense of rotation acc. to DIN-EN 50144

120.301

Chamfer in degree	Ø D mm	B mm	Ø d mm	Ø dmax	Z	for Planing Head	Ident.-No. L	Ident.-No. R
10x45	145,6	15	40	50	4	Ø 125	181207 #	181206 #
10x45	160,6	15	40	50	4	Ø 140	181209	181208 #

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	15	15	2,5	150518	181243

spare parts	dimensions	Art.-No.	Ident.-No.
countersunk screw	M6x10 T20	995125	181244
Torx wrench	T20x100	985730	166092



For finish-planing of solid woods

- on Hydro profile molders
- Hydro clamping (system Weinig) for precise concentricity tolerance ensures high radial running accuracy and precise tool balancing
- this results in high feed rates and optimum quality of cut
- HS tipped knives 30 x 3

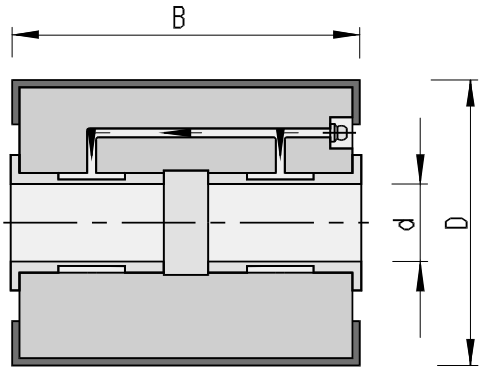
- cutting material:HS, ST or HW
  HS for softwoods
  ST for soft and hardwoods
  HW for hardwoods and exotic woods
- RPM n max. 9.000 min-1
- MEC

320.200

Ø D mm	B mm	Ø d mm	Z	hook angle in degr.	Ident.-No.
143	60	40	4	27	178104 o
143	130	40	4	27	178105 o
143	230	40	4	27	178106 o
163	60	50	4	27	178107 o
163	100	50	4	27	178108 o
163	130	50	4	27	178109 o
163	150	50	4	27	178110 o
163	180	50	4	27	178112 o
163	230	50	4	27	178113 o
163	260	50	4	27	178115 o
163	310	50	4	27	178116 o
163	60	50	6	27	178117 o
163	100	50	6	27	178118 o
163	130	50	6	27	178119 o
163	150	50	6	27	178120 o
163	180	50	6	27	178122 o
163	230	50	6	27	178123 o

Ø D mm	B mm	Ø d mm	Z	hook angle in degr.	Ident.-No.
163	260	50	6	27	178125 o
163	310	50	6	27	178126 o
163	60	50	8	25	178127 o
163	100	50	8	25	178128 o
163	130	50	8	25	178129 o
163	150	50	8	25	178130 o
163	230	50	8	25	178131 o
163	260	50	8	25	178132 o

spare parts clamping tools	dimensions	Art.-No.	Ident.-No.
setscrew	DIN 915 M12x25	995161	181466
hex head wrench	SW 6x200	985730	167817
grease gun		993270	163706
grease cartridge		993270	163707



For finish-planing of solid woods

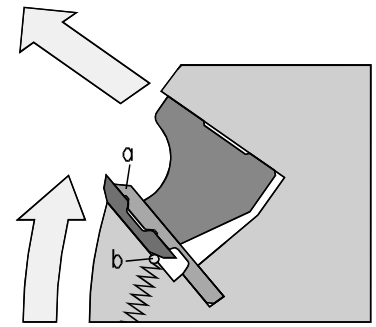
- on Hydro profile molders
- Hydro clamping (system Weinig) for precise concentricity tolerance ensures high radial running accuracy and precise tool balancing
- this results in high feed rates and optimum quality of cut
- HS tipped knives 30 x 3

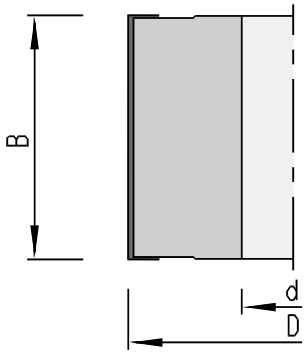
- cutting material:HS, ST or HW
  HS for softwoods
  ST for soft and hardwoods
  HW for hardwoods and exotic woods
- RPM n max. 6.000 min-1
- MEC

320.200

Ø D mm	B mm	Ø d mm	Z	hook angle in degr.	Ident.-No.
203	150	50	6	27	178133 o
203	230	50	6	27	178134 o
203	150	50	8	27	178136 o
203	230	50	8	27	178137 o
203	310	50	8	27	178139 o
203	150	50	10	23	178141 o
203	230	50	10	23	178142 o
203	310	50	10	23	178144 o
203	100	50	12	23	178145 o
203	150	50	12	23	178146 o
203	230	50	12	23	178147 o
203	310	50	12	23	178149 o
203	100	50	16	20	178150 o
203	150	50	16	20	178151 o

spare parts clamping tools	dimensions	Art.-No.	Ident.-No.
setscrew	DIN 915 M12x25	995161	181466
hex head wrench	SW 6x200	985730	167817
grease gun		993270	163706
grease cartridge		993270	163707





For planing of solid woods on molders and planers

- quick tool change with centrifugal clamping, without clamping screws and without time-consuming adjustment procedure
- tempered precision chip breaker (a) for precise positioning of the knives
- spring-loaded balls (b) hold the knife before clamping
- resharpenable, therefore very cost effective
- closed design for low noise level
- standard design with HS - TRI knives installed

- cutting material:HS - TRI or HW
- n max 9 000 min-1
- MEC

320.200

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
100	80	30	3	70469103 o
100	120	30	3	70469105 o
100	180	30	3	70469104 o
120	120	40	4	70469109 o
120	130	40	4	70469113 o
120	180	40	4	70469115 o
120	230	40	4	70469116 o
125	80	40	4	70469117 o
125	100	40	4	70469121 o
125	120	40	4	70469122 o
125	130	40	2	70469159 o
125	130	40	4	70469108 o
125	180	40	2	70469162 o
125	180	40	4	70469112 o
125	190	40	2	70469212 o
125	190	40	4	70469209 o
125	230	40	2	70469163 o
125	230	40	4	70469110 o
125	240	40	2	70469164 o
125	240	40	4	70469128 o

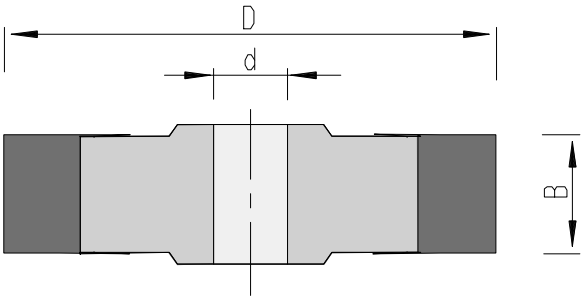
332.121

turnover knives	B mm	Cutting material	Ident.-No.
	60	HS - TRI	70469707 o
	80	HS - TRI	70469708 o
	100	HS - TRI	70469710 o
	120	HS - TRI	70469712 o
	130	HS - TRI	70469713 o
	136	HS - TRI	70469736 o
	140	HS - TRI	70469714 o
	150	HS - TRI	70469715 o
	160	HS - TRI	70469716 o
	180	HS - TRI	70469718 o
	186	HS - TRI	70469786 o
	190	HS - TRI	70469719 o
	200	HS - TRI	70469720 o
	210	HS - TRI	70469721 o
	220	HS - TRI	70469722 o
	230	HS - TRI	70469723 o
	240	HS - TRI	70469724 o
	260	HS - TRI	70469726 o
	300	HS - TRI	70469730 o
	310	HS - TRI	70469731 o
	400	HS - TRI	70469740 o
	410	HS - TRI	70469741 o
	430	HS - TRI	70469743 o
	500	HS - TRI	70469750 o
	510	HS - TRI	70469751 o
	610	HS - TRI	70469761 o
	630	HS - TRI	70469763 o
	640	HS - TRI	70469764 o
	710	HS - TRI	70469771 o
	1350	HS - TRI	70469798 o

132.121

turnover knives	B mm	Cutting material	Ident.-No.
	80	HW	70469908 o
	100	HW	70469910 o
	120	HW	70469912 o
	130	HW	70469913 o
	140	HW	70469914 o
	150	HW	70469915 o
	160	HW	70469916 o
	180	HW	70469918 o
	200	HW	70469920 o
	210	HW	70469921 o
	220	HW	70469922 o
	230	HW	70469923 o
	240	HW	70469924 o
	250	HW	70469925 o
	260	HW	70469926 o
	300	HW	70469930 o
	610	HW	70469999 o

spare parts and clammping tools	Art.-No.	Ident.-No.
knife changer	985720	70469100 o



For profiling of solid woods on shapers

- tool set consists of:
  - 2 profile knives
  - 2 deflectors
- custom profiling of knife pairs and deflectors possible
- application of 40 and 50 mm knives allowed in in cutter head No. 167245
- cutting edges parallel to cutter axis

- cutting material: HS
- n = 6.500 -10.000 min-1
- MAN

320.605

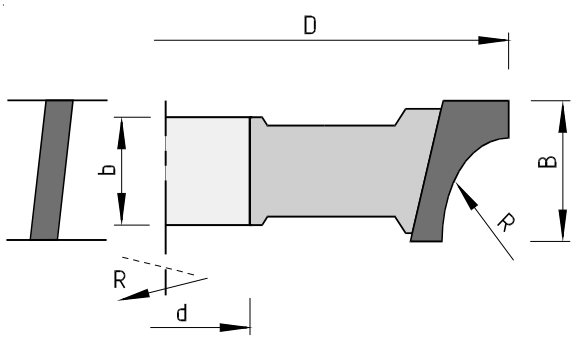
Ø D mm	B mm	Ø d mm	Z	Ident.-No.
128	40	30	2	167245 o

HS-blanks for profiling 332.521

B mm	H mm	S mm	T mm	Ident.-No.
40	45	4	15	163535
50	45	4	15	163513 o

deflectors for profiling 925.400

B mm	H mm	S mm	T mm	Ident.-No.
40	45	4	15	163536
50	45	4	15	163514 o



For cutting of quarter round profiles on stationary machines

- application on shapers
- cutting edges with face shear for optimum quality of cut and precise tool balancing

- cutting material: HW
  Art.-No. 122.315 HW cutting edge material for solid wood and panel materials
  Art.-No. 322.315 HS cutting edge material for solid wood
- MAN

- sense of rotation acc. to DIN-EN 50144

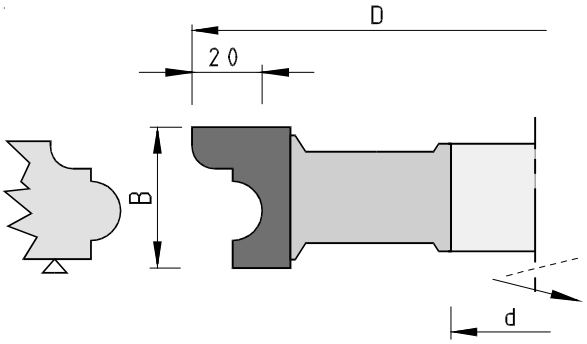
- profile runout 5 degrees

HW 122.315

R mm	Ø D mm	Ø d mm	Z	n = min-1	Ident.-No. L	Ident.-No. R
4	120	30	3	6400-11000	198284 s	198283 s
5	120	30	3	6400-11000	198286 s	198285 s
6	120	30	3	6400-11000	198288 s	198287 s
8	120	30	3	6400-11000	198290 s	198289 s
10	120	30	3	6400-11000	198292 s	198291 s
12	120	30	3	6400-11000	198294 s	198293 s
15	140	30	3	5400-9400	198296 s	198295 s
20	140	30	3	5400-9400	198298 s	198297 s

HS 322.315

R mm	Ø D mm	Ø d mm	Z	n = min-1	Ident.-No. L	Ident.-No. R
4	120	30	3	6400-11000	198268 s	198267 s
5	120	30	3	6400-11000	198270 s	198269 s
6	120	30	3	6400-11000	198272 s	198271 s
8	120	30	3	6400-11000	198274 s	198273 s
10	120	30	3	6400-11000	198276 s	198275 s
12	120	30	3	6400-11000	198278 s	198277 s
15	140	30	3	5400-9400	198280 s	198279 s
20	140	30	3	5400-9400	198282 s	198281 s



For cutting of strip profiles on stationary machines

- application on shapers and special machines
- for profiling in combination with thrust ring (not included)
- cutting edges parallel to cutter axis

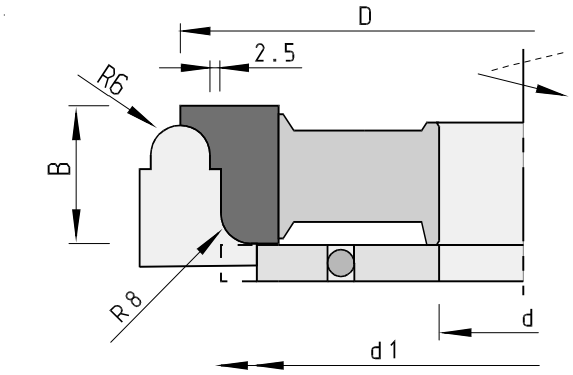
- cutting material: HW
  Art.-No. 122.605 HW cutting edge material for solid wood and panel materials
  Art.-No. 322.605 HS cutting edge material for solid wood
- n = 5.400 - 9.400 min-1
- MAN

HW 122.605

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	Ident.-No.
140	35	30	40	3	198260 s

HS 322.605

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	Ident.-No.
140	35	30	40	3	198259 s



For cutting of strip profiles on stationary machines

- application on shapers and special machines
- for profiling in combination with thrust ring (not included)
  Ø d1 for outside profile = 100 mm
  Ø d1 for inside profile = 120 mm
- cutting edges with face shear ensure high quality of cut and precise tool balancing

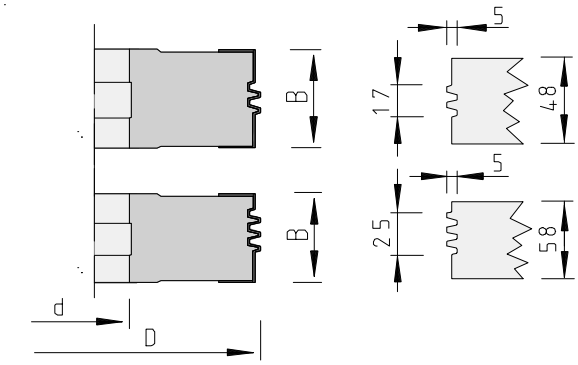
- cutting material: HW
  Art.-No. 122.615 HW cutting edge material for solid wood and panel materials
  Art.-No. 322.615 HS cutting edge material for solid wood
- n = 5.400 - 9.400 min-1
- MAN

HW 122.615

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	Ident.-No.
140	30	30	40	3	198258 s

HS 322.615

Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	Ident.-No.
140	30	30	40	3	198257 s



For cutting of edge glue joints on stationary shapers

- in hard- and soft woods table tops, stairs etc.
- fit of joints can be defined by moving the knives sideways by means of dials (see spare parts)
- when delivered, tool is set to 0,3 mm joint play
- application on shapers and molders
- turnover knives ensure consistent profile accuracy
- cutting edges parallel to cutter axis

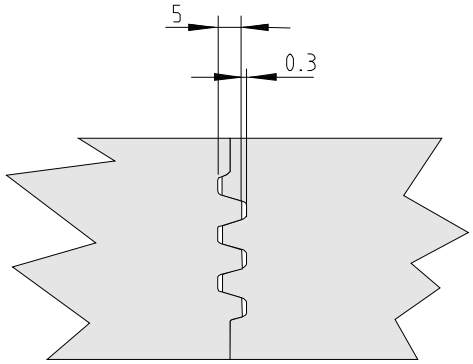
- cutting material: HW
- n = 5.700 - 9.800 min-1
- MAN

120.505

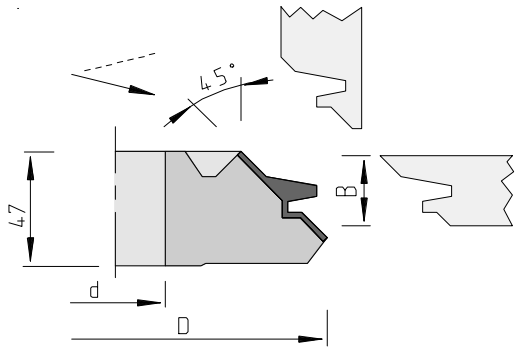
Ø D mm	B mm	Ø d mm	Ø dmax mm	Z	H mm	Ident.-No.
135	50	30	50	2	17-48	177007
135	60	30	50	2	25-58	177008

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
	50	23	2	151555	180431
	60	23	2	151555	180432

spare parts and clamping tools	dimensions	for Ident.-No.	Art.-No.	Ident.-No.
pressure jaw	48x11x6	177007	925300	180433
pressure jaw	58x11x6	177008	925300	180434
clamping part	12x8,5/M8L		925100	180357
clamping setscrew	M8/M8Lx26 SW4		995161	180340
hex head wrench	SW 4x100		985730	166091



spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
dial	0,1 + 0,15	995490	180435
dial	0,15 + 0,2	995490	180436
dial	0,2 + 0,25	995490	180437
dial	0,25 + 0,3	995490	180438
dial	0,3 + 0,35	995490	180439



For cutting of miter lock joints on stationary shapers

- in solid wood e.g. door cases, panelling and similar workpieces
- in panel materials
- body made from high-strength aluminium alloy
- wood thickness approx. 15 mm to max. 26 mm
- application on shapers and molders
- profile knives ensure high profile accuracy
- cutting edges parallel to cutter axis

- cutting material: HW
- n = 4.600 - 7.800 min-1
- MAN

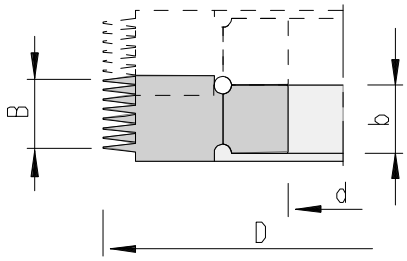
120.525

Ø D mm	B mm	Ø d mm	Z	Ident.-No.
170	26	30	2 + 2	176097

turnover knives	B mm	H mm	S mm	Art.-No.	Ident.-No.
grooving/chamfering knife	4,6 / 2,8		4,6	150509	180500
Miter Glue Joint Profile Knife	39,5	12	1,5	151547	165916

spare parts and clamping tools	dimensions	Art.-No.	Ident.-No.
pressure jaw	38x11x6	925300	180538
clamping part	12x8,5/M8L	925100	180357
clamping setscrew	M8/M8Lx26 SW4	995161	180340
Torx countersunk screw	M5x10,8 T15	995125	180840
hex head wrench	SW 4x100	985730	166091
Torx wrench	T15x100	985730	180470

Mini Finger Joint Cutter



For longitudinal joints in solid woods on finger joint machines

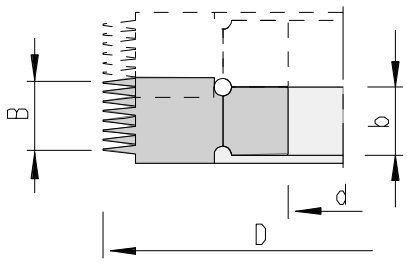
- for production of gluelam/construction timber and quality laminated timber
- finger joint length: 15/16,5
  20/22
  for machines with cross-cutting device
- for softwoods
- compared to traditional HS mini finger cutter the edge live is 2 - 3 times as long

- cutting material: HS
- MEC

- s = Price on request

322.500

Ø D mm	B mm	b mm	Ø d mm	Z	n max min-1	pitch mm	finger length mm	no. of fingers	Ident.-No.
170	28,6	26,6	50	2 + 2	8000	3,8	15/16,5	7	181185 s
180	33	31	50	2 + 2	8000	6,2	20/22	5	181187 s
260	28,6	26,6	50	3 + 3	6000	3,8	15/16,5	7	181188 s



For longitudinal joints in solid woods on finger joint machines

- finger joint length: 4/4,5
  10/11
  15/16.5
  20/22
  only for machines with cross-cutting device
- for softwoods

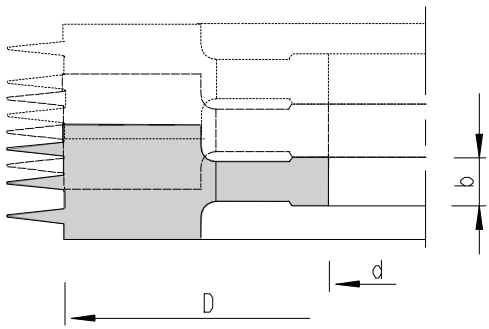
- cutting material: HS
- MEC

- s = Price on request

322.500

Ø D mm	B mm	b mm	Ø d mm	Z	n max min-1	pitch mm	finger length mm	no. of fingers	Ident.-No.
160	28,6	26,6	50	2	8000	3,8	10/10	7	175740
160	28,6	26,6	50	2	8000	3,8	10/11	7	175741
160	32,4	30,4	50	2	8000	3,8	10/11	8	178966
160	28,6	26,6	50	3 + 3	8000	3,8	10/11	7	181008 s
160	32,4	30,4	50	3 + 3	9000	1,6	4/4,5	20	182122 s
170	28,6	26,6	50	2	8000	3,8	15/15	7	175742
170	28,6	26,6	50	2	8000	3,8	15/16,5	7	175743
180	33	31	50	2	8000	6,2	20/20	5	175744
180	33	31	50	2	8000	6,2	20/22	5	175745
250	26	24	50	3 + 3	6000	1,6	4/4,5	16	182113 s
250	28,6	26,6	50	3	6000	3,8	10/10	7	175746 s
250	28,6	26,6	50	3	6000	3,8	10/11	7	175747
260	28,6	26,6	50	3	6000	3,8	15/15	7	175748 s
260	28,6	26,6	50	3	6000	3,8	15/16,5	7	175749
260	33	31	50	3	6000	6,2	20/22	5	175751

Finger Joint Cutter



For longitudinal joints in solid woods on finger joint machines

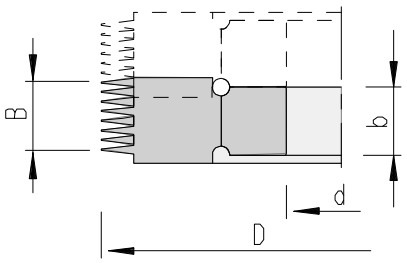
- finger joint length: 10/11
  15/16.5
  for machines with cross-cutting device
- for softwoods
- compared to traditional HS finger joint cutter the edge live is 2 - 3 times as long
- no. of finger joint cutters with regard to wood height:
  no. of cutters = wood height:
  hub width (11,4) = round up +
  1 cutter
- tool support of the machine spindle = 5,7 mm below workpiece support

- cutting material: HS
- MEC

- s = Price upon request

322.500

Ø D mm	b mm	Ø d mm	Z	n max min-1	pitch mm	finger length mm	no. of fingers	Ident.-No.
250	11,4	50	6	6000	3,8	10/11	3	181163 s
260	11,4	50	6	6000	3,8	15/16,5	3	181161 s



For longitudinal joints in solid woods on finger joint machines

- finger joint length: 10/11
  15/16.5
  only for machines with cross-cutting device
- for hard and exotic woods

- cutting material: HW
- MEC

- s = Price on request

122.500

Ø D mm	B mm	b mm	Ø d mm	Z	n max min-1	pitch mm	finger length mm	no. of fingers	Ident.-No.
160	28,6	26,6	50	2 + 2	8000	3,8	10/10	7	175732 s
160	28,6	26,6	50	2 + 2	8000	3,8	10/11	7	175733
170	28,6	26,6	50	2 + 2	8000	3,8	15/15	7	175734 s
170	28,6	26,6	50	2 + 2	8000	3,8	15/16,5	7	175735 s
250	28,6	26,6	50	3 + 3	6000	3,8	10/10	7	175736 s
250	28,6	26,6	50	3 + 3	6000	3,8	10/11	7	175737
260	28,6	26,6	50	3 + 3	6000	3,8	15/15	7	175738 s
260	28,6	26,6	50	3 + 3	6000	3,8	15/16,5	7	175739 s

combination of the cutter sets

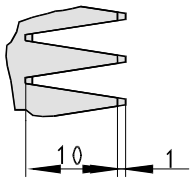
Finger Length mm	Wood Thickness mm	Number of Cutters
10 und 15	24	1
	51	2
	77	3
	104	4
	131	5
	157	6
	184	7
	210	8
	237	9
	264	10

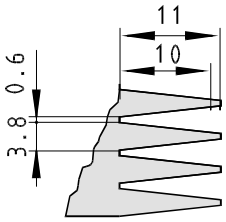
Finger Length mm	Wood Thickness mm	Number of Cutters
20	28	1
	59	2
	90	3
	121	4
	152	5
	183	6
	214	7
	245	8
	276	9
	307	10

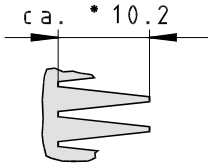
mini finger joint cutter - cross cutting with extended finger joint profile

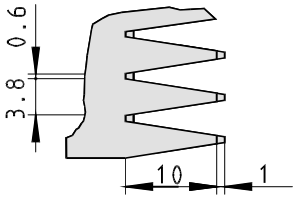
Finger Length (mm)	For Machines with Sizing Dev.	For Machines without Sizing Dev.	Finger Length adjustable (mm)
10/10	no	yes	no
10/11	yes	no	10-11
15/15	no	yes	no
15/16,5	yes	no	15-16,5
20/20	no	yes	no
20/22	yes	no	20-22

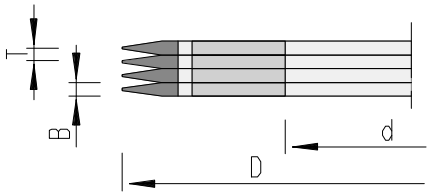
drawing











For solid wood joints on finger joint machines

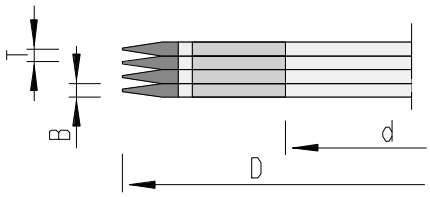
- special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges ensure optimal tool life
- increased number of teeth ensures optimum quality of cut
- on finger joint machines with cross-cutting (Grecon/Dimter, SMB, Scharpf + Kögel, Dieffenbacher, NKT) device can be adjusted to any wood thickness with bushing
- high-tensile steel body
- compared to traditional HW mini finger cutter the edge live is 2 - 3 times as long

- cutting material: HW Topcoat coating
- Ø 160 n max = 11.800 min-1
  Ø 250 n max = 7.400 min-1
- MEC

- s = Price on request

122.502

Ø D mm	B=T mm	Ø d mm	finger length mm	Z	application	Ident.-No.
160	3,8	70	10/11	4	softwoods	181230 s
160	3,8	70	10/11	4	hard/exotic woods	181231 s
250	3,8	70	10/11	6	hard/exotic woods	181232 s
250	3,8	70	10/11	6	softwoods	181233



For solid wood joints on finger joint machines

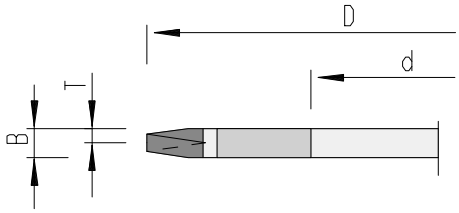
- special coordination of cutting material to the material to be cut and the spiral arrangement of the cutting edges ensure optimal tool life
- increased number of teeth ensures optimum quality of cut
- on finger joint machines with cross-cutting (Grecon/Dimter, SMB, Scharpf + Kögel, Dieffenbacher) device can be adjusted to any wood thickness with bushing
- high-tensile steel body
- Topline cut

- cutting material: HW
- Ø 160 n max = 11.800 min-1
  Ø 250 n max = 7.400 min-1
  Ø 260 n max = 7.200 min-1
- MEC

- s = Price on request

122.502

Ø D mm	B=T mm	Ø d mm	finger length mm	Z	application	Ident.-No.
160	3,8	70	10/11	2	softwoods	177561 s
160	3,8	70	10/11	2	hard/exotic woods	177562 s
160	3,8	70	10/11	4	softwoods	177563
160	3,8	70	10/11	4	hard/exotic woods	177564
250	3,8	70	10/11	6	hard/exotic woods	180938
250	3,8	70	10/11	6	softwoods	180939
260	3,8	70	15/16	6	soft/hard woods	178253 s



For cutting of closed visible joints on finger joint machines

- in combination with mini finger joint cutters with same Ø and pitch
- high-tensile steel body
- for hard and soft/exotic woods
- Ø 149 und Ø 239 (half shoulder) only for finger jointing lines with scoring saw blade

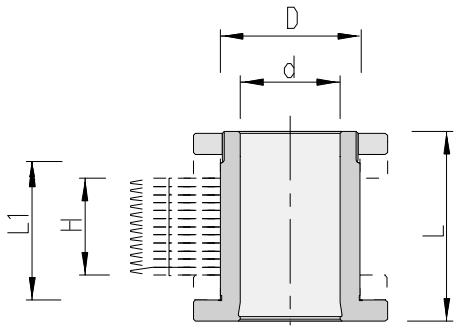
- cutting material: HW
- Ø 149 n max = 12 700 min-1
  Ø 160 n max = 11 800 min-1
  Ø 239 n max = 7 900 min-1
  Ø 250 n max = 7 400 min-1

- MEC

122.502

Ø D mm	B mm	Ø d mm	finger length mm	T mm	Z	Ident.-No.
149	3,8	70	5	3,8	4	180916
160	11,4	70	10	3,8	4	177574
239	3,8	70	10	3,8	6	180917
239	11,4	70	10	3,8	6	181245
250	11,4	70	10	3,8	6	177576

Bushing for Mini Finger Joint Cutter



For clamping of mini finger joint cutters and edge finger joint cutters

- for varying wood thicknesses
- fill intermediate sizes with spacers
- spacers Ø 97 for cutters Ø 160-210 mm (not required)
- when cutter Ø 250 mm install at least 1 spacer Ø 177 on top and bottom
- high-tensile steel
- high radial and axial running accuracies
- fastening nut or hydraulic clamping for cutter
  attachment must be ordered separately
- for cutter sets over 100 mm high we recommend hydraulic clamping
- the bushing length depends on the wood height "H" and on the type of nut
- accessories: mounting device, mounting ring and wrench is imperative for self-resharpening

997.300

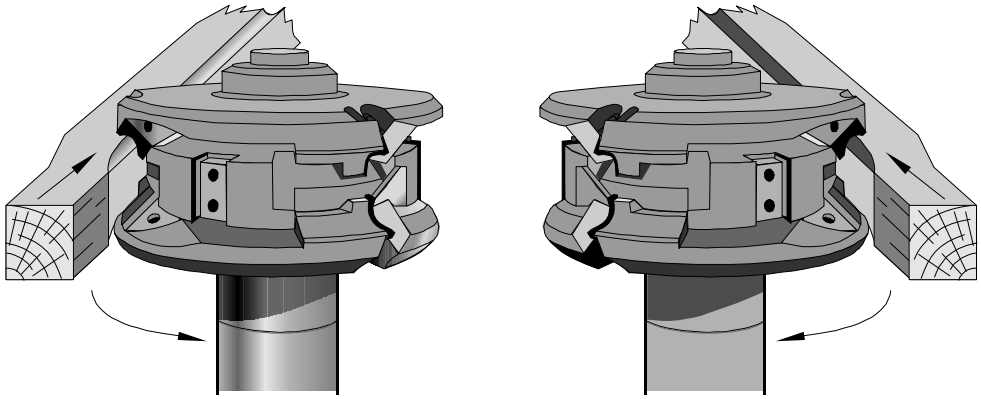
Ø D mm	Ø d mm	L mm	L1 mm	Ident.-No.
70	50	90	57	178188
70	50	120	87	181035
70	50	130	97	178171
70	50	195	162	178172
70	50	220	187	178173
70	50	240	207	178174

955.520

spacers	Ø D mm	Ø d mm	B mm	Ident.-No.
	100	70	7,6	180940
	100	70	11,4	180941
	175	70	11,4	181034
	175	70	7,6	181033

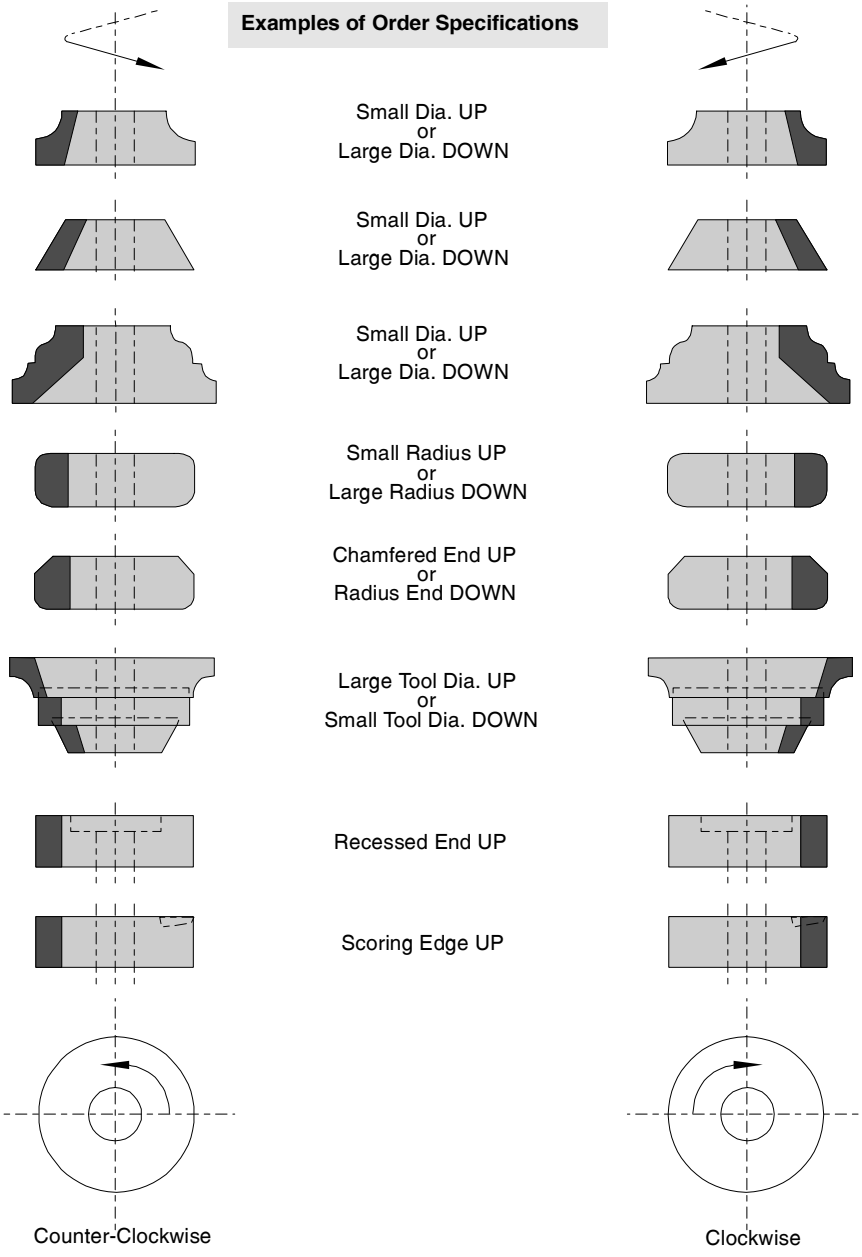
accessories	dimensions	Art.-No.	Ident.-No.
mounting device		997300	177103
mounting ring	96x70x60	955520	177546
flexible head spanner		985720	177102
face nut	M68x1,5x14	995290	177104
hydraulic clumping nut	M68x1,5x56	933090	178787
hex head wrench	SW 4x100	985730	166091

right **left**



Counter-Clockwise Clockwise

Examples of Order Specifications



The customer requirement:

Fast and timely manufacturing of individual profiles !

The solution:

LEUCO super profilers

A LEUCO super profiler consists of a body with clamping wedges for attachment of custom profiled carbide profile knives and support plates in various profile variations.

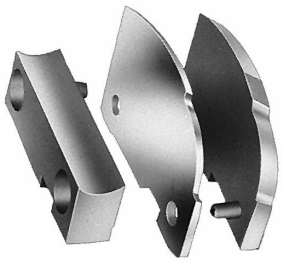
Different shapes and dimensions of the body allow the use on:

- ✧ table saws
- ✧ molders
- ✧ double-end tenoners
- ✧ CNC routers

The profile options shown on the appropriate catalog pages facilitate the selection of the body and the profile knives.

LEUCO delivers custom profiled knives within 10 working days in the following carbide grades

- ✧ **HL Board 06** for panel materials and for solid woods - hard
- ✧ **HL Solid 60** for solid woods - soft



Assembly of the cutting insert (from right to left)**:**

- ✧ support plate

  (number = number of teeth on the body)

  ⇨ required only for new profiles
- ✧ profile knife
- ✧ clamping wegde

  (included in the delivery of the body)

The following data is required upon ordering a complete super profiler and/or profile knife:

① profile drawing with dimension or workpiece sample

② body Ident. #

③ desired carbide grade of the profile knife (HL Board 06 or HL Solid 60)

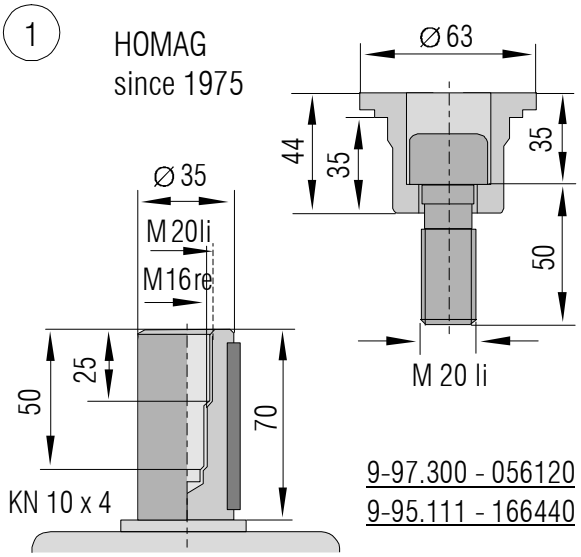
④ numer of profile knives (6 piece min.)

⑤ number of support plates (only for new profiles)

For repeat orders only the Ident # lasered on to the profile knife is required.

1

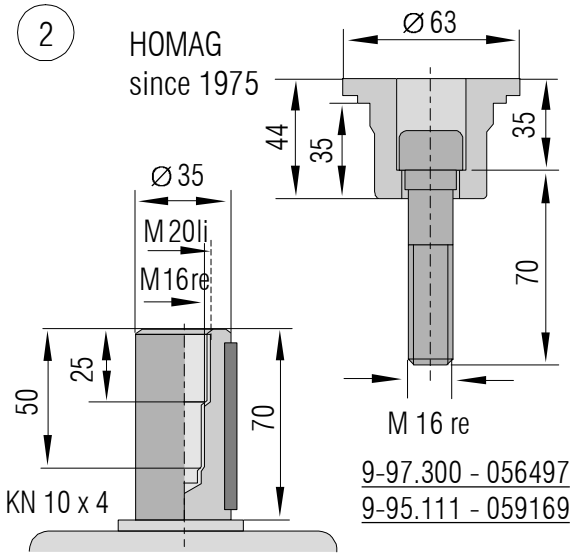
HOMAG
since 1975



9-97.300 - 056120
9-95.111 - 166440

2

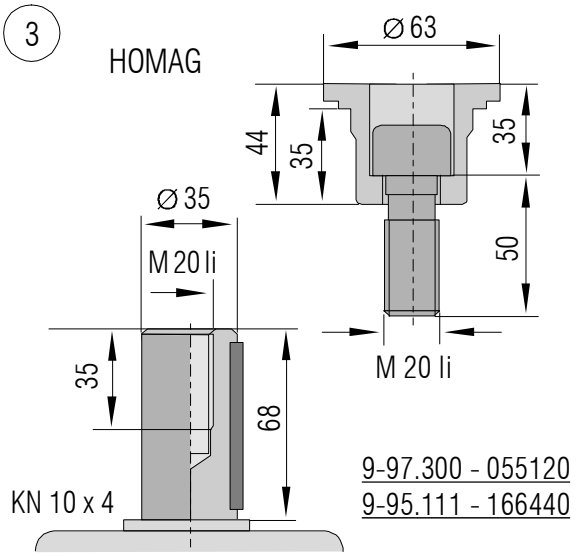
HOMAG
since 1975



9-97.300 - 056497
9-95.111 - 059169

3

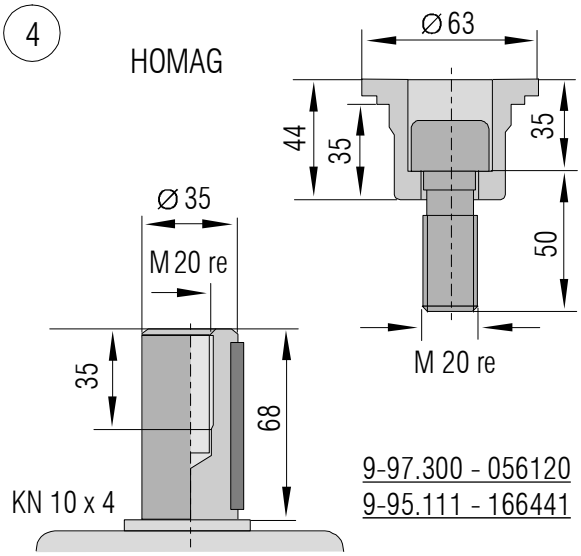
HOMAG



9-97.300 - 055120
9-95.111 - 166440

4

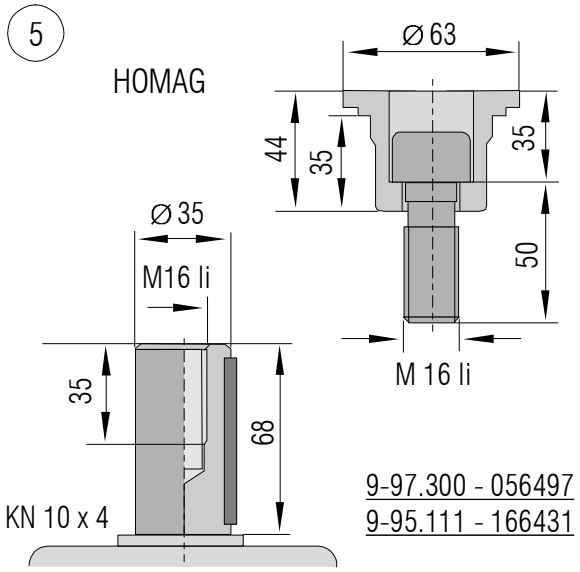
HOMAG



9-97.300 - 056120
9-95.111 - 166441

5

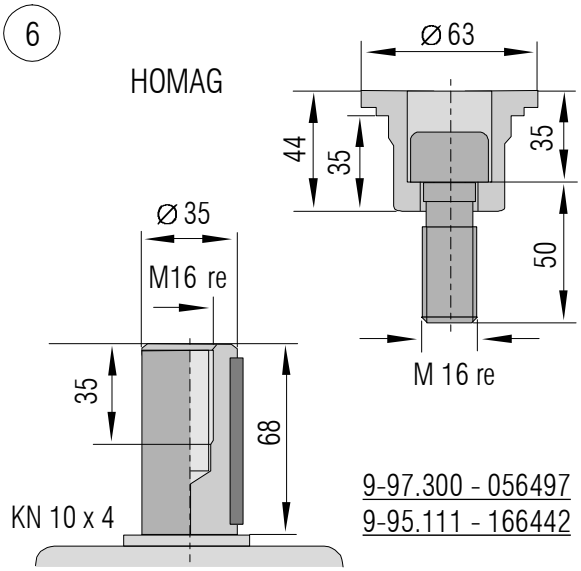
HOMAG



9-97.300 - 056497
9-95.111 - 166431

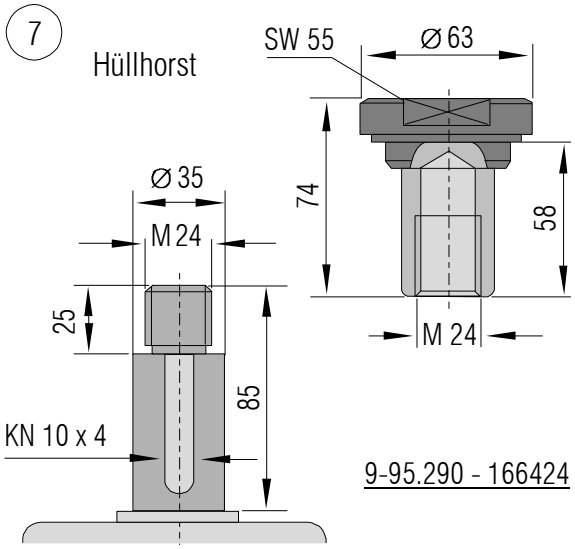
6

HOMAG



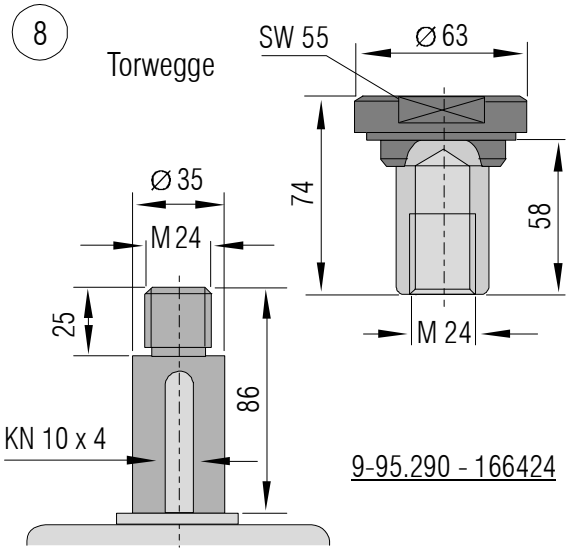
9-97.300 - 056497
9-95.111 - 166442

7 Hüllhorst



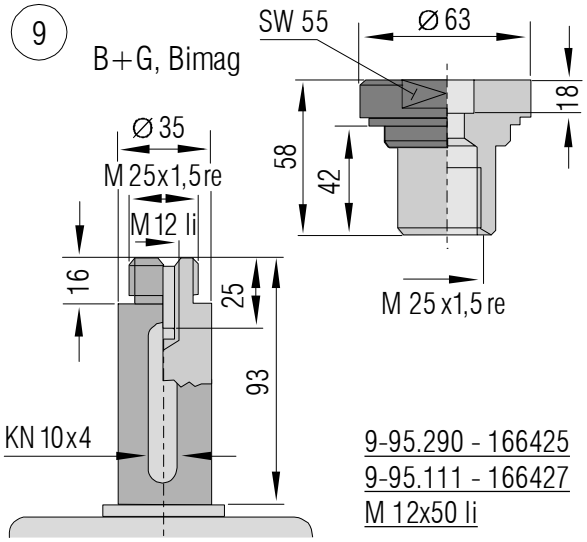
9-95.290 - 166424

8 Torwegge



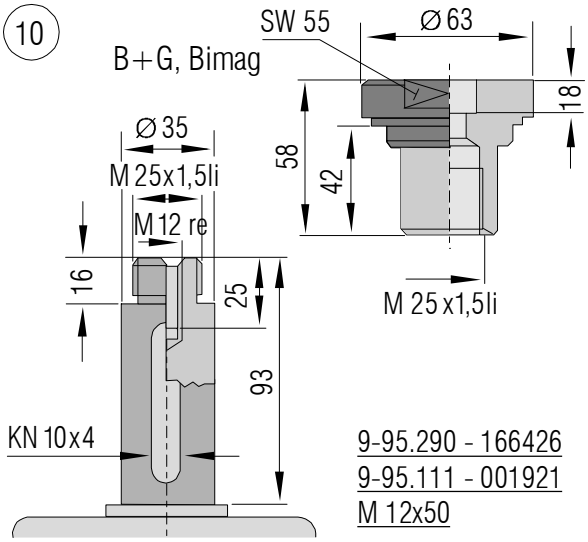
9-95.290 - 166424

9 B+G, Bimag



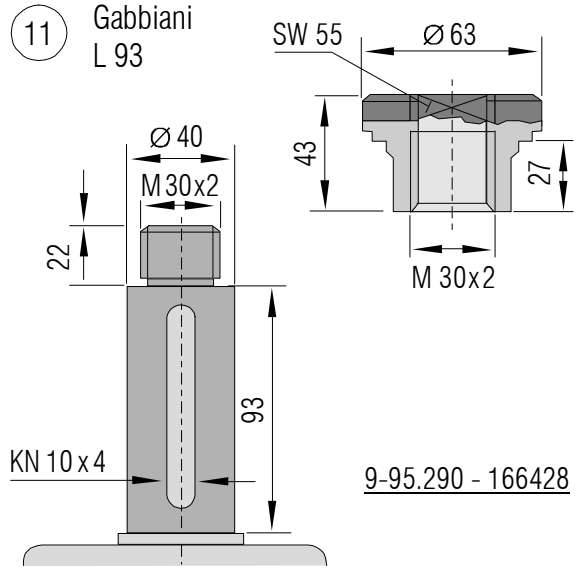
9-95.290 - 166425
9-95.111 - 166427
M 12x50 li

10 B+G, Bimag



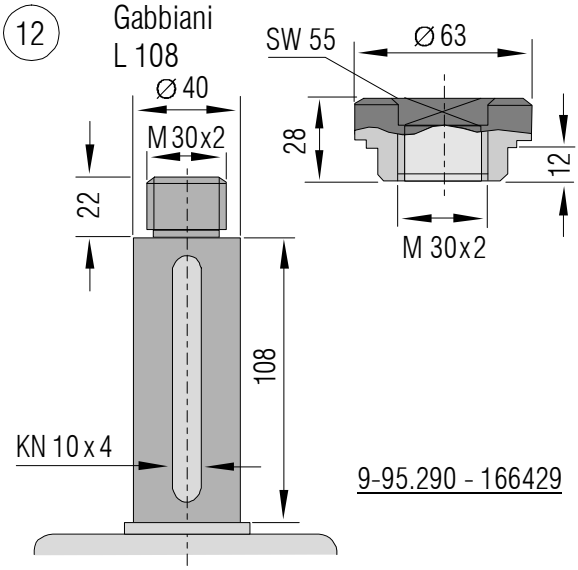
9-95.290 - 166426
9-95.111 - 001921
M 12x50

11 Gabbiani L 93



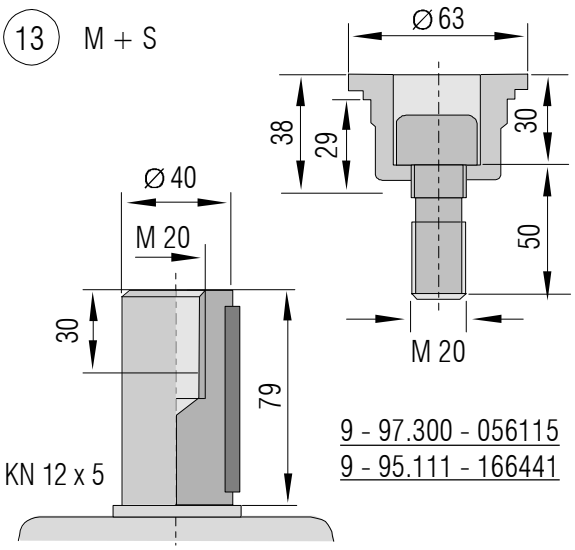
9-95.290 - 166428

12 Gabbiani L 108



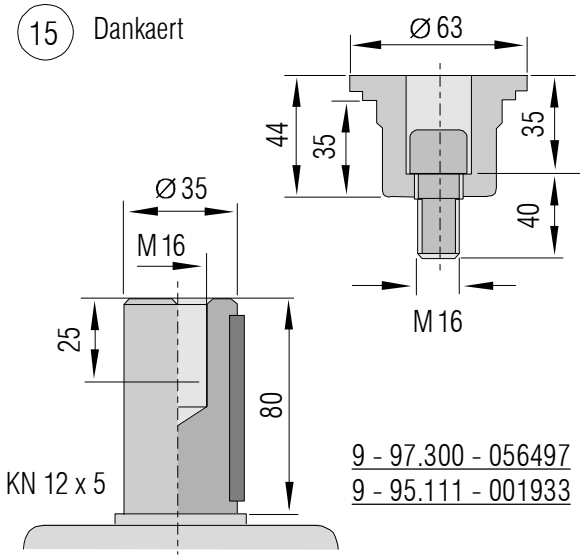
9-95.290 - 166429

(13) M + S



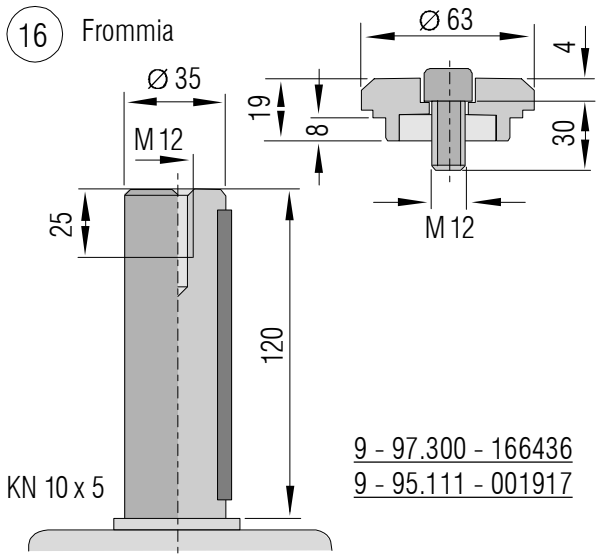
9 - 97.300 - 056115
9 - 95.111 - 166441

(15) Dankaert



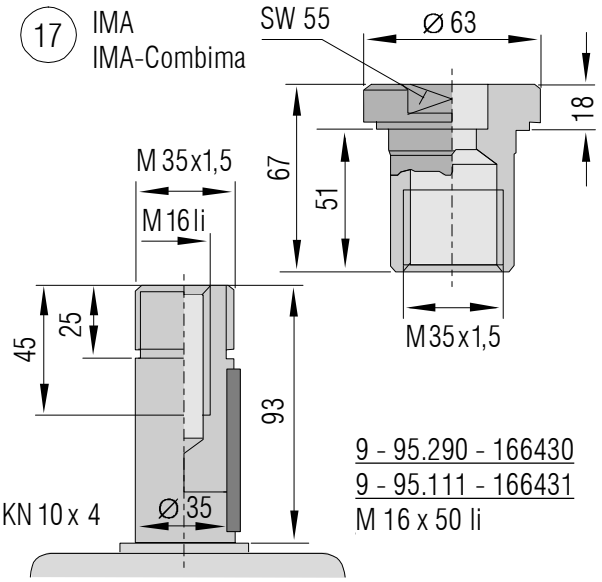
9 - 97.300 - 056497
9 - 95.111 - 001933

(16) Frommia



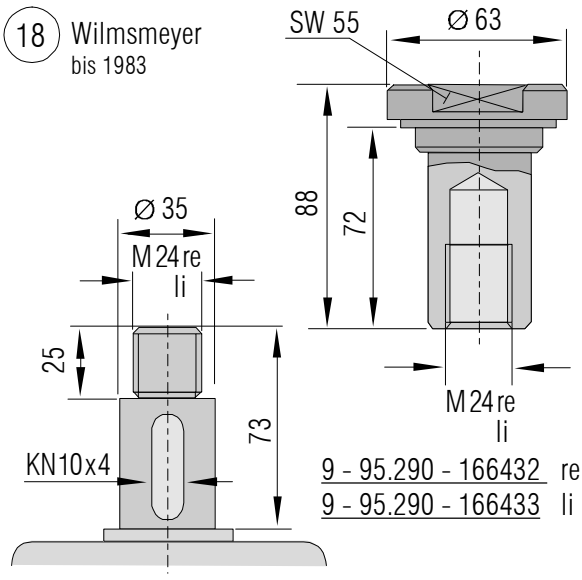
9 - 97.300 - 166436
9 - 95.111 - 001917

(17) IMA
IMA-Combima



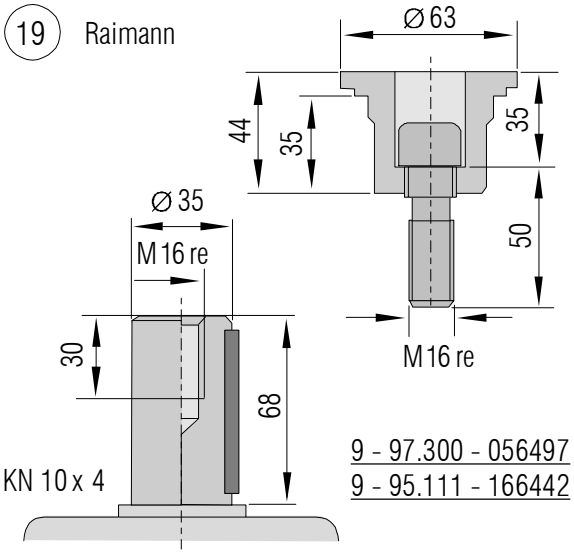
9 - 95.290 - 166430
9 - 95.111 - 166431
M 16 x 50 li

(18) Wilmsmeyer
bis 1983



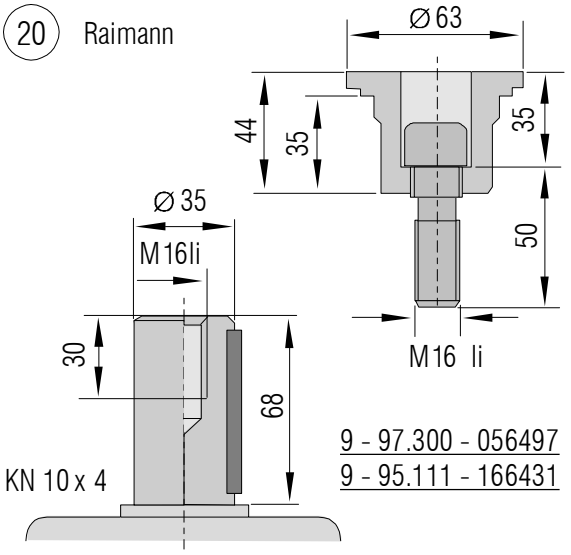
9 - 95.290 - 166432 re
9 - 95.290 - 166433 li

19 Raimann



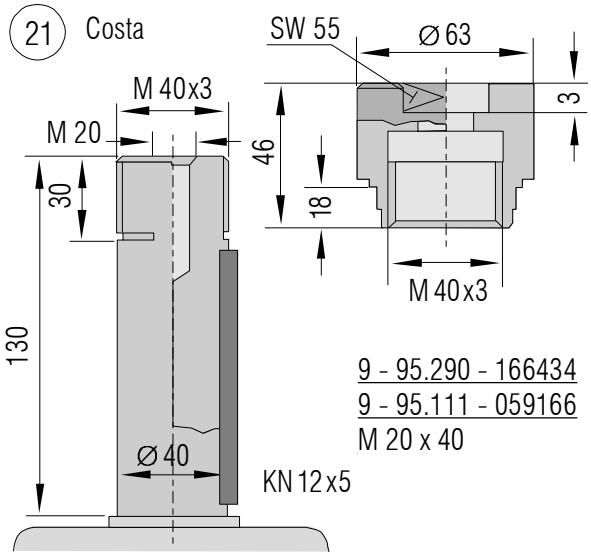
9 - 97.300 - 056497
9 - 95.111 - 166442

20 Raimann



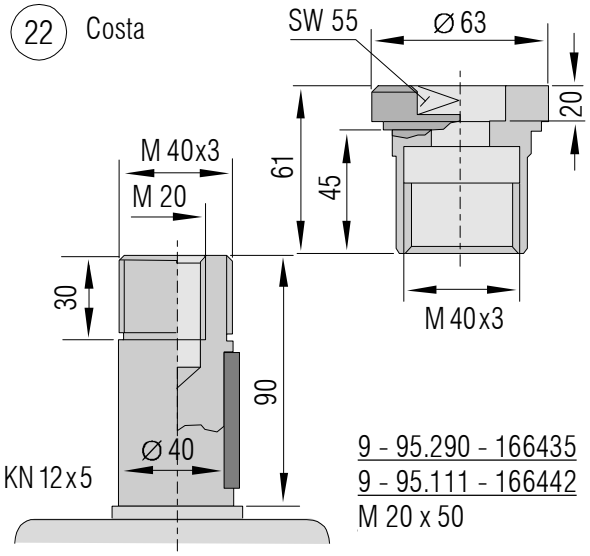
9 - 97.300 - 056497
9 - 95.111 - 166431

21 Costa



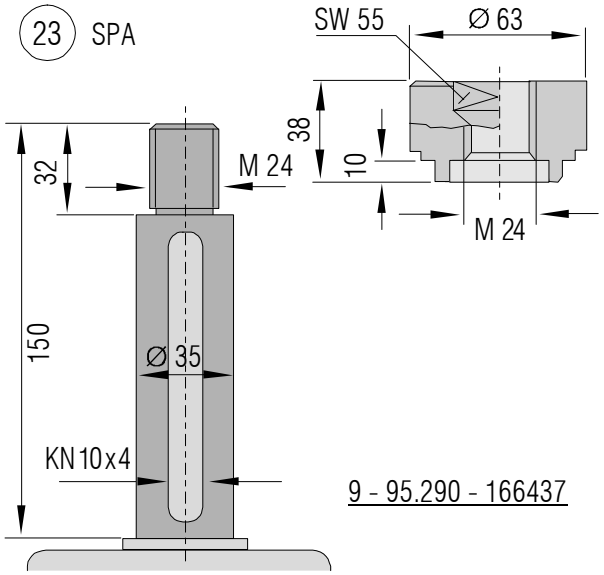
9 - 95.290 - 166434
9 - 95.111 - 059166
M 20 x 40

22 Costa



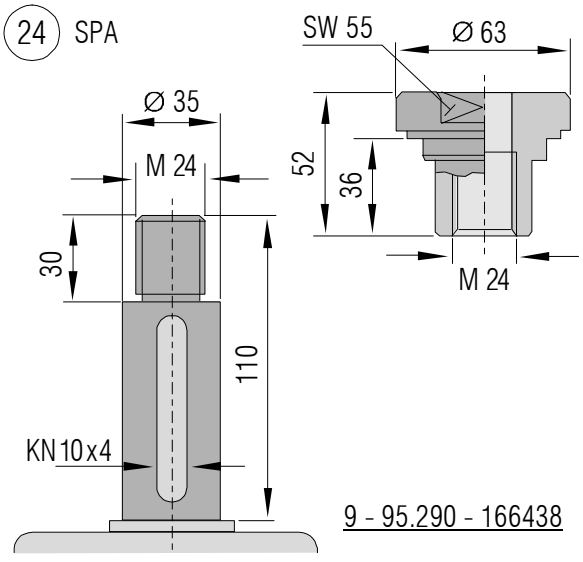
9 - 95.290 - 166435
9 - 95.111 - 166442
M 20 x 50

23 SPA



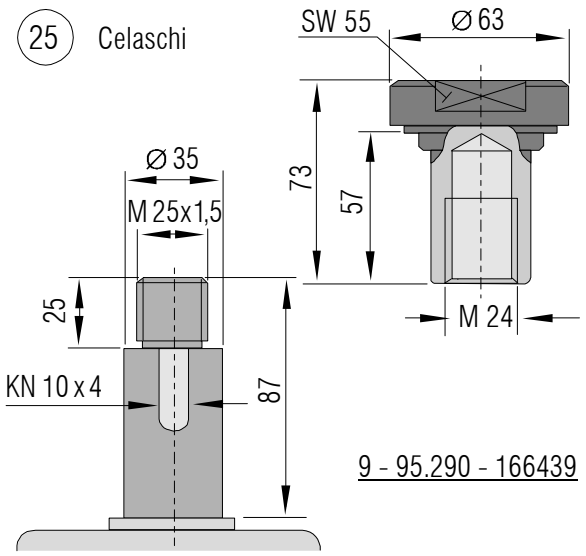
9 - 95.290 - 166437

24 SPA



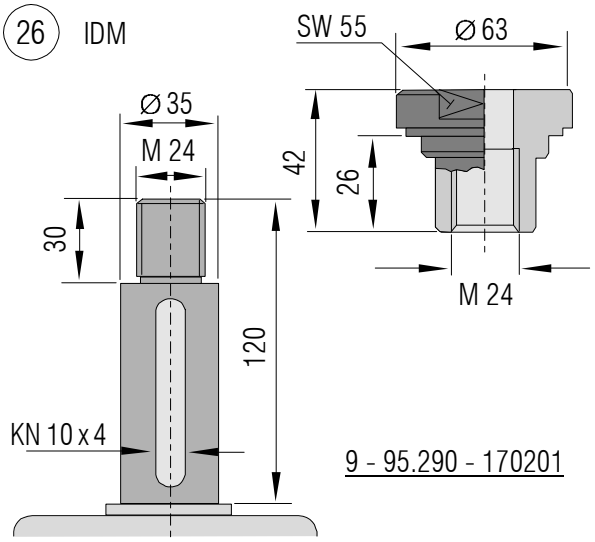
9 - 95.290 - 166438

25 Celaschi



9 - 95.290 - 166439

26 IDM



9 - 95.290 - 170201