

DIA Saws and Hoggers

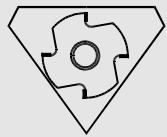
Page

DIA Saws

Sizing Saws	1
Panel Sizing Saws and Multi-Blade Saws	2
Scoring Saws	5
DIAMAX Scoring Saws	12
Hogging Saws	13
NE Circular Saw Blades „Topline“	16

DIA Hoggers

LEUCODIA-Finish Tec CM	17
LEUCODIA-Uni Tec CM	18
Power Tec CM	19
Power Tec	21
Power Tec S	25
Twin Tec "Topline" Saw Blade Design Ø 220 mm	26
Twin Tec "Topline" Compact Design Ø 220 mm	30
Spare Parts for Twin Tec Hoggers	32
Segmented Hoggers Ø 200 mm / Ø 250 mm	34
Segments for Segmented Hoggers	38
Compact Hoggers Ø 250 mm	39
Spare Parts	43



Cutters with Bore	Page
-------------------	------

DIA Postforming

DIA Panel Raising Cutters	44
DIA Radius Panel Raising Cutters	48
DIA Scribing Tools	49

Grooving

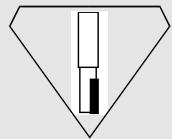
DIA Grooving Cutters	51
DIAMAX Lamello Grooving Cutters	52

Edge Trimming

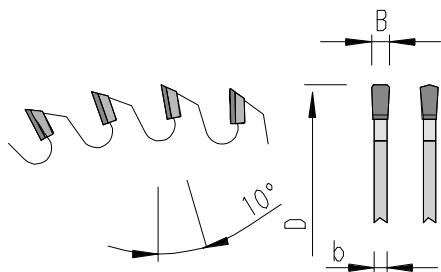
DIAMAX Edge Banding / Jointing Cutters	53
DIAMAX Edge Banding / Chamfering Cutters	56
I-System Edge Trimming	59
DIAMAX Edge Banding / Rounding Cutters	65
DIAMAX Edge Rounding and Chamfering Cutter for Stefani	72
DIAMAX Edge Rounding and Chamfering Cutter for HolzHer	73

**Jointing / Rabbeting / Chamfering /
Rounding**

DIAMAX Jointing / Rabbeting Cutters	74
DIAMAX Jointing Cutters CM	76
DIA Jointing Cutters	78
LEUCODIA Planing and Rabbeting Cutter	81
LEUCODIA Power DIA Profiler	82



Shank-Type Cutters	Page
For Conventional and CNC Routers	
LEUCODIA - DIAMAX Shank-Type Cutters (Cylindrical Shank)	83
LEUCODIA - DIAMAX High-Performance Shank-Type Cutters	86
LEUCODIA High-Performance Shank-Type Cutters	87
LEUCODIA High-Performance Shank -Type Cutters CM	89
LEUCODIA High-Performance Shank-Type Cutters	90
High-Performance Shank -Type Cutter with solid carbide body	92
High Performance - Trimming Router Bit	93
RH-LH Combination Shank-type Router Bit	94
LEUCODIA Conical Shank-Type Cutter	95
LEUCODIA Shank-Type Cutter	96
LEUCODIA Profiler	99
Technical Information	I

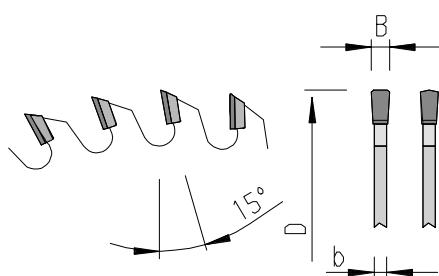


**For finished cuts in panel materials,
plastics, Corian, Varicor**

- panel materials (particleboard, MDF etc.)
 - melamine and paper laminated
 - HPL laminated
- for use on:
 - table saws against feed
 - vertical panel sizing machines (Striebig, HolzHer, etc.)
 - scoring with feed and dividing against feed e.g. on Striebig machines
- Art.-No. 202.180 resharpenable area 2 mm
- tooth configuration:
inverted-v/flat with chamfer "DA-F-FA"
- n max 6.200 min-1

202.180

Ø D mm	B mm	b mm	Ø d mm	Z	NL	Ident.-No.
250	3,2	2,2	30	48	2/10/60+2/7/42	180096
303	3,2	2,2	30	60	2/10/60+2/7/42	178781
303	3,2	2,2	30	84	2/10/60+2/7/42	178985
350	3,2	2,2	30	60	2/10/60+2/7/42	179177



For rip and cross cuts in panel materials

- for cuts in single sheets or in stacks
 - in raw, melamine and paper laminated particleboard and MDF
 - HPL laminated panel materials
 - in thermoplastics and duroplastics
- for use on panel sizing saws with pressure beams
- resharpenable area 3.5 mm
- number of teeth depends on type of feed, material to be cut, stack height, and desired quality of cut
- tooth configuration: inverted-v/flat w. chamfer "DA-F-FA"

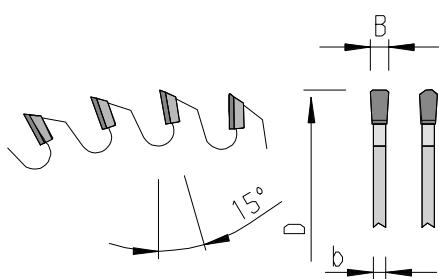
204.082

Ø D mm	B mm	b mm	Ø d mm	Z	NL / DKN	mach.	Ident.-No
400	4,4	3,2	75	60	4/15/105	Giben Prismatic 1	173666 s
400	4,4	3,2	75	72	4/15/105	Giben Prismatic 1	173667 s
400	4,8	3,5	30	60		Irion, Schelling, Mayer	173662 s
400	4,8	3,5	30	72		Irion, Schelling, Mayer	173663 s
400	4,8	3,5	60	60		Holzma, Anthon	173664 s
400	4,8	3,5	60	72		Holzma, Anthon	173665 s
430	4,4	3,2	75	60	4/15/105	Giben Prismatic 2	173670 s
430	4,4	3,2	75	72	4/15/105	Giben Prismatic 2	173671 s
430	4,8	3,5	60	60		Anthon	173668 s
430	4,8	3,5	60	72		Anthon	173669 s
450	4,8	3,5	30	60		Panhans, Irion	173672 s
450	4,8	3,5	30	72		Panhans, Irion	173673 s
450	4,8	3,5	60	60		Holzma	173674 s
450	4,8	3,5	60	72		Holzma	173675 s



For rip and cross cuts in panel materials

- for cuts in single sheets or in stacks
 - in raw, melamine and paper laminated particleboard and MDF
 - HPL laminated panel materials
 - in thermoplastics and duroplastics
- for use on panel sizing saws with pressure beams
- resharpenable area 3.5 mm
- number of teeth depends on type of feed, material to be cut, stack height, and desired quality of cut
- tooth configuration: Trapez/flat w. chamfer "TR-F-FA"

**204.082**

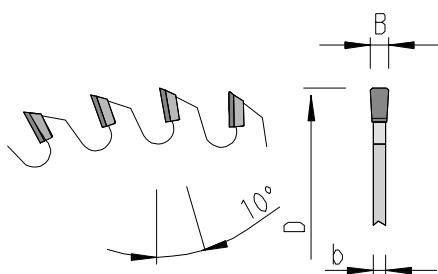
Ø D mm	B mm	b mm	Ø d mm	Z	NL	mach.	Ident.-No
380	4,8	3,5	60	72	2/14/100	Holzma	182281 s
450	4,8	3,5	60	72	2/14/100	Holzma	182282





For trimming cuts on Paul gang-rip saws

- in particle boards and MDF raw, melamine-resin-, paper laminated
- HPL laminated panel materials
- in thermoplasts and duroplasts
- fibre-strengthened materials
- gypsum plaster boards
- resharpenable area 3.5mm
- tooth configuration: flat w. chamfer "F-FA"
- Ident.-No. 181189 for hydro bushing 180455



203.040

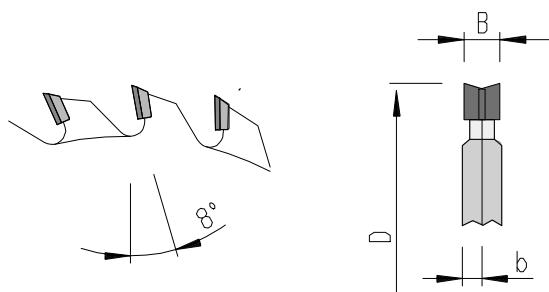
Ø D mm	B mm	b mm	Ø d mm	Z	DKW	NL	mach.	Ident.-No
250	3,2	2,2	100	36	12,5x4,5		Paul	181182
250	3,2	2,2	110	36		4/8,5/130	Paul	181189





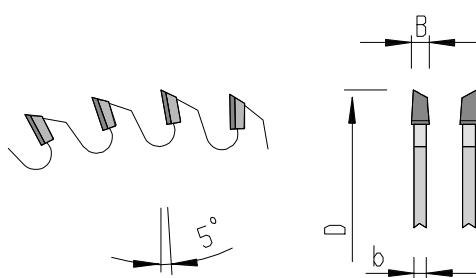
For chip-free scoring of panel materials

- particleboard and MDF panels
 - melamine and paper laminated
 - HPL covered and veneered
- on table saw
- use with feed
- two-piece set - the kerf of the scoring saw can be adjusted with shims to match main saw
- tooth configuration: each saw blade half-bevel on one side "ES"
- Ident.-No. 189104 automatic kerf adjustment



205.080

Ø D mm	B mm	b mm	Ø d mm	Z	NL	mach.	Ident.-No.
120	2,8 - 3,8	2,2	22	2 x 12	2/3,8/42	Altendorf Martin	189101
120	2,8 - 3,8	2,2	50	2 x 12	4/6,2/62	Altendorf-adjusting device	189104



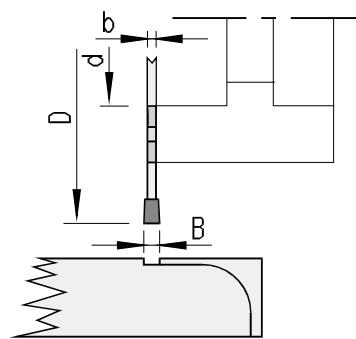
For chip-free scoring of panel materials

- particleboard and MDF panels
 - melamine and paper laminated
 - HPL laminated
- on panel sizing saws and table saws
- application with feed
- kerf "B" = kerf of the main saw blade
- table saws Art.-No. 205.091
- panel sizing saws Art.-No. 205.090
- tooth configuration: conical - alternate top bevel "KO-WS"

205.090 / 205.091

Ø D mm	B mm	b mm	Ø d mm	Z	mach.	Art.-No.	Ident.-No.
120	3,1 / 3,9	2,2	22	16	Altendorf, Martin	205091	178766
125	4,8 / 5,6	4,0	22	20	Martin	205090	173676 s
125	4,8 / 5,6	4,0	45	20	Giben	205090	173677 s
160	4,4 / 5,2	4,0	45	20	Giben Prismatic 1	205090	173680 s
180	4,8 / 5,6	4,0	20	20	Anthon	205090	173681 s
180	4,4 / 5,2	4,0	30	20	Panhans	205090	173682 s
200	4,8 / 5,6	3,5	45	20	Holzma	205090	173683 s
215	4,4 / 5,2	3,2	50	20	Giben Prismatic 1	205090	173684 s





For chip-free scoring of inlay profiles

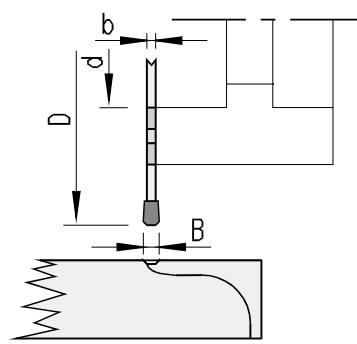
- application with feed
- resharpenable area 4.0 mm
- Art.-No. 205.010 for Homag machines
- Art.-No. 205.011 for IMA machines
- type A
 - straight flanks
 - for veneered boards
- type B
 - flanks 3 degrees conical
 - for melamine faced and plastic coated boards
- tooth configuration: flat "F"
- n max 24.000 min-1

205.010

Ø D mm	B mm	b mm	Ø d mm	Z	type	NL	Ident.-No.
70	4,0	3,0	34	8	A	4/5,3/42	168473
70	4,0	3,0	34	8	B	4/5,3/42	181145

205.011

Ø D mm	B mm	b mm	Ø d mm	Z	type	Ident.-No.
75	3,2	2,2	22	10	A	168464 s
75	3,2	2,2	22	10	B	181146 #

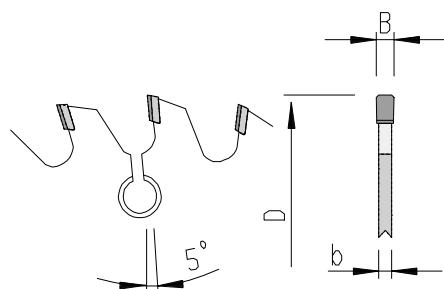


For chip-free scoring of softforming profiles on Homag machines

- for Homag flange
- application with feed
- resharpenable area 3.0 mm
- tooth configuration: flat with two-sided chamfer 1.5 x 45 degrees "F-FA"
- n max 24.000 min-1

205.080

Ø D mm	B mm	b mm	Ø d mm	Z	NL	Ident.-No.
70	4,3	3,0	34	8	4/5,3/42	168474 s



For chip-free scoring of panel materials

- for long tool life in:
 - melamine and paper laminated materials
 - HPL and foil covered and veneered panel materials
- for use on double-end tenoners and edgebanders
- application with feed
- resharpenable area 4.0 mm
- tools with pinholes:
 - Ø 50 mm NL for LEUCO S-System tool carrier type B - Ident.-No. 160849
 - Ø 65 mm NL for mounting flange Ident.-No. 006480 (Homag, Brandt, IMA) and LEUCO S-System tool carrier Type A - Ident.-No. 164770L and 164758R
- tooth configuration: flat with two-sided chamfer "F-FA"
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$

205.041

Ø D mm	B mm	b mm	Ø d mm	Z	feed min-1	NL	Ident.-No.
150	3,2	2,2	55	24	20		169321 s
150	3,2	2,2	60	24	20		170170 s
150	3,2	2,2	55	28	25		169322 s
150	3,2	2,2	60	28	25		170171 s
150	3,2	2,2	55	32	30		169323 s
150	3,2	2,2	60	32	30		170172 s
150	3,2	2,2	55	36	35		169324 s
150	3,2	2,2	60	36	35		170173 s
180	3,2	2,2	30	24	20		169325 s
180	3,2	2,2	50	24	20	3/22/80	168905 s
180	3,2	2,2	65	24	20	6/5,5/90	168906
180	3,2	2,2	30	28	25		169326 s
180	3,2	2,2	50	28	25	3/22/80	168907 s
180	3,2	2,2	65	28	25	6/5,5/90	168908 s
180	3,2	2,2	30	32	30		169327 s
180	3,2	2,2	50	32	30	3/22/80	168909 s

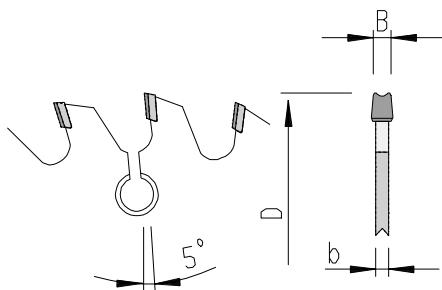


Ø D mm	B mm	b mm	Ø d mm	Z	feed min-1	NL	Ident.-No.
180	3,2	2,2	65	32	30	6/6,5/90	169328 s
180	3,2	2,2	30	36	35		169329 s
180	3,2	2,2	50	36	35	3/22/80	169330 s
180	3,2	2,2	65	36	35	6/5,5/90	169331 s
180	3,2	2,2	30	40	40		169332 s
180	3,2	2,2	50	40	40	3/22/80	169333 s
180	3,2	2,2	65	40	40	6/6,5/90	169334 s
180	3,2	2,2	30	44	45		169335 s
180	3,2	2,2	50	44	45	3/22/80	169336 s
180	3,2	2,2	65	44	45	6/5,5/90	169337 s
180	3,2	2,2	30	48	50		169338 s
180	3,2	2,2	50	48	50	3/22/80	169339 s
180	3,2	2,2	65	48	50	6/6,5/90	169340 s
200	3,2	2,2	30	24	20		169341 s
200	3,2	2,2	50	24	20	3/22/80	169342 s
200	3,2	2,2	30	28	25		169343 s
200	3,2	2,2	50	28	25	3/22/80	169344 s
200	3,2	2,2	30	32	30		169345 s
200	3,2	2,2	50	32	30	3/22/80	169346 s
200	3,2	2,2	30	36	35		169347 s
200	3,2	2,2	50	36	35	3/22/80	169348 s
200	3,2	2,2	30	40	40		169349 s
200	3,2	2,2	50	40	40	3/22/80	169350 s
200	3,2	2,2	30	44	45		169351 s
200	3,2	2,2	50	44	45	3/22/80	169352 s
200	3,2	2,2	30	48	50		169353 s
200	3,2	2,2	50	48	50	3/22/80	169354 s



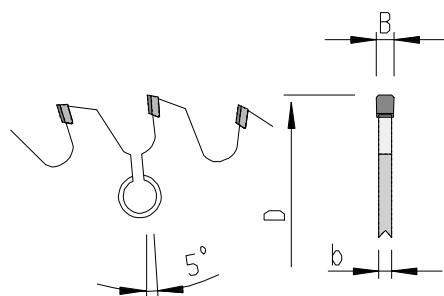
For tear-free scoring of panel materials

- panel and MDF boards
 - melamine- and paper coated
 - HPL-covered
- on panel sizing
- for use with the feed
- tooth geometry: hollow back with chamfer "HR-FA"

**205.082**

Ø D mm	B mm	b mm	Ø d mm	Z	NL	mach.	Ident.-No.
180	4,4-5,2	3,2	45	36		Holzma	189234 s
180	4,8-5,6	3,5	45	36		Holzma	182283
200	4,4-5,2	3,2	20	36		Schelling	189232 s
200	4,8-5,6	3,5	45	36		Holzma	189231 s
200	4,4-5,2	3,2	65	36	2/8,4/100+2/8,4/110	Selco	189230 s
200	4,8-5,6	3,5	65	36	2/8,4/110	Selco WN/EB	189233 s





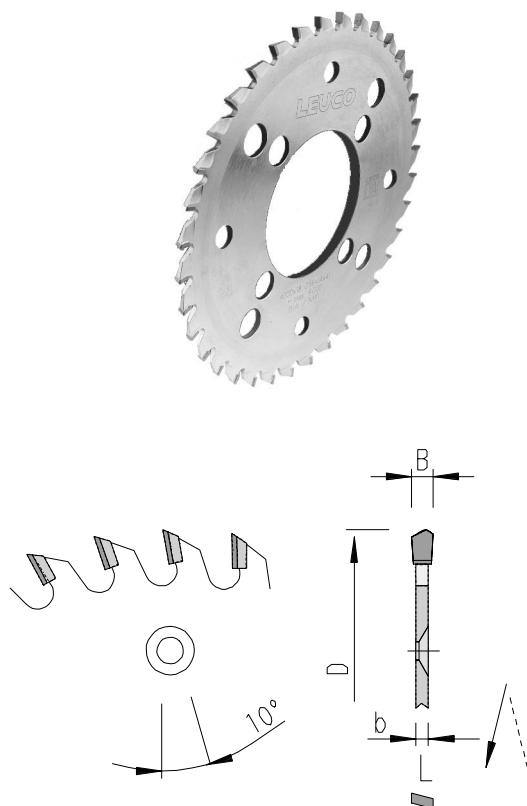
For chip-free scoring of panel materials

- for long tool life in:
 - melamine and paper laminated materials
 - HPL and foil covered and veneered panel materials
- for use on double-end tenoners and edgebanders
- application with feed
- good price/cost-ratio due to large-scale production
- reduced resharpenable area
- the specified feed rates are based on $n=6.000 \text{ min}^{-1}$
- tools with pinholes:
 - Ø 50 mm NL for LEUCO S-System tool carrier type B-Ident.-No.160849
 - Ø 65 mm NL for mounting flange Ident.-No. 006480 (Homag, Brandt, IMA) and LEUCO S-System tool carrier type A-Ident.-No.164770L and 164758R
- tooth configuration: flat with two-sided chamfer "F-FA"
- $n \max 10.000 \text{ min}^{-1}$

205.241

Ø D mm	B mm	b mm	Ø d mm	Z	feed min ⁻¹	NL	Ident.-No.
180	3,2	2,2	50	24	20	3/22/80	173712
180	3,2	2,2	65	24	20	6/6,5/90	173714
180	3,2	2,2	50	28	25	3/22/80	173716
180	3,2	2,2	50	32	30	3/22/80	173720
180	3,2	2,2	65	32	30	6/6,5/90	173722





For chip-free sizing of panel materials

- long tool life and reduced downtimes when machining:
 - melamine and paper laminated materials
 - HPL and foil covered and veneered panel materials
- for use on double-end tenoners and edgebanders
- application with feed
- for use during the scoring/hogging (RZ) and double-hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- saws with equal tooth pitch
- to combine with LEUCO segmented hoggers:
Ø 80 on segmented hogger with standard bushing
Ø 100 on segmented hogger for S-System
- tooth configuration: top bevel with chamfer and shear angle "ES-FA"
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- $n \text{ max } 9.000 \text{ min}^{-1}$ with Ø 200 mm
- $n \text{ max } 7.200 \text{ min}^{-1}$ with Ø 250 mm
- sense of rotation see drawing

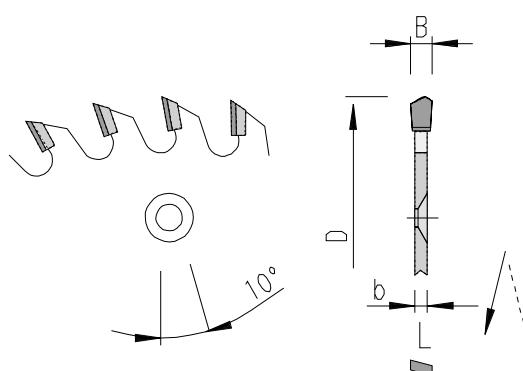
202.062

Ø D mm	B mm	b mm	Ø d mm	Z	feed RZ min-1	feed DZ min-1	L	Ident.-No. R
200	4	2,8	80	24	15	25	170397 s	170398 s
200	4	2,8	80	28	17,5	30	170399 s	170400 s
200	4	2,8	80	32	20	32,5	170401 s	170402 s
200	4	2,8	80	36	22,5	35	170403 s	170404 s
200	4	2,8	80	40	25	40	170405 s	170406 s
200	4	2,8	80	44	27,5	45	170407 s	170408 s
200	4	2,8	80	48	30	50	170409 s	170410 s
250	4	2,8	80	24	15	25	170495 s	170496 s
250	4	2,8	80	30	20	32,5	170497 s	170498 s
250	4	2,8	80	36	25	40	170499 s	170500 s
250	4	2,8	80	42	27,5	45	170501 s	170502 s
250	4	2,8	80	48	30	50	170503 s	170504 s
250	4	2,8	80	54	35	55	170505 s	170506 s
250	4	2,8	80	60	40	60	170507 s	170508 s
250	4	2,8	80	66	45	65	170509 s	170510 s



Ø D mm	B mm	b mm	Ø d mm	Z	feed RZ min-1	feed DZ min-1	Ident.-No.	
L	R							
250	4	2,8	80	72	50	70	170511 s	170512 s
250	4	2,8	100	24	15	25	170621 s	170622 s
250	4	2,8	100	30	20	32,5	170623 s	170624 s
250	4	2,8	100	36	25	40	170625	170626
250	4	2,8	100	42	27,5	45	170627 s	170628 s
250	4	2,8	100	48	30	50	170629	170630
250	4	2,8	100	54	35	55	170631 s	170632 s
250	4	2,8	100	60	40	60	170633 s	170634 s
250	4	2,8	100	66	45	65	170635 s	170636 s
250	4	2,8	100	72	50	70	170637 s	170638 s





For chip-free sizing of panel materials

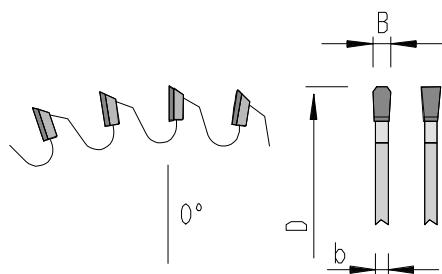
- long tool life and reduced downtimes when machining:
 - melamine and paper laminated materials
 - HPL and foil covered and veneered panel materials
 - for use on double-end tenoners and edgebanders
 - application with feed
 - for use during the scoring/hogging (RZ) and double-hogging (DZ) process
 - resharpenable area 4.0 mm
 - sides of teeth can be resharpened
 - saws with equal tooth pitch
 - to combine with LEUCO Twin Tec hoggers
- tooth configuration: top bevel with chamfer and face shear "ES-FA"
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
 - $n \max 7.200 \text{ min}^{-1}$ with $\varnothing 220 \text{ mm}$
 - sense of rotation see drawing

202.062

Ø D mm	B mm	b mm	Ø d mm	Z	feed RZ min-1	feed DZ min-1	Ident.-No. L	R
220	4	2,8	80	24	15	25	171353 s	171354 s
220	4	2,8	80	30	20	32,5	171355 s	171356 s
220	4	2,8	80	36	25	40	171357	171358
220	4	2,8	80	42	27,5	45	171359 s	171360 s
220	4	2,8	80	48	30	50	171361 s	171362 s
220	4	2,8	80	54	35	55	171363 s	171364 s
220	4	2,8	80	60	40	60	171365 s	171366 s

For sizing and miter cuts in aluminum profiles

- On Chop and Miter Saws
- neutral hook angle requires tight workpiece clamping
- tooth geometry:
Triple Chip Flat Chamfer "TR-F-FA" for NF-Solid
Triple Chip Flat "TR-F" for NF-Profiles
- special laser ornaments and tooth partition for excellent burr-free cuts with low roughness (utility patent applied for)



for solid NF-material

208.080

Ø D mm	B mm	b mm	Ø d mm	Z	NL	Mach.	Ident.-No
500	4	3,4	50	90	4/15/80	Kaltenbach RKL 550	189064 s
500	4	3,4	30	90		Elumatec	189065 s
550	4,4	3,8	50	96	4/15/80	Kaltenbach RKL 550	189066 s

for NF-profiles

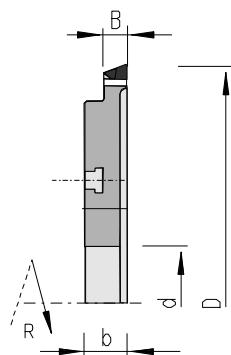
208.070

Ø D mm	B mm	b mm	Ø d mm	Z	NL	Mach.	Ident.-No
275	3,4	2,8	32	60	4/9/50	Wagner 1994	189067 s
285	3,4	2,8	32	60	4/9/50	Wagner	189068 s
380	3,4	3	32	84	4/9/50	Elumatec	189069 s
400	3,6	3,2	40	90	2/12/80	Eisele VA-L 350 NC1	189070 s
500	3,8	3,4	30	108	2/10/70	Elumatec	189071 s
550	4,1	3,6	30	120		Elumatec MGS	189072 s



**For chip-free sizing of panel materials
optimised chip removal (Chip-Meister)**

- New: improved chip deflection by means of chip deflection integrated in the tool
 - reduced cleaning efforts
 - reduced dust extraction performance
- high cutting quality by means of divided cut in pre and after cut
- longest edge lives by means of optimised tooth geometry
- machining of:
 - panel boards with loose intermediate ply raw, Melamine-coated, foil,...)
 - recycling-panel boards
 - panel boards with sensitive coatings
- On Double End Tenoners in double hogging
- for Homag-Completeline-Technique
- for thinnest glued joints
- New: machining of 8 mm boards also possible
- resharpening area 4 mm
- nmax 6.000 min-1
- sense of rotation acc. to DIN-EN 50144



For LEUCO Hydro-S System / LEUCO S-System Ø 160 and bush

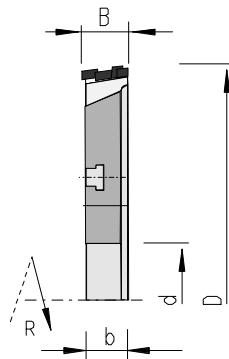
215.085

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m/min	Ident.-No.	
L	R						
250	10	23	60	36+6	40	182025 s	182024 s
250	10	23	60	48+8	55	182027 s	182026 s
250	10	23	60	60+12	70	182029 s	182028 s



**For chip-free sizing of panel materials
optimised chip removal (Chip-Meister)**

- New: improved chip deflection by means of chip deflection integrated in the tool
 - reduced cleaning efforts
 - reduced dust extraction performance
- high cutting quality by means of divided cut in pre and after cut
- longest edge lives by means of optimised tooth geometry
- machining of:
 - panel boards with loose intermediate ply raw, Melamine-coated, foil,...)
 - recycling-panel boards
 - panel boards with sensitive coatings
- On Double End Tenoners in double hogging
- New: machining of 8 mm boards also possible
- resharpening area 4 mm
- nmax 6.000 min⁻¹
- sense of rotation acc. to DIN-EN 50144



For LEUCO Hydro-S System / LEUCO S-System Ø 160 and bush

215.084

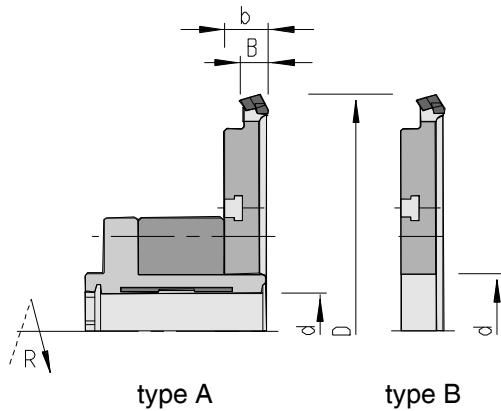
Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m/min	Ident.-No.	
L	R						
250	8	23	60	24+12	30	182115 s	182114 s
250	8	23	60	36+18	45	182031	182030
250	8	23	60	48+24	60	182033	182032
250	8	23	60	54+27	70	182035 s	182034 s
250	16	23	60	36+18+6	45	182037 s	182036 s
250	16	23	60	48+24+6	60	182039 s	182038 s
250	16	23	60	54+27+9	70	182041 s	182040 s
250	24	23	60	36+18+6+6	45	182048 s	182042 s
250	24	23	60	48+24+6+6	60	182045 s	182044 s
250	24	23	60	54+27+9+9	70	182047 s	182046 s

For LEUCO S-System Ø 192

215.084

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m/min	Ident.-No.	
L	R						
250	8	23	80	24+12	30	182117 s	182116 s
250	8	23	80	36+18	45	182119 s	182118 s
250	8	23	80	48+24	60	182121 s	182120 s





For tear-free forming of panel materials with optimized chip evacuation (Chip Meister)

- NEW: improved chip evacuation integrated into the tool
 - reduced cleaning efforts
 - reduced suction performance
 - high cutting quality thanks to division of cut into:
 - noise optimized hogging tooth
 - quality-optimized finishing tooth with rounded edge
 - longest edge lives thanks to optimized tooth geometry
 - machining of:
 - panel- and MDF-boards (raw, coated - melamine, veneer, foil, ...)
 - other panel materials
 - NEW: machining of 8 mm boards is also possible
 - used on DET
 - double-hogging
 - resharpening area 4 mm
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type A with hydro-bush

215.051

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	40	12 + 12	30	180961 s	180962 s
250	14,5	23	40	18 + 18	50	180963 s	180964 s
250	14,5	23	40	24 + 24	70	180965 s	180966 s
250	14,5	23	40	28 + 28	100	180967 s	180968 s

type B for LEUCO Hydro-S System / LEUCO S-System Ø 160

215.052

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	60	12 + 12	30	180969	180970
250	14,5	23	60	18 + 18	50	180971	180972
250	14,5	23	60	24 + 24	70	180973 s	180974 s
250	14,5	23	60	28 + 28	100	180975 s	180976 s

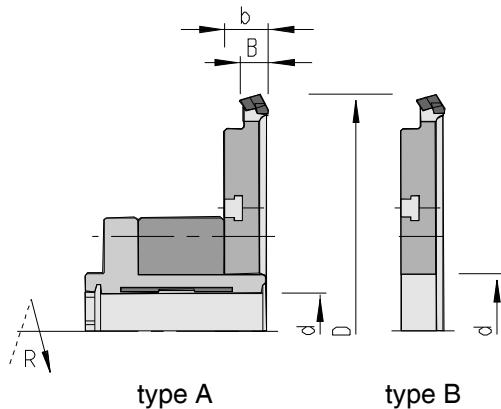


type D for LEUCO S-System Ø 192

215.052

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	80	12 + 12	30	180977 s	180978 s
250	14,5	23	80	18 + 18	50	180979 s	180980 s
250	14,5	23	80	24 + 24	70	180981 s	180982 s
250	14,5	23	80	28 + 28	100	180983 s	180984 s





For chip-free sizing of panel materials even with high feed-speeds

- high quality of cut due to division of cut into:
 - low-noise hogger tooth
 - finished-cut tooth for optimum quality with closed cutting edges
- optimised teeth form ensures long tool life
- noise reduction improves work environment
- machining of:
 - particle and MDF boards (raw, melamine veneer, foil laminated, ...)
 - other panel materials
- used on double-end tenoners with feed (HOMAG, IMA, Torwegge...)
- double-hogging
- resharpenable area 4mm
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type A with hydro-bush

215.051

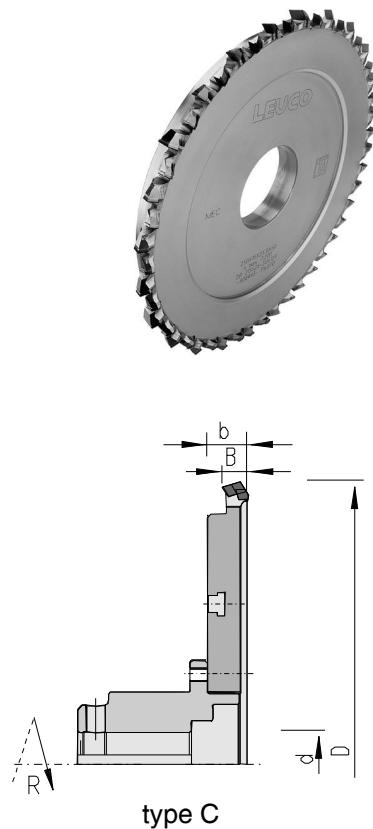
Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	40	12 + 12	30	179440 &	179439 &
250	14,5	23	40	18 + 18	50	179442 &	179441 &
250	14,5	23	40	24 + 24	70	179444 s	179443 s
250	14,5	23	40	28 + 28	100	179446 s	179445 s

type B for LEUCO Hydro-S System / LEUCO S-System Ø 160

215.052

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	60	12 + 12	30	179432	179431
250	14,5	23	60	18 + 18	50	179434	179433
250	14,5	23	60	24 + 24	70	179436 s	179435 s
250	14,5	23	60	28 + 28	100	179438 s	179437 s





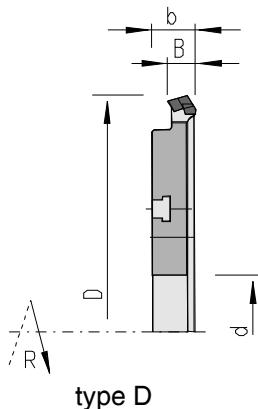
For chip-free sizing of panel materials even with high feed-speeds

- high quality of cut due to division of cut into:
 - low-noise hogger tooth
 - finished-cut tooth for optimum quality with closed cutting edges
- optimised teeth form ensures long tool life
- noise reduction improves work environment
- machining of:
 - particle and MDF boards (raw, melamine veneer, foil laminated, ...)
 - other panel materials
- used on double-end tenoners with feed (Homag)
- double-hogging
- resharpenable area 4mm
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type C on standart bushing (HOMAG)

215.051

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
						L	R
250	14,5	23	35	12 + 12	30	180124 &	180123 &
250	14,5	23	35	18 + 18	50	180126 &	180125 &
250	14,5	23	35	24 + 24	70	180128 &	180127 &
250	14,5	23	35	28 + 28	100	180130 &	180129 &
250	14,5	23	40	12 + 12	30	180132 &	180131 &
250	14,5	23	40	18 + 18	50	180134 &	180133 &
250	14,5	23	40	24 + 24	70	180136 &	180135 &
250	14,5	23	40	28 + 28	100	180138 &	180137 &



For chip-free sizing of panel materials even with high feed-speeds

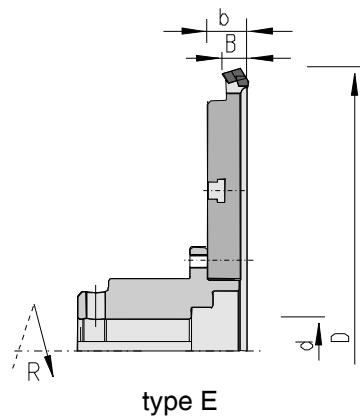
- high quality of cut due to division of cut into:
 - low-noise hogger tooth
 - finished-cut tooth for optimum quality with closed cutting edges
- optimised teeth form ensures long tool life
- noise reduction improves work environment
- machining of:
 - particle and MDF boards (raw, melamine veneer, foil laminated, ...)
 - other panel materials
- used on double-end tenoners with feed (Homag, IMA, Torwegge...)
- double-hogging
- resharpenable area 4mm
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type D for LEUCO S-System Ø 192

215.052

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
L	R						
250	14,5	23	80	12 + 12	30	180109 s	180108 s
250	14,5	23	80	18 + 18	50	180111	180110
250	14,5	23	80	24 + 24	70	180113 s	180112 s
250	14,5	23	80	28 + 28	100	180115 s	180114 s





For chip-free sizing of panel materials even with high feed-speeds

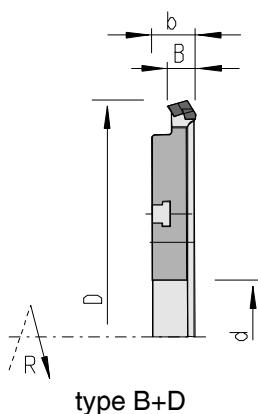
- high quality of cut due to division of cut into:
 - low-noise hogger tooth
 - finished-cut tooth for optimum quality with closed cutting edges
- optimised teeth form ensures long tool life
- noise reduction improves work environment
- machining of:
 - particle and MDF boards (raw, melamine veneer, foil laminated, ...)
 - other panel materials
- used on double-end tenoners with feed (IMA)
- double-hogging
- resharpenable area 4mm
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type E on standart bushing (IMA)

215.051

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	Ident.-No.	
L	R						
250	14,5	23	35	12 + 12	30	180507 s	180506 s
250	14,5	23	35	18 + 18	50	180509 s	180508 s
250	14,5	23	35	24 + 24	70	180511 s	180510 s
250	14,5	23	35	28 + 28	100	180513 s	180512 s
250	14,5	23	40	12 + 12	30	180515 s	180514 s
250	14,5	23	40	18 + 18	50	180517 s	180516 s
250	14,5	23	40	24 + 24	70	180519 s	180518 s
250	14,5	23	40	28 + 28	100	180521 s	180520 s





For chip-free sizing of panel materials even with high feed-speeds

- high quality of cut due to division of cut into:
 - low-noise hogger tooth
 - finished-cut tooth for optimum quality with closed cutting edges
- optimised teeth form ensures long tool life
- noise reduction improves work environment
- machining of:
 - particle and MDF boards (raw, melamine veneer, foil laminated, ...)
 - other panel materials
- used on double-end tenoners with feed (Homag, IMA, Torwegge...)
- double-hogging
- resharpenable area 4mm
- optimized pitch for machining of small and medium-sized hogging widths
- n max 6.000 min-1
- sense of rotation acc. to DIN-EN 50144

type B for LEUCO S-System Ø 160

215.052

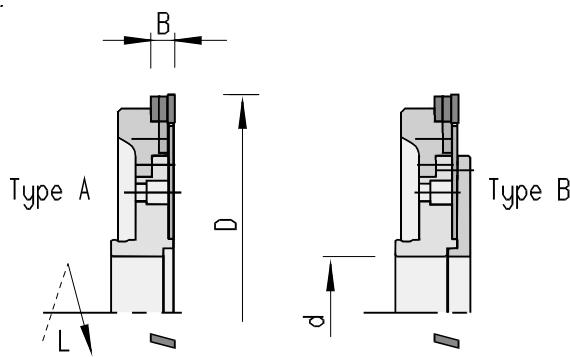
Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	L	Ident.-No. R
250	14,5	23	60	16 +8+4	30	182217 s	182218 s
250	14,5	23	60	20 +10+5	45	182219 s	182220 s
250	14,5	23	60	24 +12+6	60	182221 s	182222 s
250	14,5	23	60	28 +14+7	80	182223 s	182224 s
250	14,5	23	60	32 +16+8	100	182225 s	182226 s

type D for LEUCO S-System Ø 192

215.052

Ø D mm	B mm	b mm	Ø d mm	Z	feed DZ m / min	L	Ident.-No. R
250	14,5	23	80	16 +8+4	30	182227 s	182228 s
250	14,5	23	80	20 +10+5	45	182229 s	182230 s
250	14,5	23	80	24 +12+6	60	182231 s	182232 s
250	14,5	23	80	28 +14+7	80	182233 s	182234 s
250	14,5	23	80	32 +16+8	100	182235 s	182236 s





For chip-free sizing of panel materials

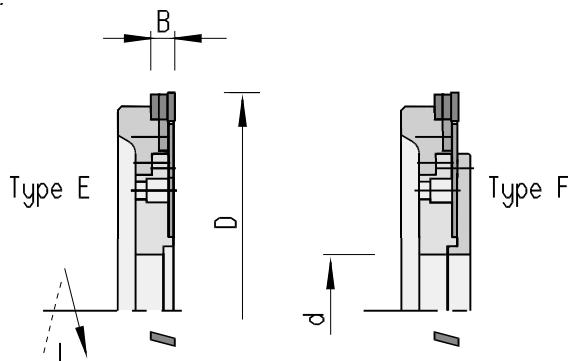
- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials covered with HPL, foil and veneer
- cut division of the HW cutting edges ensures optimum hogging of the offal
- application on double-end tenoners and edge trimming machines with feed
- for the scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- segments in the hogging component Z = 1 solid tungsten carbide with shear angle
- the feed rates specified are for n = 6.000 min-1
- fits LEUCO S-System Ø 160 mm
- n max 7.200 min-1

S-System Ø 160 mm

215.012

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	type	Ident.-No. L	Ident.-No. R
220	13	60	24 + (6x2)		25		171311 s	171312 s
220	13	60	24 + (6x2)	15			171255 s	171256 s
220	13	60	30 + (6x2)		32,5		171313 s	171314 s
220	13	60	30 + (6x2)	20			171257 s	171258 s
220	13	60	36 + (6x2)		40		171315 s	171316 s
220	13	60	36 + (6x2)	25			171259 s	171260 s
220	13	60	42 + (6x2)		45		171317 s	171318 s
220	13	60	42 + (6x2)	27,5			171261 s	171262 s
220	13	60	48 + (6x2)		50		171319 s	171320 s
220	13	60	48 + (6x2)	30			171263 s	171264 s
220	13	60	54 + (6x2)		55		171321 s	171322 s
220	13	60	54 + (6x2)	35			171265 s	171266 s
220	13	60	60 + (6x2)		60		171323 s	171324 s
220	13	60	60 + (6x2)	40			171267 s	171268 s





For chip-free sizing of panel materials

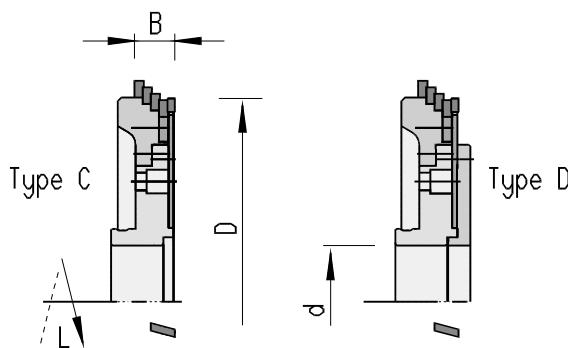
- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials covered with HPL, foil and veneer
- cut division of the HW cutting edges ensures optimum hogging of the offal
- application on double-end tenoners and edge trimming machines with feed
- for the scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- segments in the hogging part Z = 1 solid tungsten carbide with shear angle
- feed rates are based on n = 6.000 min⁻¹
- fits Hydro S-System Ø 160 mm
- n max. 7.200 min⁻¹

Hydro S-System Ø 160 mm

215.012

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	type	Ident.-No. L	Ident.-No. R
220	13	60	24 + (6x2)		25		172602 s	172603 s
220	13	60	24 + (6x2)	15			172532 s	172533 s
220	13	60	30 + (6x2)		32,5		172604 s	172605 s
220	13	60	30 + (6x2)	20			172534 s	172535 s
220	13	60	36 + (6x2)		40		172606 s	172607 s
220	13	60	36 + (6x2)	25			172536 s	172537 s
220	13	60	42 + (6x2)		45		172608 s	172609 s
220	13	60	42 + (6x2)	27,5			172538 s	172539 s
220	13	60	48 + (6x2)		50		172610 s	172611 s
220	13	60	48 + (6x2)	30			172540 s	172541 s
220	13	60	54 + (6x2)		55		172612 s	172613 s
220	13	60	54 + (6x2)	35			172542 s	172543 s
220	13	60	60 + (6x2)		60		172614 s	172615 s
220	13	60	60 + (6x2)	40			172544 s	172545 s





For chip-free sizing of panel materials

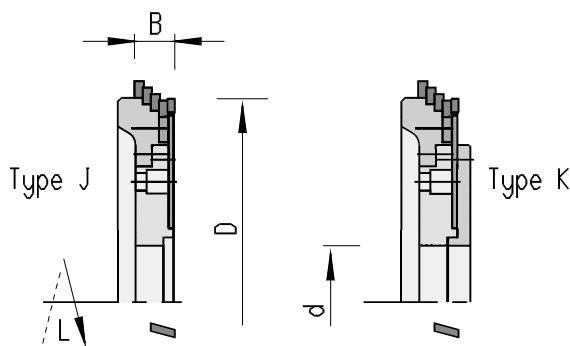
- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials covered with HPL, foil and veneer
- stepped cut design prevents chipping of the ends when cutting across the grain
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- segments in the hogging part Z = 1 solid tungsten carbide with shear angle
- feed rates are based on n = 6.000 min⁻¹
- fits LEUCO S-System Ø 160 mm
- n max 7.200 min⁻¹

S-System Ø 160 mm

215.022

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No.	
						L	R
220	22	60	24 + (6x4)		25	D	172333 s 172334 s
220	22	60	24 + (6x4)	15		C	172305 s 172306 s
220	22	60	30 + (6x4)		32,5	D	172335 s 172336 s
220	22	60	30 + (6x4)	20		C	172307 s 172308 s
220	22	60	36 + (6x4)		40	D	172337 s 172338 s
220	22	60	36 + (6x4)	25		C	172309 s 172310 s
220	22	60	42 + (6x4)		45	D	172339 s 172340 s
220	22	60	42 + (6x4)	27,5		C	172311 s 172312 s
220	22	60	48 + (6x4)		50	D	172341 s 172342 s
220	22	60	48 + (6x4)	30		C	172313 s 172314 s
220	22	60	54 + (6x4)		55	D	172343 s 172344 s
220	22	60	54 + (6x4)	35		C	172315 s 172316 s
220	22	60	60 + (6x4)		60	D	172345 s 172346 s
220	22	60	60 + (6x4)	40		C	172317 s 172318 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials covered with HPL, foil and veneer
- stepped cut design prevents chipping of the ends when cutting across the grain
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- segments in the hogging part Z = 1 solid tungsten carbide with shear angle
- feed rates are based on n = 6.000 min⁻¹
- fits LEUCO Hydro S-System Ø 160 mm
- n max 7.200 min⁻¹

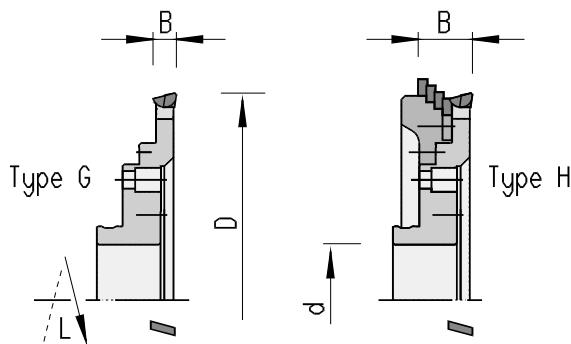
Hydro S-System Ø 160 mm

215.022

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	type	Ident.-No. L	Ident.-No. R
220	22	60	24 + (6x4)		25		172630 s	172631 s
220	22	60	24 + (6x4)	15			172560 s	172561 s
220	22	60	30 + (6x4)		32,5		172632 s	172633 s
220	22	60	30 + (6x4)	20			172562 s	172563 s
220	22	60	36 + (6x4)		40		172634 s	172635 s
220	22	60	36 + (6x4)	25			172564 s	172565 s
220	22	60	42 + (6x4)		45		172636 s	172637 s
220	22	60	42 + (6x4)	27,5			172566 s	172567 s
220	22	60	48 + (6x4)		50		172638 s	172639 s
220	22	60	48 + (6x4)	30			172568 s	172569 s
220	22	60	54 + (6x4)		55		172640 s	172641 s
220	22	60	54 + (6x4)	35			172570 s	172571 s
220	22	60	60 + (6x4)		60		172642 s	172643 s
220	22	60	60 + (6x4)	40			172572 s	172573 s



For chip-free sizing of panel materials



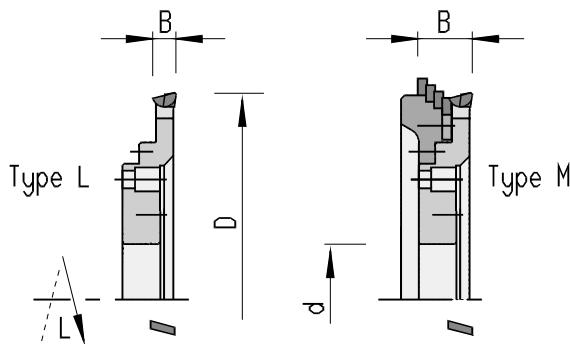
- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - HPL and foil laminated panel materials
- stepped cut design prevents chipping of the ends when cutting across the grain
- hogging part is not required for small offal widths
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 6.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- segments in the hogging part Z = 1 solid tungsten carbide with shear angle
- feed rates are based on n = 6.000 min⁻¹
- fits LEUCO S-System Ø 160 mm
- n max 7.200 min⁻¹

S-System Ø 160 mm

215.062

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	type	Ident.-No.	
							L	R
224	11,5	60	24+6	15	25		172874 s	172875 s
224	11,5	60	30+6	20	32,5		172887 s	172888 s
224	11,5	60	36+6	25	40		172876 s	172877 s
224	11,5	60	42+6	27,5	45		172889 s	172890 s
224	11,5	60	48+6	30	50		172878 s	172879 s
224	29	60	24+6+(6x4)	15	25		172891 s	172892 s
224	29	60	30+6+(6x4)	20	32,5		172893 s	172894 s
224	29	60	36+6+(6x4)	25	40		172895 s	172896 s
224	29	60	42+6+(6x4)	27,5	45		172897 s	172898 s
224	29	60	48+6+(6x4)	30	50		172899 s	172900 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - HPL and foil laminated panel materials
- stepped cut design prevents chipping of the ends when cutting across the grain
- hogging part is not required for small offal widths
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 6.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- segments in the hogging part Z = 1 solid tungsten carbide with shear angle
- feed rates are based on n = 6.000 min⁻¹
- fits LEUCO Hydro S-System Ø 160 mm
- n max 7.200 min⁻¹

Hydro S-System Ø 160 mm

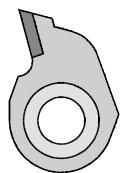
215.062

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	type	Ident.-No.	
							L	R
224	11,5	60	24+6	15	25		172901 s	172902 s
224	11,5	60	30+6	20	32,5		172903 s	172904 s
224	11,5	60	36+6	25	40		172905 s	172906 s
224	11,5	60	42+6	27,5	45		172907 s	172908 s
224	11,5	60	48+6	30	50		172909 s	172910 s
224	29	60	24+6+(6x4)	15	25		172911 s	172912 s
224	29	60	30+6+(6x4)	20	32,5		172913 s	172914 s
224	29	60	36+6+(6x4)	25	40		172915 s	172916 s
224	29	60	42+6+(6x4)	27,5	45		172917 s	172918 s
224	29	60	48+6+(6x4)	30	50		172919 s	172920 s



For use in the TwinTec hogger part

- Z = 1 solid tungsten carbide or LEUCODIA tipped
- shear angle
- one set consists of 6 segments
- completely tipped for:
 - circular cut: 12 segments
 - stepped cut: 24 segments

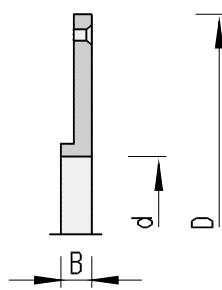
**150.501 / 232.921**

	Art.-No.	Ident.-No.	
		L	R
LEUCODIA	232921	171234	171235
LEUCODUR	150501	171232	171233



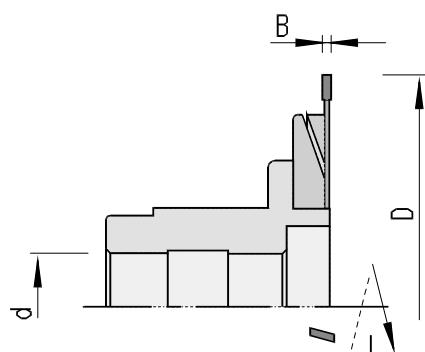
**For attaching of the hogger saw blades to
TwinTec hoggers**

- during the double hogging process the saw is attached to the flange by screws
- included in delivery:
 - flange, countersunk screws M5x16 mm

**997.300**

Ø D mm	B mm	d mm	Art.-No	Ident.-No.
170	12	60	997300	171367 s





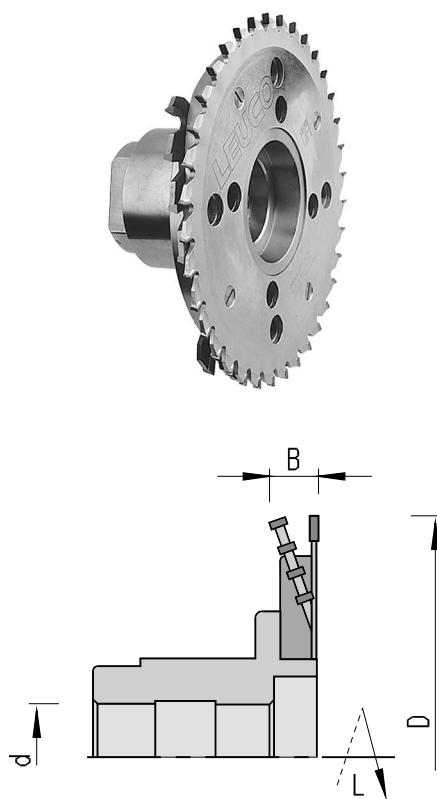
For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- for combination with shear angle segments
 - HW Art.-No. 116.200
 - LEUCODIA Art.-No. 216.200
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- bushing-mounted
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$

215.031

Ø D mm	B mm	Ø d mm	DKN mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No.	
L	R							
200	4	35	10x3,3	24	15	25	170439 s	170440 s
250	4	35	10x3,3	24	15	25	170549 s	170550 s
200	4	35	10x3,3	28	17,5	30	170441 s	170442 s
250	4	35	10x3,3	30	20	32,5	170551 s	170552 s
200	4	35	10x3,3	32	20	32,5	170443 s	170444 s
200	4	35	10x3,3	36	22,5	35	170445 s	170446 s
250	4	35	10x3,3	36	25	40	170553 s	170554 s
200	4	35	10x3,3	40	25	40	170447 s	170448 s
250	4	35	10x3,3	42	27,5	45	170555 s	170556 s
200	4	35	10x3,3	44	27,5	45	170449 s	170450 s
200	4	35	10x3,3	48	30	50	170451 s	170452 s
250	4	35	10x3,3	48	30	50	170557 s	170558 s
250	4	35	10x3,3	54	35	55	170559 s	170560 s
250	4	35	10x3,3	60	40	60	170561 s	170562 s
250	4	35	10x3,3	66	45	65	170563 s	170564 s
250	4	35	10x3,3	72	50	70	170565 s	170566 s





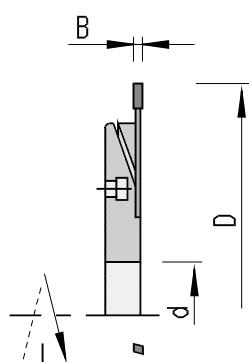
For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- cut division of the HW cutting edges ($Z=4$ with shear angle) ensures optimum hogging of the offal
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- bushing-mounted
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$

215.031

Ø D mm	B mm	Ø d mm	DKN mm	Z segment	feed RZ m / min	feed DZ m / min	Ident.-No.	
							L	R
200	18	35	10x3,3	24	4 x 4	15	25	170453 s 170454 s
250	18	35	10x3,3	24	6 x 4	15	25	170567 s 170568 s
200	18	35	10x3,3	28	4 x 4	17,5	30	170455 s 170456 s
250	18	35	10x3,3	30	6 x 4	20	32,5	170569 s 170570 s
200	18	35	10x3,3	32	4 x 4	20	32,5	170457 s 170458 s
200	18	35	10x3,3	36	4 x 4	22,5	35	170459 s 170460 s
250	18	35	10x3,3	36	6 x 4	25	40	170571 s 170572 s
200	18	35	10x3,3	40	4 x 4	25	40	170461 s 170462 s
250	18	35	10x3,3	42	6 x 4	27,5	45	170573 s 170574 s
200	18	35	10x3,3	44	4 x 4	27,5	45	170463 s 170464 s
200	18	35	10x3,3	48	4 x 4	30	50	170465 s 170466 s
250	18	35	10x3,3	48	6 x 4	30	50	170575 s 170576 s
250	18	35	10x3,3	54	6 x 4	35	55	170577 s 170578 s
250	18	35	10x3,3	60	6 x 4	40	60	170579 s 170580 s
250	18	35	10x3,3	66	6 x 4	45	65	170581 s 170582 s
250	18	35	10x3,3	72	6 x 4	50	70	170583 s 170584 s





For chip-free sizing of panel materials

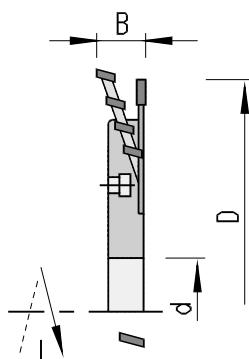
- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- for combination with shear angle segments
 - HW Art.-No. 116.200
 - LEUCODIA Art.-No. 216.200
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- fits LEUCO S-System Ø 192 mm
- $n \text{ max } 7.200 \text{ min}^{-1}$

S-System Ø 192 mm

215.032

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No.	
L	R						
250	4	80	24	15	25	170675 s	170676 s
250	4	80	30	20	32,5	170677 s	170678 s
250	4	80	36	25	40	170679 s	170680 s
250	4	80	42	27,5	45	170681 s	170682 s
250	4	80	48	30	50	170683 s	170684 s
250	4	80	54	35	55	170685 s	170686 s
250	4	80	60	40	60	170687 s	170688 s
250	4	80	66	45	65	170689 s	170690 s
250	4	80	72	50	70	170691 s	170692 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- cut division of the HW cutting edges ($Z=4$ with shear angle) ensures optimum hogging of the offal
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration: top bevel with chamfer and shear angle
- saws with equal tooth pitch
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- fits LEUCO S-System Ø 192 mm
- $n \text{ max } 7.200 \text{ min}^{-1}$

S-System Ø 192 mm

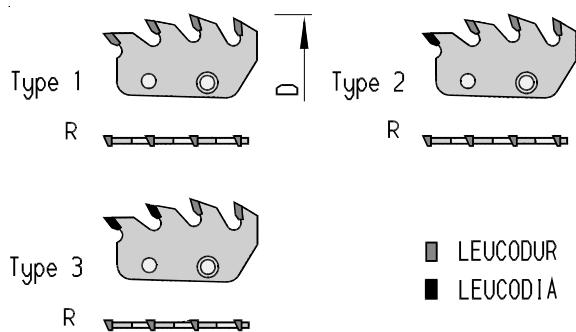
215.032

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No.	
L	R						
250	18	80	24	15	25	170693 s	170694 s
250	18	80	30	20	32,5	170695 s	170696 s
250	18	80	36	25	40	170697 s	170698 s
250	18	80	42	27,5	45	170699 s	170700 s
250	18	80	48	30	50	170701 s	170702 s
250	18	80	54	35	55	170703 s	170704 s
250	18	80	60	40	60	170705 s	170706 s
250	18	80	66	45	65	170707 s	170708 s
250	18	80	72	50	70	170709 s	170710 s



For complete hogging of the offal in panel materials

- for offal widths to 18 mm
- when used with LEUCODIA hoggers (without recess) the first tooth of the segment features a ten degree bevel on the side of the tooth
- ready-to-use in LEUCODIA segmented hoggers Ø 200 mm and Ø 250 mm Art.-No. 215.326 and 215.526
- face shear configuration
- segments must be installed in sets. One set consists of:
 - 4 segments for Ø 200 mm
 - 6 segments for Ø 250 mm
- for scoring/hogging (RZ) and double hogging (DZ)
- type 1, 2 and 3 for circular cut
- stepped cut configuration (HW tipped) - no end chipping when cutting across the grain
- order in sets or numbers divisible into sets

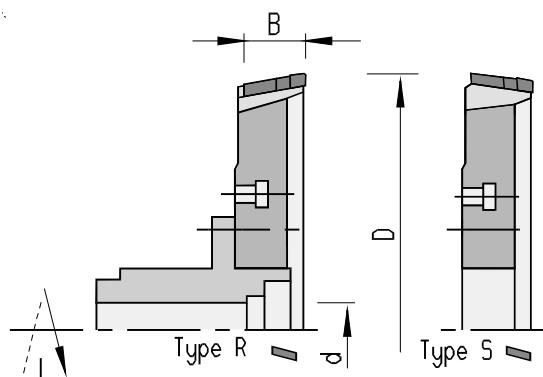


LEUCODUR
 LEUCODIA

116.200 / 216.200

for Ø D mm	Z	type	Art.-No.	Ident.-No.	
				L	R
200/250	4	1	116200	171395	171396
200/250	4	stepped cut	116200	177376	177377
200/250	1 +3	2	216200	172288	172289
200/250	2 +2	3	216200	172290	172291





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration:
 - type "R": top bevel with chamfer and shear angle for cutting with the grain
 - type "S": ascending chamfer and shear angle for cutting against the grain
- bushing-mounted
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$

cutting with the grain type R

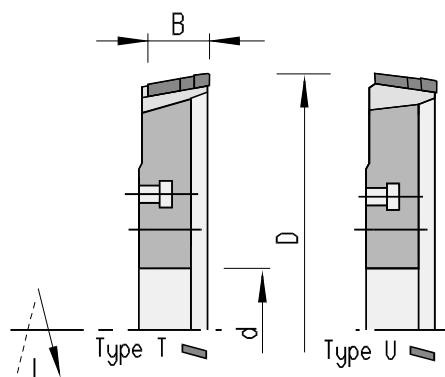
215.081

Ø D mm	B mm	Ø d mm	DKN	Z	feed RZ m / min	feed DZ m / min	Ident.-No.
L	R						
250	10/20	35	10x3,3	30+6+6	20	32,5	176584 s 176585 s
250	10/20	35	10x3,3	36+6+6	25	40	176586 & 176587 &
250	10/20	35	10x3,3	42+6+6	27,5	45	176588 s 176589 s
250	10/20	35	10x3,3	48+6+6	30	50	176590 s 176591 s
250	10/20	35	10x3,3	60+6+6	40	60	176592 s 176593 s

cutting across the grain type S

Ø D mm	B mm	Ø d mm	DKN	Z	feed RZ m / min	feed DZ m / min	Ident.-No.
L	R						
250	10/20	35	10x3,3	30+6+6	20	32,5	176604 s 176605 s
250	10/20	35	10x3,3	36+6+6	25	40	176606 s 176607 s
250	10/20	35	10x3,3	42+6+6	27,5	45	176608 & 176609 &
250	10/20	35	10x3,3	48+6+6	30	50	176610 s 176611 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration:
 - type "T": top bevel with chamfer and shear angle for cutting with the grain
 - type "U": ascending chamfer and shear angle for cutting against the grain
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- fits LEUCO S-System Ø 192 mm

cutting with the grain type T

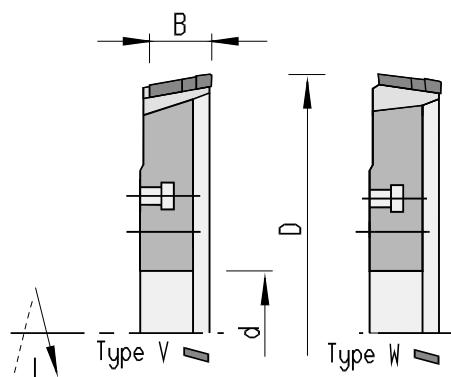
215.082

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	80	30+6+6	20	32,5	176594 s	176595 s
250	10/20	80	36+6+6	25	40	176596	176597
250	10/20	80	42+6+6	27,5	45	176598 s	176599 s
250	10/20	80	48+6+6	30	50	176600 s	176601 s
250	10/20	80	60+6+6	40	60	176602 s	176603 s

cutting across the grain type U

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	80	30+6+6	20	32,5	176612 s	176613 s
250	10/20	80	36+6+6	25	40	176614 s	176615 s
250	10/20	80	42+6+6	27,5	45	176616 s	176617 s
250	10/20	80	48+6+6	30	50	176618 s	176619 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration:
 - type "V": top bevel with chamfer and shear angle for cutting with the grain
 - type "W": ascending chamfer and shear angle for cutting against the grain
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- fits LEUCO Hydro-S-System Ø 160 mm

cutting with the grain type V

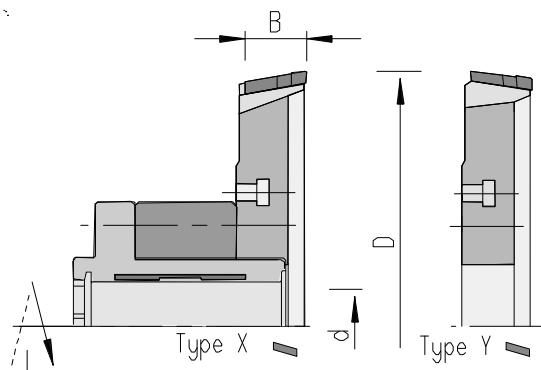
215.082

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	60	30+6+6	20	32,5	176620 s	176621 s
250	10/20	60	36+6+6	25	40	176622 s	176623 s
250	10/20	60	42+6+6	27,5	45	176624 s	176625 s
250	10/20	60	48+6+6	30	50	176626 s	176627 s
250	10/20	60	60+6+6	40	60	176628 s	176629 s

cutting across the grain type W

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	60	30+6+6	20	32,5	176640 s	176641 s
250	10/20	60	36+6+6	25	40	176642 s	176643 s
250	10/20	60	42+6+6	27,5	45	176644 s	176645 s
250	10/20	60	48+6+6	30	50	176646 s	176647 s





For chip-free sizing of panel materials

- high-precision axial and radial running accuracies for excellent quality of cut
- long tool life and decreased downtimes when machining:
 - melamine and paper laminated
 - panel materials laminated with HPL, foil and veneer
- application on double-end tenoners and edge trimming machines with feed
- for scoring/hogging (RZ) and double hogging (DZ) process
- resharpenable area 4.0 mm
- sides of teeth can be resharpened
- tooth configuration:
 - type "X": top bevel with chamfer and shear angle for cutting with the grain
 - type "Y": ascending chamfer and shear angle for cutting against the grain
- mounted onto Hydro bushing with hex socket, fits precision motors with shaft diameter 40 mm
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$

cutting with the grain type X

215.081

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	40	30+6+6	20	32,5	176630 s	176631 s
250	10/20	40	36+6+6	25	40	176632 s	176633 s
250	10/20	40	42+6+6	27,5	45	176634 s	176635 s
250	10/20	40	48+6+6	30	50	176636 s	176637 s
250	10/20	40	60+6+6	40	60	176638 s	176639 s

cutting across the grain type Y

Ø D mm	B mm	Ø d mm	Z	feed RZ m / min	feed DZ m / min	Ident.-No. L	R
250	10/20	40	30+6+6	20	32,5	176648 s	176649 s
250	10/20	40	36+6+6	25	40	176650 s	176651 s
250	10/20	40	42+6+6	27,5	45	176652 s	176653 s
250	10/20	40	48+6+6	30	50	176654 s	176655 s



Twin Tec Hogger

			Art.-No.	Ident.-No.
Torx cylindrical-head screw	for hogger ring	M5x12 T 20	995115	171237
Torx countersunk screw to attach the flange		M5x16 T 20	995125	164839
Torx countersunk screw to attach the saw without flange		M5x10 T 20	995125	171236
Torx countersunk screw for segments		M5x13,5 T 20	995125	171238
Torx wrench		T 20x100	985730	166092

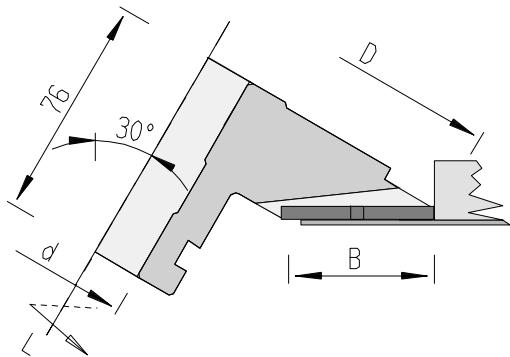
segmented hoggers Ø 200 mm and Ø 250 mm

			Art.-No.	Ident.-No.
countersunk screw	to attach the segments	M8x12,5	995192	180010
countersunk screw	to attach the saws	M5x12 DIN 87	995122	180007
spacer		115x1,0x80,5	955520	009255
cylindrical-head screw	to attach the enlargement (18 & 36 mm)	M8x16 DIN 7984	995111	180004
cylindrical-head screw	to attach the enlargement (54 mm)	M8x30 DIN 7984	995111	180005
cylindrical-head screw	to attach the enlargement (72 mm)	M8x50 DIN 7984	995111	180006
hex socket head wrench		SW 5 DIN 911	985730	009674
screwdriver		9,0 mm (für Zerspaner)	985730	011088

segmented hoggers from Ø 300 mm

			Art.-No.	Ident.-No.
countersunk screw	to attach the segments	M8x17	995192	180011
countersunk screw	to attach the saws	M5x12 DIN 87	995122	180007
screwdriver		9,0 mm (für Zerspaner)	985730	011088



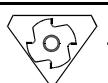


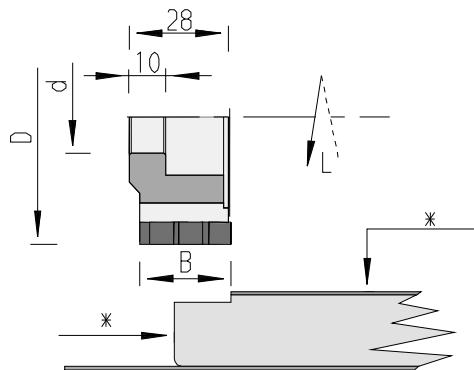
For panel raising during the direct postforming process

- for use without inlay strip
- application with feed on Homag and IMA postforming machines
- $n_{\text{max}} = 9.000 \text{ min}^{-1}$

222.022

Ø D mm	B mm	Ø d mm	DKN mm	Z	Ident.-No.	
L	R					
200	44	35	10 x 4	4 + 4	180522 s	180523 s
200	54	35	10 x 4	4 + 4	180524 s	180525 s





For panel raising of laminated panel materials

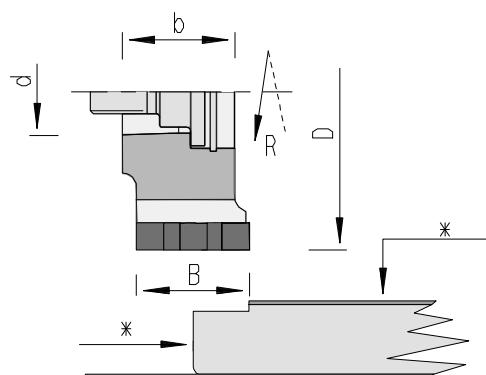
- melamine and paper laminated
- HPL-laminated and veneered
- with inlay profiles
- for the direct postforming process
- application on Homag machines with feed
- resharpenable area 3.5 mm
- Inside edge- Z = 9 which eliminates the need for extra scoring station
- shear angle and extreme division of cutting pressure
- n max = 24.000 min-1

* tracing with copy wheel

222.020

Ø D mm	B mm	Ø d mm	DKN mm	Z	Ident.-No.
70	25	20	6 x 2,8	9 + 3 + 3	179021 s 179022 s
L	R				





For panel raising of laminated panel materials "HSK25R"

- melamine and paper laminated
 - HPL covered and veneered
 - with inlay profiles
 - for the direct postforming process
 - application with feed on Homag machines
 - new HSK 25R interface offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
 - resharpenable area 3.5 mm
 - Inside edge- Z = 9 resp. Z = 12 which eliminates the need for extra scoring station
 - shear angle and extreme division of cutting pressure
- n max = 24.000 min-1

* tracing with copy wheel

222.020

ØD mm	B mm	b mm	Ø d mm	Z	Vf max m/min	L	Ident.-No. R
70	25	28	HSK 25R	9	25	179020	179019
70	25	28	HSK 25R	12	35	180464 s	180463 s

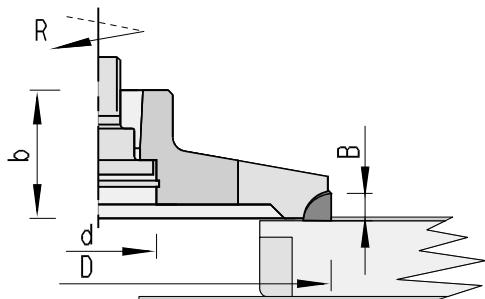
spare parts	dimensions	Art.-No.	Ident.-No.
screw for HSK25R	M10x1,25x32 SW 8	995190	177780
shim ring	DIN 988 18x25x1,0	995440	177781
locking ring	DIN 472 25x1,2	995460	177782





For panel raising of the U profile and flush cutting of the L profile "HSK25R"

- on Homag postforming machines against feed
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- edges with shear angles
- resharpenable area 3.5 mm
- n max 24.000 min -1



222.020

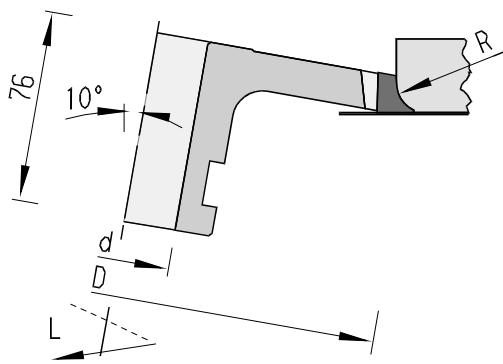
ØD mm	B mm	b mm	Ø d mm	Z	Ident.-No. L	Ident.-No. R
100	5	28	HSK 25R	4	177701 s	177702 s

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



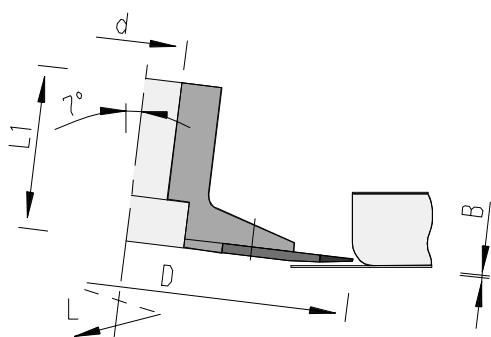
For profiling and simultaneous panel raising during the postforming process

- for the direct postforming process without inlay strip
- application against feed on Homag and IMA postforming machines
- n max = 10.000 min-1



222.060

R mm	Ø D mm	Ø d mm	DKN mm	Z	L	Ident.-No. R
3	180	35	10 x 4	4	172996 s	172997 s
4	180	35	10 x 4	4	172998 s	172999 s
5	180	35	10 x 4	4	173000 s	173001 s
6	180	35	10 x 4	4	173002 s	173003 s
6,5	180	35	10 x 4	4	173004 s	173005 s
7	180	35	10 x 4	4	173006 s	173007 s
7,5	180	35	10 x 4	4	173008 s	173009 s
8	180	35	10 x 4	4	173010 s	173011 s
9	180	35	10 x 4	4	173012 s	173013 s
9,5	180	35	10 x 4	4	173014 s	173015 s
10	180	35	10 x 4	4	173016 s	173017 s
11	180	35	10 x 4	4	173018 s	173019 s
12	180	35	10 x 4	4	173020 s	173021 s
12,5	180	35	10 x 4	4	173022 s	173023 s
14	180	35	10 x 4	4	173024 s	173025 s



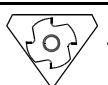
For scribing of the radii during the postforming process

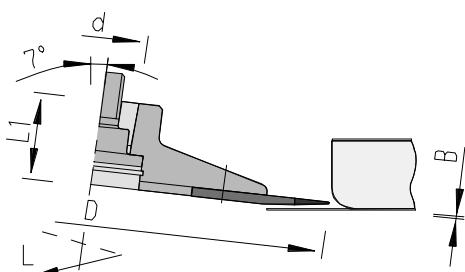
- for the direct postforming process without inlay strip
- for veneered and plastic laminated panel materials
- application against feed on Homag and IMA postforming machines
- replaceable cutting edges
- straight cutter axis
- tooth configuration: symmetrical design
- LEUCODIA cutter inserts -- install only in sets (packing unit 4 pieces)
- n max. 9.000 min-1
- B=0,5 mm not recommended for butted-up workpieces. In this case B=1,2 mm should be used instead

209.080

Ø D mm	B mm	Ø d mm	L1 mm	DKN mm	Z	tooth conf.	Ident.-No.	
							L	R
125	0,5	20	45	6x3	4	symmetrical	180073 &	180074 s
125	0,8	20	45	6x3	4	symmetrical	180955 &	180956 s
125	1,2	20	45	6x3	4	symmetrical	180830 &	180831 s

spare parts	Art.-No.	Ident.-No.	
		L	R
LEUCODIA cutter insert "B" 0,5 mm with screw Torx	232921	180063	180064
LEUCODIA cutter insert "B" 0,8 mm with screw Torx	232921	180959	180960
LEUCODIA cutter insert "B" 1,2 mm with screw Torx	232921	180834	180835 #
Torx countersunk screw	995125		178722
wrench with spinner handle	985730		171188





For scribing of the radii during the postforming process "HSK 25R"

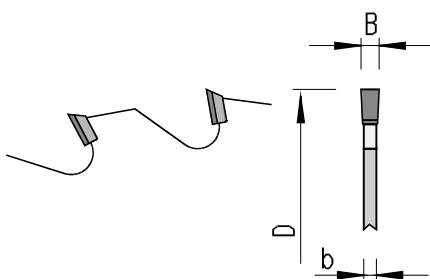
- on Homag postforming machines
- for the direct postforming process without inlay strip
- for veneered and plastic laminated panel materials
- application against feed
- replaceable cutting edges
- new interface HSK 25R offers high radial and axial running accuracy and precise tool balancing to ensure optimum quality of cut
- straight cutter axis
- tooth configuration: symmetrical design for all radii
- LEUCODIA cutter inserts -- install only in sets (packing unit 4 pieces)
- n max. 9.000 min-1
- B=0,5 mm not recommended for butted-up workpieces. In this case B=1,2 mm should be used instead

209.080

Ø D mm	B mm	Ø d mm	L1 mm	Z	tooth conf.	Ident.-No.	
						L	R
125	0,5	HSK 25R	26	4	symmetrical	180075 &	180076 &
125	0,8	HSK 25R	26	4	symmetrical	180957 &	180958 &
125	1,2	HSK 25R	26	4	symmetrical	180832 &	180833 &

spare parts	Art.-No.	Ident.-No.	
		L	R
LEUCODIA cutter insert "B" 0,5 mm with screw Torx	232921	180063	180064
LEUCODIA cutter insert "B" 0,8 mm with screw Torx	232921	180959	180960
LEUCODIA cutter insert "B" 1,2 mm with screw Torx	232921	180834	180835 #
screw for HSK25R	995190		177780
shim ring	995440		177781
locking ring	995460		177782
Torx countersunk screw	995125		178722
wrench with spinner handle	985730		171188



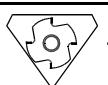


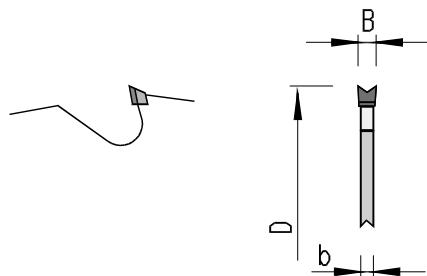
For chip-free grooving in panel materials, hardwoods and plastics

- application with feed on double-end tenoners and edge trimming machines
- in raw and laminated panel materials (particleboard and MDF-panels)
- in thermoplastics and duroplastics
- in abrasive, hard and exotic woods
- number of teeth depends on the feed rate, the material to be cut and the desired quality of cut
- for grooving in the face and edge of material
- resharpenable area 3.5 mm
- tooth configuration: flat
- n max 10.000 min-1

209.010

Ø D mm	B mm	b mm	Ø d mm	Z	DKN mm	Ident.-No.
180	4	3	35	12	10x4	178194 s
180	4	3	35	18	10x4	178195 s
180	4	3	35	24	10x4	178196 s
180	5	4	35	12	10x4	178205 s
180	5	4	35	18	10x4	178197 s
180	5	4	35	24	10x4	178198 s
180	6	5	35	12	10x4	178199 s
180	6	5	35	18	10x4	178200 s
180	6	5	35	24	10x4	178201 s
180	8	7	35	12	10x4	178202 s
180	8	7	35	18	10x4	178203 s
180	8	7	35	24	10x4	178204 s



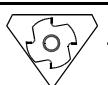


**For chip-free groove-cutting
of Lamello wood joints**

- for solid wood with and across the grain
- for laminated panel materials
- for use on Lamello machines for manufacturing of angle joints
- can be used on CNC machines as a grooving cutter
- large-scale manufacturing ensures low purchase price
- reduced resharpenable area
- tooth configuration: concave
- MAN
- $n = 7\,000 - 13\,300 \text{ min}^{-1}$

209.285

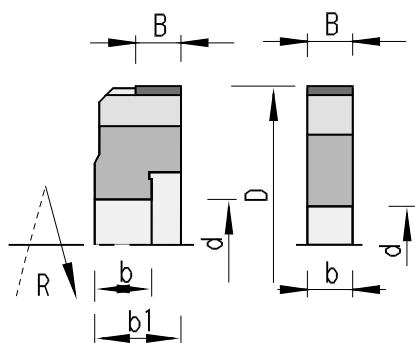
Ø D mm	B mm	b mm	Ø d mm	Z	Ident.-No.
100	3,95	4	22	4	178496





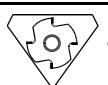
For rounding and flush cutting of edge bands

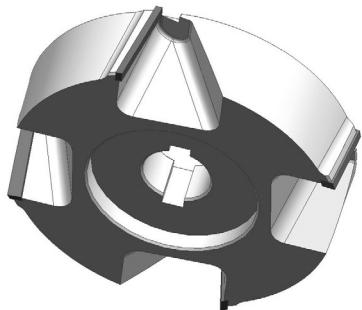
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- reduced resharpenable area
- straight cutter axis
- type A: Brandt, Homag, IDM, IMA
- type B: Brandt, Homag
- n max 24.000 min⁻¹
- sense of rotation acc. to DIN-EN 50144



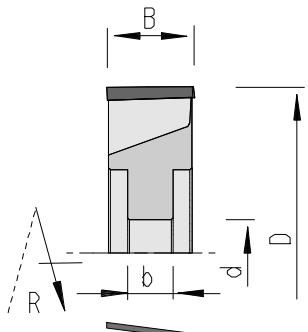
222.510

Ø D mm	B mm	b1 mm	b mm	Ø d mm	DKN mm	Z	type	L	Ident.-No.	R
70	10	10	12,5	20	6 x 3,5	4	A	175787 #	175786 #	
70	10	10	12,5	20	6 x 3,5	6	A	175789	175788	
70	10	10	10	16	5 x 2,3	4	B		175779	
70	10	10	10	16	5 x 2,3	6	B		175780	





TOP WORK

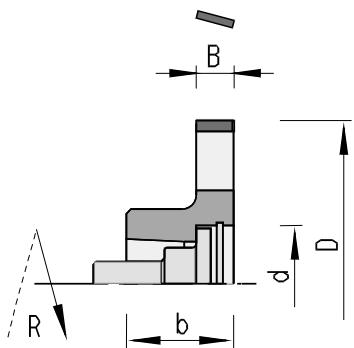


For flush cutting and jointing of edge bands

- on SCM-Stefani edge banding machines
- for solid wood, veneer- and plastic edges
- large-scale manufacturing ensures low purchase price
- cutting edges with shear angle
- reduced resharpenable area
- n max 23 800 min -1
- sense of rotation acc. to DIN-EN 50144

222.210

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	Ident.-No. L	Ident.-No. R
80	20,0	11	16	5x2,3	4	182410	182409



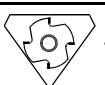
**For flush cutting and chamfering of
edge bands "HSK25R"**

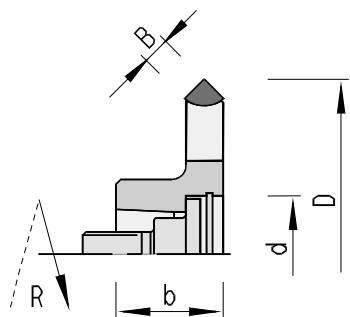
- on Homag and IMA edgebanders
- for solid wood, veneer and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- cutting edges with shear angles
- not resharpenable because constant (zero) diameter must be maintained
- n max 24.000 min -1
- sense of rotation acc. to DIN-EN 50144

222.510

ØD mm	B mm	b mm	Ø d mm	Z	Ident.-No.	
					L	R
70	8	23	HSK 25R	4	177651	177652
70	15	23	HSK 25R	4	177653	177654
70	8	23	HSK 25R	6	180492	180493
70	15	23	HSK 25R	6	180494	180495

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





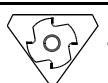
**For chamfering of edge bands and
two-sided chamfering of grooves
"HSK25R"**

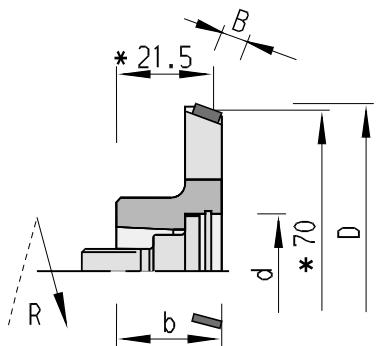
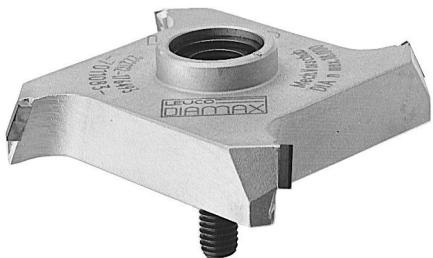
- on Homag and IMA edgebanders
- for solid wood, veneer and plastic edge bands
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- LEUCODIA TOPLINE design for increased tool life and optimum quality of cut
- polished cutting face and precise clearance angle
- resharpenable
- n max 24.000 min -1
- sense of rotation acc. to DIN-EN 50144

222.530

Ø D mm	B mm	b mm	Ø d mm	chamfer a. in degr.	Z	L	Ident.-No. R
75	8	23	HSK 25R	45	4	177705 s	177706 s

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 "HSK25R"**

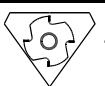
- on Homag and IMA edgebanders
- for solid wood, veneer and plastic edge bands
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- cutting edges with shear angles
- not resharpenable because constant (zero) diameter must be maintained
- n max 24.000 min -1
- sense of rotation acc. to DIN-EN 50144

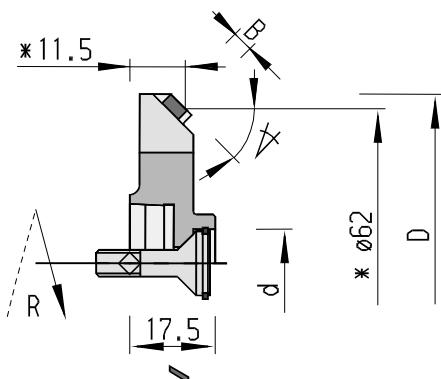
* basic dimensions

222.510

Ø D mm	B mm	b mm	Ø d mm	chamfer a. in degr.	Z	L	Ident.-No.	R
73	6	23	HSK 25R	20	4		177649	177650

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 chamfering of edge bands on Homag edgebanders

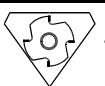
- fits edge trimming assembly FK 01, FK 02 and FK 03
- not resharpenable because constant (zero) diameter must be maintained
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- face shear angle
- the short taper mounting surface allows high radial running accuracy and precise tool balancing for optimum quality of cut
- n max. 18.000 min-1
- sense of rotation acc. to DIN-EN 50144

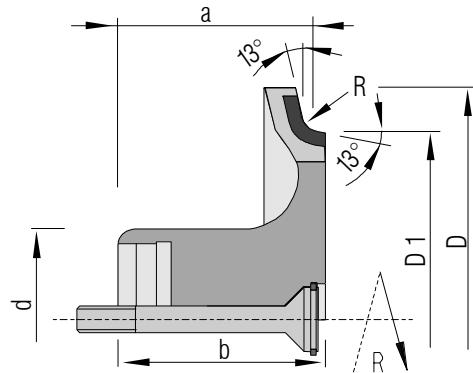
* basic dimensions

222.512

Ø D mm	B mm	Ø d mm	chamfer a. in degr.	Z	Ident.-No.	
					L	R
62,8/62	6	HSK 32	5	4	177405 s	177404 s
64/62	6	HSK 32	20	4	176494	176493
66,3/62	6	HSK 32	30	4	177407 s	177406 s
73,6/62	6	HSK 32	45	4	177409 s	177408 s

spare parts	dimensions	Art.-No.	Ident.-No.
locking ring	DIN 472 14x1	995460	057258
shim ring	DIN 998 8x14x1	995440	173406
countersunk screw	DIN 7991 M6x30	995121	173407





For rounding and chamfering of edges on HOMAG edge banding machines

- suitable for FK-aggregates
- improved chip disposcel thanks to internal chip evacuation advantages:
 - less chips remain inside of the machine
 - avoidance of malfunctions due to chips
 - suction power can be reduced: noise reduced
- tool can not be resharpened, due to constant root diameter
- polished cutting face and high-finish clearance angle
- shear angle
- HSK 32 interface leads to highest concentricity
- attention: machines must be re-equipped accordingly
- basic dimensions: $a = 31,5$ and $D_1 = 62$
- interim radii 79.- EURO surcharge on next-largest model
- sense of rotation acc. to DIN-EN 50144

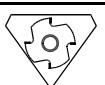
222.812

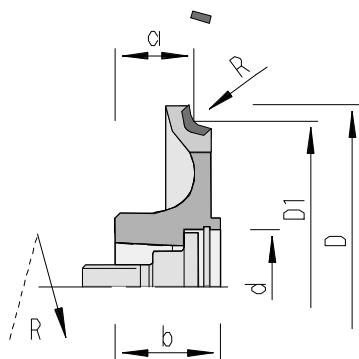
R mm	\varnothing D mm	b mm	\varnothing d mm	z	Ident.-No.	
					L	R
1	74	33	HSK 32	4	180301 s	180300 s
1,5	74	33	HSK 32	4	180278	180279
2	74	33	HSK 32	4	180280	180281
2,5	74	33	HSK 32	4	180303 s	180302 s
3	74	33	HSK 32	4	180282	180283
4	74	33	HSK 32	4	180307 s	180306 s
5	74	33	HSK 32	4	180311 s	180310 s
1,5	74	33	HSK 32	6	180315	180314
2	74	33	HSK 32	6	180284	180285
3	74	33	HSK 32	6	180286	180287
2,5	74	33	HSK 32	6	180317 s	180316 s
4	74	33	HSK 32	6	180304 s	180305 s
5	74	33	HSK 32	6	180308 s	180309 s



chamfer Ø D in degree mm	b mm	Ø d mm	z	Ident.-No.	
				L	R
20	64,8	34	HSK 32	4	180288 180289
45	64,8	34	HSK 32	4	180319 180318
20	64,8	34	HSK 32	6	180290 180291
45	64,8	34	HSK 32	6	180321 s 180320 s

spare parts	dimensions	Art.-No.	Ident.-No.
locking ring	DIN 472 14x1	995460	057258
shim ring	DIN 998 8x14x1	995440	173406
countersunk screw	DIN 7991 M6x45	995121	180293



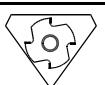


For rounding and chamfering of edges on HOMAG edge banding machines

- 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: noise reduced
- tool can not be resharpened, due to constant root diameter
- polished cutting face and high-finish clearance angle
- shear angle
- HSK 25R interface leads to highest concentricity
- Z = 4 for feedrate 20 - 30 m/min
- Z = 6 for feedrate 30 - 45 m/min
- attention: machines must be re-equipped accordingly
- basic dimensions: a = see table, D1 = 62
- interim radii 79.- EURO surcharge on next-largest model
- sense of rotation acc. to DIN-EN 50144

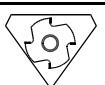
222.812

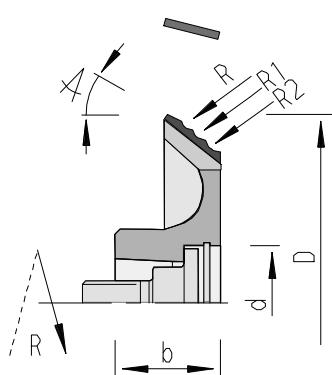
R mm	Ø D mm	a mm	b mm	Ø d mm	Z	Ident.-No.	
L	R						
1	84	17,5	23	HSK 25R	4	180542 s	180543 s
1,5	84	18	23	HSK 25R	4	180544 s	180545 s
2	84	18,5	23	HSK 25R	4	180546	180547
2,5	84	19	23	HSK 25R	4	180548 s	180549 s
3	84	19,5	23	HSK 25R	4	180550	180551
3,5	84	20	23	HSK 25R	4	180552 s	180553 s
4	84	20,5	23	HSK 25R	4	180554 s	180555 s
4,5	84	21	23	HSK 25R	4	180556 s	180557 s
5	84	21,5	23	HSK 25R	4	180558 s	180559 s
1	84	17,5	23	HSK 25R	6	180560 s	180561 s
1,5	84	18	23	HSK 25R	6	180562	180563
2	84	18,5	23	HSK 25R	6	180564	180565
2,5	84	19	23	HSK 25R	6	180566 s	180567 s
3	84	19,5	23	HSK 25R	6	180568	180569
3,5	84	20	23	HSK 25R	6	180570 s	180571 s
4	84	20,5	23	HSK 25R	6	180572 s	180573 s
4,5	84	21	23	HSK 25R	6	180574 s	180575 s
5	84	21,5	23	HSK 25R	6	180576 s	180577 s



chamfer in degr.	Ø D mm	a mm	b mm	Ø d mm	Z	L	Ident.-No. R
20	73	16,5	22,2	HSK 25R	4	180578	180579
45	73	17,5	22,2	HSK 25R	4	180580 s	180581 s
20	73	16,5	22,2	HSK 25R	6	180582 #	180583 #
45	73	17,5	22,2	HSK 25R	6	180584 s	180585 s

spare parts and	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





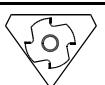
**For rounding and chamfering of edge bands
on HOMAG edge-banding machines**

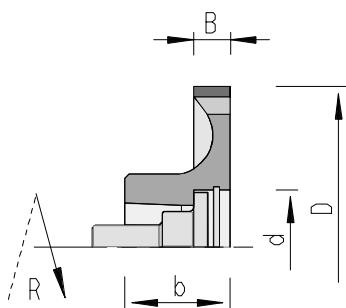
- improved chip evacuation integrated into the tool
this means:
 - no contamination of the machine with chips
 - no malfunctions caused by chips
 - suction performance can be reduced
therefore: less noise
- not resharpenable because of constant basic dimension
- inexpensive price due to series production
- polished face and precise shear angle
- shear angle
- HSK 25R interface for highest concentricity
- Z = 4 for feed speed 20 - 30 m/min
- Z = 6 for feed speed 30 - 45 m/min
- sense of rotation acc. to DIN-EN 50144
- attention: machines must be equipped accordingly

222.812

R mm	R1 mm	R2 mm	chamfer in degr.	Ø D mm	Ø d mm	b mm	Z	L	Ident.-No. R
3	2		20	81,1	HSK 25R	28	4	180757	180758
3	2		20	81,1	HSK 25R	28	6	180759 s	180760 s
1,5	2	3	20	81,1	HSK 25R	28	4	180708 s	180709 s
1,5	2	3	20	81,1	HSK 25R	28	6	180763 s	180764 s

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





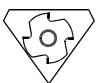
For flush cutting and chamfering of edges on HOMAG edge banding machines

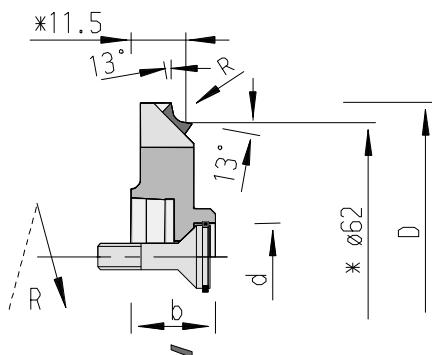
- improved chip disposal thanks to internal chip evacuation advantages:
 - less chips remain inside of the machine
 - avoidance of malfunctions due to chips
 - suction power can be reduced: noise reduced
- tool can not be resharpened, due to constant root diameter
- economic price thanks to large scale manufacturing
- polished cutting face and high-finish clearance angle
- shear angle
- HSK 25R interface leads to highest concentricity
- Z = 4 for feedrate 20 - 30 m/min
- Z = 6 for feedrate 30 - 45 m/min
- Z = 8 for feedrate 45 - 60 m/min
- attention: machines must be re-equipped accordingly
- sense of rotation acc. to DIN-EN 50144

222.812

ØD mm	B mm	b mm	Ø d mm	Z	Ident.-No.		
					L	R	
70	8	23	HSK 25R	4	from April '03	181176	181177
70	8,5	22,2	HSK 25R	4	until April '03	180648	180649
70	15	23	HSK 25R	4		180934 s	180935 s
70	8	23	HSK 25R	6	from April '03	181178	181179
70	8,5	22,2	HSK 25R	6	until April '03	180650 #	180651 #
70	15	23	HSK 25R	6		180936 s	180937 s
70	8	23	HSK 25R	8	from April '03	181180 s	181181 s
70	8,5	22,2	HSK 25R	8	until April '03	180652 s	180653 s

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 rounding of edge bands on Homag edgebanders

- fits edge trimming assembly FK 01, FK 02 and FK 03
- not resharpenable because constant (zero) diameter must be maintained
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- face shear angle
- the short taper mounting surface allows high radial running accuracy and precise tool balancing for optimum quality of cut
- HSK 32 shortened
- Z=4 feed 20-30 m/min
- n max. 18 000 min-1
- sense of rotation acc. to DIN-EN 50144
- interim radii 79.- EURO surcharge on next-largest model

* base dimensions

222.512

R mm	Ø D mm	b mm	Ø d	Z	L	Ident.-No. R
0,8	70	17,5	HSK 32	4	179376 s	179377 s
1	69	17,5	HSK 32	4	179378 s	179379 s
1,5	69	17,5	HSK 32	4	179380 s	179381 s
2	69	17,5	HSK 32	4	179382	179383
2,5	69	17,5	HSK 32	4	179384 s	179385 s
3	69	17,5	HSK 32	4	179386	179387
3,5	72	17,5	HSK 32	4	179388 s	179389 s
4	72	17,5	HSK 32	4	179390 s	179391 s
4,5	72	17,5	HSK 32	4	179392 s	179393 s
5	72	17,5	HSK 32	4	179394 s	179395 s

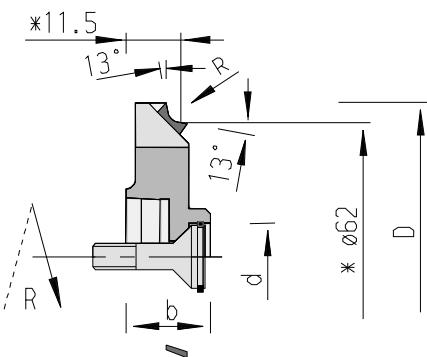
spare parts	dimensions	Art.-No.	Ident.-No.
locking ring	DIN 472 14x1	995460	057258
shim ring	DIN 998 8x14x1	995440	173406
countersunk screw	DIN 7991 M6x30	995121	173407



For rounding of edge bands on Homag edgebanders

- fits edge trimming assembly FK 01, FK 02 and FK 03
- not resharpenable because constant (zero) diameter must be maintained
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- face shear angle
- the short taper mounting surface allows high radial running accuracy and precise tool balancing for optimum quality of cut
- HSK 32 shortened
- Z=6 feed 30-45 m/min
- n max. 18 000 min⁻¹
- sense of rotation acc. to DIN-EN 50144
- interim radii 79.- EURO surcharge on next-largest model

* base dimensions

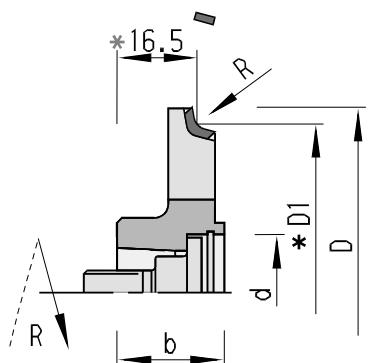
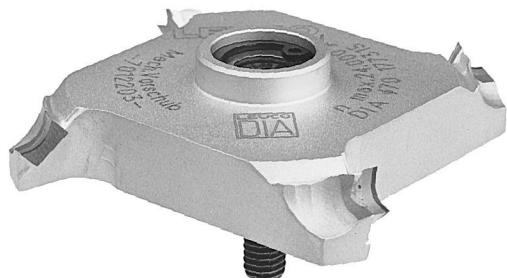


222.512

R mm	Ø D mm	b mm	Ø d	Z	L	Ident.-No. R
0,8	70	17,5	HSK 32	6	178464 s	178465 s
1	69	17,5	HSK 32	6	178466 s	178467 s
1,5	69	17,5	HSK 32	6	178468 s	178469 s
2	69	17,5	HSK 32	6	178470 s	178471 s
2,5	69	17,5	HSK 32	6	178472 s	178473 s
3	69	17,5	HSK 32	6	178474 s	178475 s
3,5	72	17,5	HSK 32	6	178476 s	178477 s
4	72	17,5	HSK 32	6	178478 s	178479 s
4,5	72	17,5	HSK 32	6	178480 s	178481 s
5	72	17,5	HSK 32	6	178482 s	178483 s

spare parts	dimensions	Art.-No.	Ident.-No.
locking ring	DIN 472 14x1	995460	057258
shim ring	DIN 998 8x14x1	995440	173406
countersunk screw	DIN 7991 M6x30	995121	173407





For rounding of edge bands "HSK25R"

- on Homag and 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
 - low purchase price due to large scale manufacturing
 - polished cutting face and precise clearance angle
 - cutting edges with face shear angle
 - not resharpenable because zero diameter must be maintained
 - Z=4 feed 20-30 m/min
 - n max 24 000 min -1
 - sense of rotation acc. to DIN-EN 50144
 - interim radii 79.- EURO surcharge on next-largest model
- * base dimensions a = 16.5 + R

222.512

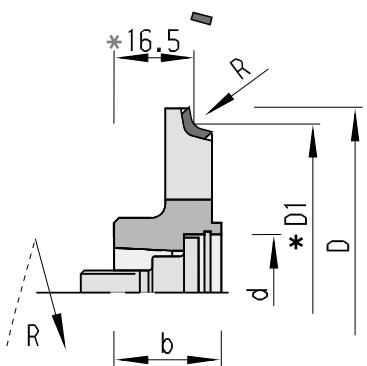
R mm	Ø D mm	b mm	D1 mm	Ø d mm	Z	L	Ident.-No. R
1	75,1	23	70	HSK 25R	4	177655 s	177656 s
1,5	76,1	23	70	HSK 25R	4	177657 s	177658 s
2	77,5	23	70	HSK 25R	4	177659	177660
2,5	78,1	23	70	HSK 25R	4	177661 s	177662 s
3	78,8	23	70	HSK 25R	4	177663	177664
3,5	80	23	70	HSK 25R	4	177665 s	177666 s
4	81,2	23	70	HSK 25R	4	177667 s	177668 s
4,5	82,3	23	70	HSK 25R	4	177669 s	177670 s
5	83,3	23	70	HSK 25R	4	177671 s	177672 s

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 rounding of edge bands "HSK25R"

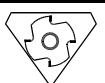
- on Homag and IMA edgebanders
 - for solid wood and plastic edges
 - new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
 - low purchase price due to large scale manufacturing
 - polished cutting face and precise clearance angle
 - cutting edges with face shear angle
 - not resharpenable because zero diameter must be maintained
 - Z=6 feed 30-45 m/min
 - n max 24 000 min -1
 - sense of rotation acc. to DIN-EN 50144
 - interim radii 79.- EURO surcharge on next-largest model
- * base dimensions $a = 16,5 + R$

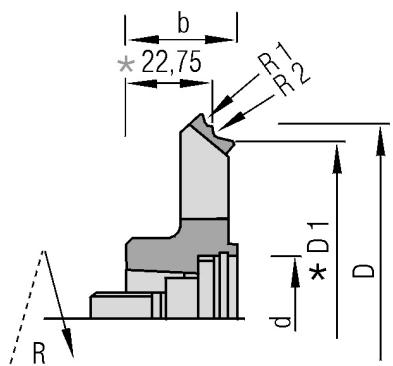


222.512

R mm	\varnothing D mm	b mm	D1 mm	\varnothing d mm	Z	L	Ident.-No.	R
1	75,1	23	70	HSK 25R	6		178545 s	178546 s
1,5	76,1	23	70	HSK 25R	6		178547 s	178548 s
2	77,5	23	70	HSK 25R	6		178549 s	178550 s
2,5	78,1	23	70	HSK 25R	6		178551 s	178552 s
3	78,8	23	70	HSK 25R	6		178553 s	178554 s
4	81,2	23	70	HSK 25R	6		178557 s	178558 s
4,5	82,3	23	70	HSK 25R	6		178559 s	178560 s
5	83,3	23	70	HSK 25R	6		178561 s	178562 s

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 rounding and chamfering "HSK25R"

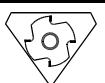
- on Homag edgebanders
- for solid wood and plastic edges
- new interface HSK 25R offers high radial running accuracy and precise tool balancing to ensure optimum quality of cut
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- cutting edges with face shear angle
- not resharpenable because zero diameter must be maintained
- n max 24.000 min -1
- sense of rotation acc. to DIN-EN 50144

* basic dimensions

222.512

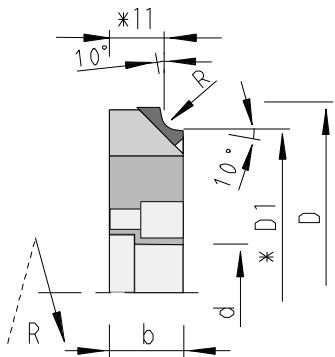
R1 mm	R2 mm	Ø D mm	b mm	Ø D1 mm	Ø d mm	Z	chamfer a. in degr.	L	Ident.-No. R
3	2	85	28	69	HSK 25R	4	20	179076	179077

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



For the rounding of edge bands on Homag-BAZ flush-cutting unit

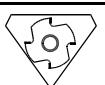
- on HOMAG flush-cutting unit
- suitable for plastic- and solid wood edges
- polished face for good chip evacuation
- precise shear angle for optimum cutting quality
- cutting edges with opposing shear angles increase the cutting quality
- n max. 24 000 min-1
- sense of rotation acc. to DIN-EN 50144



* basic dimensions

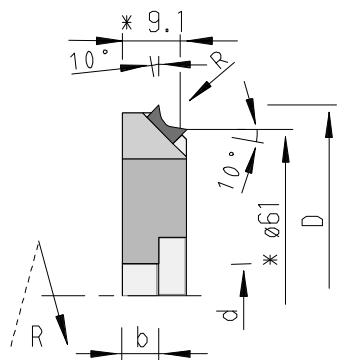
222.512

R mm	\varnothing D mm	b mm	D1 mm	\varnothing d mm	Z	NL	L	Ident.-No. R
2	57	14	50	15	3	3/4,2/25	179416	179417
3	57	14	50	15	3	3/4,2/25	179418	179419



**For rounding of edge bands on Homag and Brandt edgebanders**

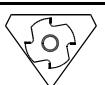
- low purchase price due to large scale manufacturing
- polished cutting face and precise clearance angle
- reduced resharpenable area
- face shear angle
- n max. 24.000 min-1
- sense of rotation acc. to DIN-EN 50144

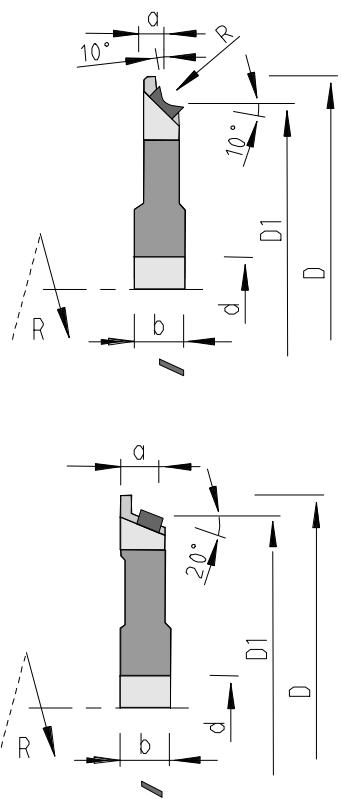


* basic dimensions

222.512

R mm	Ø D mm	b mm	Ø d mm	DKN mm	Z	L	Ident.-No. R
2	69	12	16	5x2,3	4	177312	177311
3	69	12	16	5x2,3	4	177314	177313





For rounding and chamfering of edges on Stefani edge banding machines

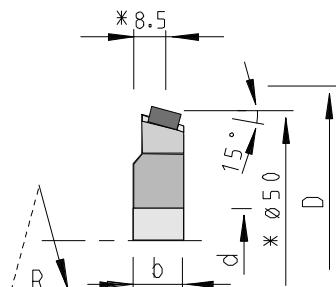
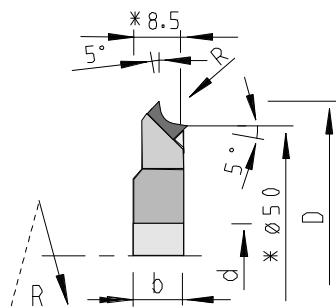
- suitable for Stefani edge banding machines with ED-System
- Chip Meister improved chip removal advantages:
 - less chips remain inside of the machine
 - avoidance of malfunctions due to chips
 - suction power can be reduced: noise reduced
- tool can not be resharpened, due to constant root diameter
- polished cutting face and high-finish clearance angle
- shear angle
- basic dimensions: $a = 8,1$ and $D1 = 61,7$
- n max. 20.000 min-1
- sense of rotation acc. to DIN-EN 50144

222.512

R mm	Ø D mm	b mm	Ø d mm	Ø D1 mm	a mm	DKN	Z	Ident.-No.	
						L	R		
1	73	12	12	61,7	8,1	4x2,15	4	182288 s	182289 s
1,5	73	12	12	61,7	7,6	4x2,15	4	182290 s	182291 s
2	73	12	12	61,7	7,1	4x2,15	4	182292	182293
2,5	73	12	12	61,7	6,6	4x2,15	4	182294 s	182295 s
3	73	12	12	61,7	6,1	4x2,15	4	182296	182297
4	73	12	12	61,7	5,1	4x2,15	4	182298 s	182299 s
5	73	12	12	61,7	4,1	4x2,15	4	182300 s	182301 s

chamfer in degr.	Ø D mm	b mm	Ø d mm	Ø D1 mm	a mm	DKN	Z	Ident.-No.	
						L	R		
20	73	12	12	61,7	8,7	4x2,15	4	182302	182303





**For rounding and chamfering of edge bands
on HolzHer-Edge Banding Machines**

- low purchase price due to large scale manufacturing
- reduced resharpenable area
- face shear angle
- n max. 24.000 min-1
- sense of rotation acc. to DIN-EN 50144

* basic dimensions

222.212

R mm	Ø D mm	b mm	Ø d mm	DKN mm	Z	Ident.-No.	
L	R						
2	57	12,5	16	5x2,3	2	182141	182142
2,5	57	12,5	16	5x2,3	2	182143	182144
3	57	12,5	16	5x2,3	2	182145	182146

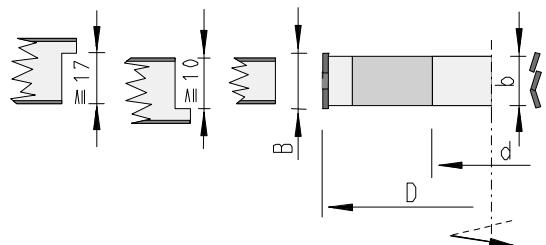
chamfer in degr.	Ø D mm	b mm	Ø d mm	DKN mm	Z	Ident.-No.	
L	R						
15	52	12,5	16	5x2,3	2	182147 s	182148 s





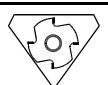
For jointing and rabbeting of laminated panel materials

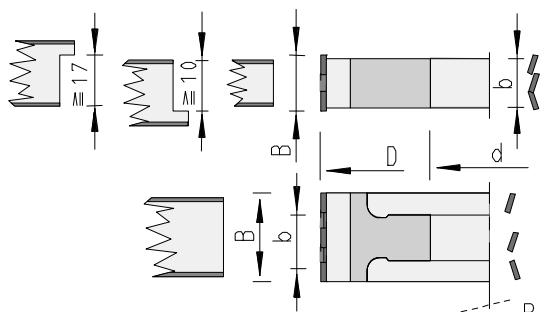
- melamine and paper laminated
- HPL covered and veneered
- application against feed on:
 - shapers Ø 125 mm
 - Homag machines Ø 125 mm
- low purchase price due to large scale manufacturing
- reduced resharpenable area
- opposing shear angle
- jointing/rabbeting: 222.225
- MAN
- sense of rotation acc. to DIN-EN 50144



222.225

Ø D mm	B mm	Ø d mm	DKN mm	Z	n = min-1	Ident.-No.
125	25	30	8 x 3	2 + 2	6100-10500	173710
125	25	50		2 + 2	6100-10500	173786



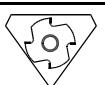


For jointing of laminated panel materials

- melamine and paper laminated
- HPL coated and veneered
- application against feed on:
 - HolzHer, Brandt and IMA machines Ø 100 mm
 - Ott machines Ø 85 mm
 - Homag machines Ø 125 mm
- low purchase price due to large scale manufacturing
- low noise level
- reduced resharpenable area (resharpenable up to 4 times)
- Ident.-No. 180714, 181175, 181241
 - symmetrical design - applicable left and right
 - crowned design for optimum glueing of edges
 - opposing shear angle
 - spiral cutting layout
- MEC
- sense of rotation acc. to DIN-EN 50144

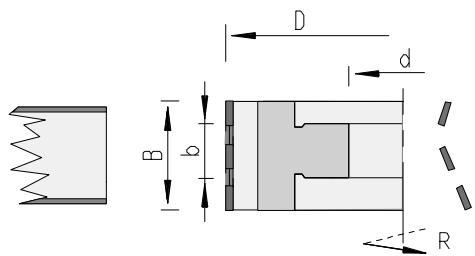
222.220

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	n max min-1	L	Ident.-No. R
85	45,0	45	30	8x3	3 + 3	Ott	22200	181166	181165
100	34,0	37,6	30	8x3	3 + 3	IMA / Brandt	18000	181153	181152
100	48,0	25	30	8x3	2 + 2	HolzHer / SCM	18000	181516	181517
100	48,0	40,6	30	8x3	3 + 3	IMA / Brandt SCM-IDM	18000	181154	181155
100	63,0	25	30	8x3	2 + 2	HolzHer / SCM	18000	181518	181519
100	63,0	40,6	30	8x3	3 + 3	Brandt	18000	182175	182176
100	63,0	40,6	30	8x3	3 + 3	SCM	18000	182393	182392
125	34,0	37,6	30	8x3	3 + 3	Homag	15000	180714	180714
125	43,0	40	30	8x3	3 + 3	Homag	15000	181175	181175
125	63,0	40	30	8x3	3 + 3	Homag	15000	181241	181241

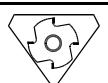


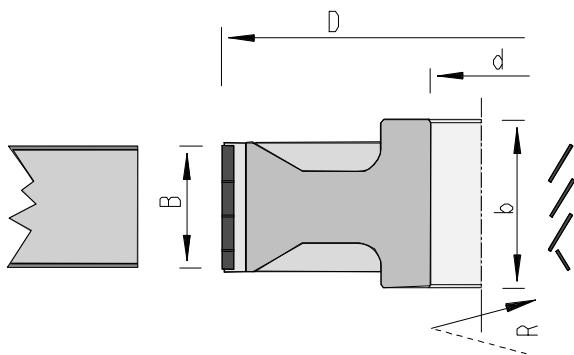
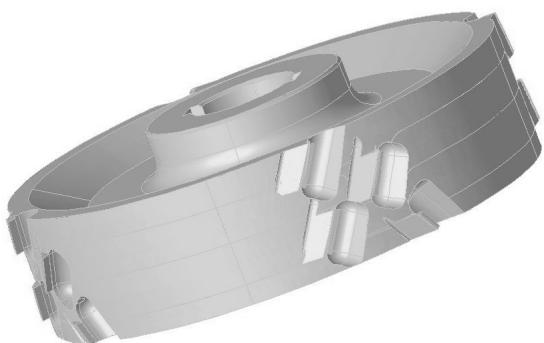
For jointing of laminated panel materials

- with or against the feed
- suitable for panel boards and MDF boards melamine-, paper- and foil-covered
- version Chip-Meister:
optimised chip removal
- inexpensive price thanks to large series production
- noise-optimised
- resharpening area 1 mm (resharpenable up 4 times)
- opposing shear angle
- spiral cutting edges
- MEC
- direction of rotation according to DIN-EN 50144

**222.220**

Ø D mm	B mm	b mm	Ø d mm	DKN mm	Z	mach.	n max min-1	Ident.-No. L	R
100	53,0	25	30	8x2,3	2 + 2	HolzHer	18000	182173	182172



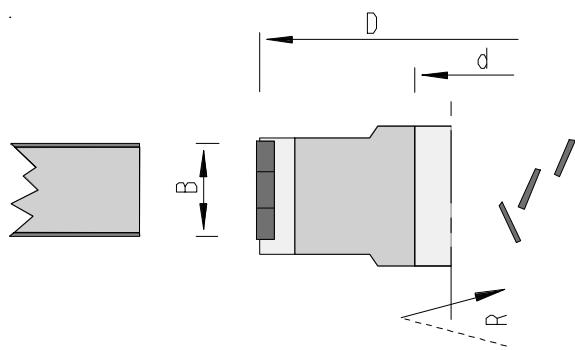


For cutting against the edge on Homag Through Feed Machine

- application with or against the feed
- suitable for panel boards and MDF boards melamine, paper and foil coated
- version Chip-Meister:
optimised chip evacuation (with i-system jointing aggregate)
- large shear angle for high quality in the decor
- sense of rotation acc. to DIN-EN 50144

222.220

Ø D mm	B mm	b mm	Ø d mm	DKN	Z	n max min-1	L	Ident.-No. R
180	43	58,5	35	10x3,3	4 + 4	8000	181217 s	181216 s
180	63	58,5	35	10x3,3	4 + 4	8000	181261 s	181262 s



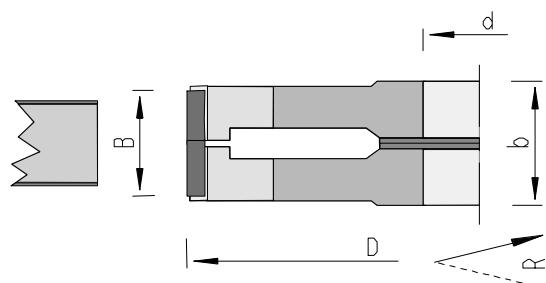
For jointing of laminated panel materials

- melamine and paper laminated
- HPL covered and veneered
- application against feed on double-end tenoners and edge trimming machines
- the specified feed rates are based on $n = 6.000 \text{ min}^{-1}$
- resharpenable area 3.5 mm
- opposing shear angle
- $n \text{ max } 10.000 \text{ min}^{-1}$
- sense of rotation acc. to DIN-EN 50144

222.020

$\varnothing D$ mm	B mm	$\varnothing d$ mm	DKN mm	Z	feed min ⁻¹	Ident.-No.	
						L	R
180	25	35	10 x 4	4 + 4	20	179013 s	179014 s
180	25	35	10 x 4	6 + 6	30	179015 s	179016 s
180	35	35	10 x 4	4 + 4	20	179017	179018





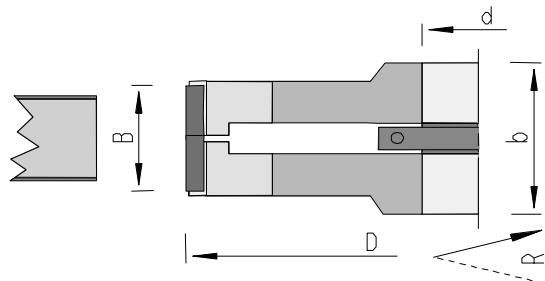
For jointing of laminated panel materials

- melamine and paper laminated
- HPL covered and veneered
- application against feed on double-end tenoners and edge trimming machines
- the specified feed rates are based on:
 - $\varnothing D = 150 \text{ mm}$ - $n = 9.000 \text{ min}^{-1}$
 - $\varnothing D = 200 \text{ mm}$ - $n = 6.000 \text{ min}^{-1}$
- tool allows for 3 adjustments = four single tool lives between sharpenings
- resharpenable area 3.5 mm
- opposing shear angle
- n max. $\varnothing 150 \text{ mm}$ 12.000 min-1
 $\varnothing 200 \text{ mm}$ 9.000 min-1
- sense of rotation acc. to DIN-EN 50144

223.020

$\varnothing D$ mm	B mm	b mm	$\varnothing d$ mm	DKN mm	Z	feed min-1	Ident.-No.
150	22 - 28	32	30	8x3	3 + 3	23	178798 s
200	22 - 28	32	35	10x4	4 + 4	20	178801 s
200	22 - 28	32	35	10x4	5 + 5	25	179073 s
200	22 - 28	32	35	10x4	6 + 6	30	178804





For jointing of laminated panel materials

- melamine and paper laminated
- HPL covered and veneered
- with or against the feed on DET with precision spindle (hexagon adapter)
- clear increase of edge life by means of concentricity achieved by hydro clamping
- adjusting several times allows the addition of edge lives
- reduction of machine downtimes by means of user-friendly adjustment device

• n max. D = 200 mm 9.000 min⁻¹
D = 240 mm 6.000 min⁻¹

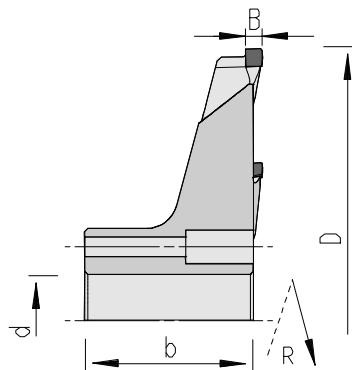
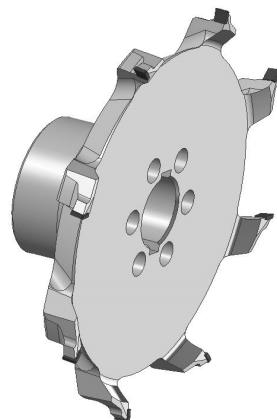
- sense of rotation acc. to DIN-EN 50144

223.020

Ø D mm	B mm	b mm	Ø d mm	Z	feed min ⁻¹	Ident.-No.	
L	R						
200	22-28	101	40	2 x (4+4)	25	180099 s	180098 s
200	22-28	101	40	2 x (6+6)	35	180101 s	180100 s
200	22-28	101	40	2 x (8+8)	45	180103 s	180102 s
200	22-28	101	40	2 x (10+10)	55	180105 s	180104 s
240	22-28	101	40	2 x (12+12)	65	180107 s	180106 s
240	22-28	101	40	2 x (14+14)	80	180180 s	180179 s



TOP WORK

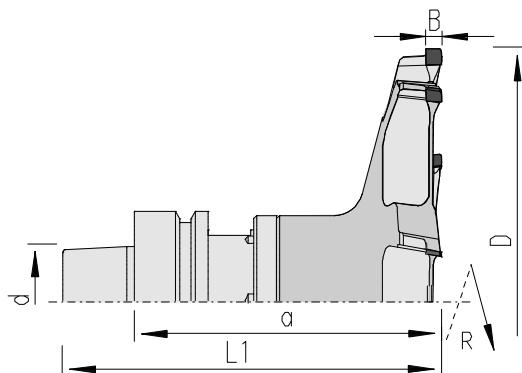


For planing of workbench boards

- on CNC milling machines
- high milling performance and short machining time when dressing the workbench boards, e.g. with Nesting-technology
- smooth surface thanks to special cutting edge geometry
- nmax 10.300 min⁻¹
- sense of rotation acc. to DIN-EN 50144

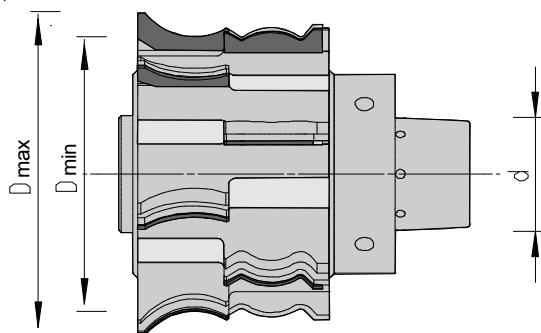
222.020

Ø D mm	B mm	b mm	Ø d mm	Z	Ident.-No. R
180	5,6	58	30	8	182426 s

**229.020**

Ø D mm	B mm	L1 mm	Ø d mm	a mm	Z	Ident.-No. R
180	5,6	133	HSK63F	108	8	182425 s





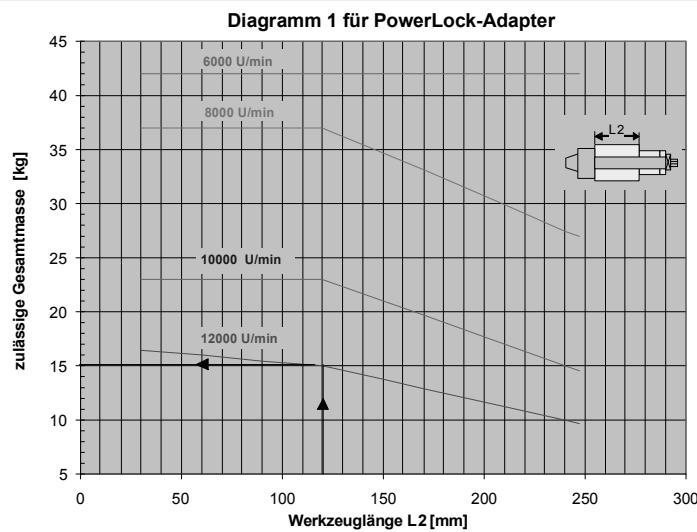
For profiling on moulding automats with HSK-interface

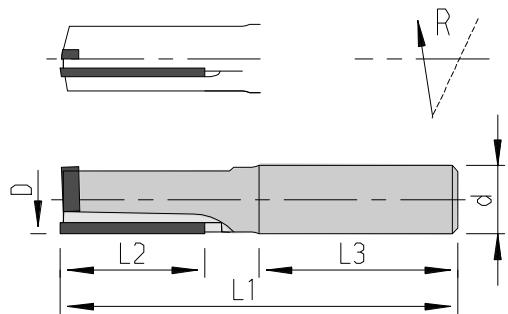
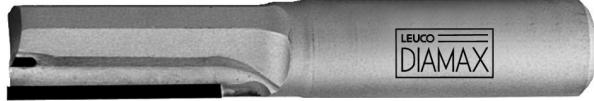
- for the machining of MDF, hard wood and exotic wood
- highest concentricity
- feed speed and workpiece surface like in the case of jointed HW-tools
- Topline with polished knife face and precise cutting edge
- optimal cutting speed 80-100m/s
- profiles according to customer specifications
- price upon request
- n max = depending on L2 and weight (see chart)

LEUCO
Power
DIA/Profil

222.068

\varnothing d mm	\varnothing Dmax mm	\varnothing Dmin mm	Z	feed speed for nmax=12000 min-1
Weinig HSK	180	100	2	33
Weinig HSK	180	100	3	50
Weinig HSK	180	100	4	66
Weinig HSK	180	100	5	83
Weinig HSK	180	100	6	100
Weinig HSK	180	100	7	117
Weinig HSK	180	100	8	133





For jointing, rabbeting, grooving and copying on CNC routers

- very suitable for the machining of:
 - coated panel- and MDF-boards
 - hard solid woods
 - several plastics and mineral boards
- high quality machining of MDF and solid woods (hard)
- resharpenable several times which leads to economic efficiency
- polished face and finely eroded clearance angle
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- straight cutter axis -- continuous cutting edge avoids overlap-marks
- high reliability of tool thanks to its increased stability through special design of brazing area
- with length adjusting screw for shank Ø 16 mm
- reducing sleeve (Class. # 933.280) is required for use with PS 2000-E:
- solid tungsten carbide body for Ø8 and Ø10

DIAMAX Topline

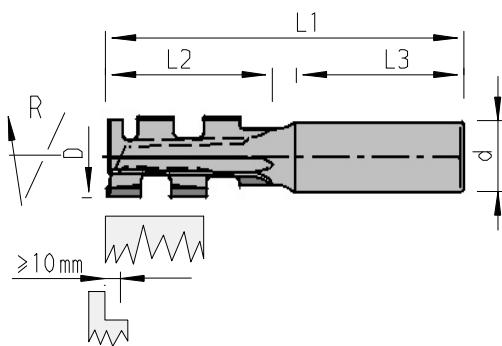
229.522

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	n max min-1	Ident.-No.	
							L	R
8	12	12	35	60	1	30000	*	178660 s * 178659
10	22	12	35	70	2	30000	*	178769 * 178661
12	25,4	12	35	70	1	24000		181102
16	25,4	16	45	85	1	24000		181104
16	35	16	45	95	1	24000		181106

DIAMAX without solid tungsten carbide body

229.222

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	n max min-1	Ident.-No.
							R
8	22	10	35	65	1	24000	182023



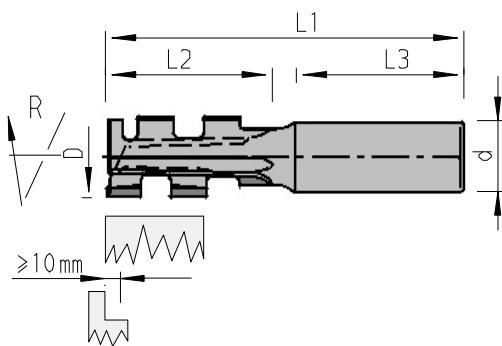
For jointing, rabbeting, grooving and copying on CNC routers

- very suitable for the machining of:
 - coated panel- and MDF-boards
 - hard solid woods
 - several plastics and mineral boards
- resharpenable several times which leads to economic efficiency
- optimum cutting quality due to huge shear angle, alternating top and bottom
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- smooth running thanks to 3-wing design offers high cutting quality additionally
- the spiral chip gullet ensures good chip removal and thus long edgelives
- high reliability of tool thanks to its increased stability through special design of brazing area
- with length adjusting screw for shank Ø 16 mm and Ø 25 mm
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.222

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	Ident.-No.	
L	R						
12	22	12	35	67	1 + 1	181087	181088
12	28	12	35	70	1 + 1	181085	181086
12	22	25	35	64	1 + 1	181695	181694
12	28	25	55	95	1 + 1	181083	181084
16	22	16	45	82	1 + 1	181081	181082
16	22	20	45	82	1 + 1	181079 #	181080
16	22	25	55	92	1 + 1	181077	181078
16	28	16	45	88	1 + 1	181075	181076
16	28	20	45	88	1 + 1	181073	181074
16	28	25	55	98	1 + 1	181071	181072
16	35	16	45	95	1 + 1	181069	181070
18	28	16	45	85	1 + 1	181067	181068
18	28	25	55	95	1 + 1	181065	181066
18	35	16	45	92	1 + 1	181063	181064
18	35	20	45	92	1 + 1	181061 #	181062
18	35	25	55	102	1 + 1	181059	181060
18	43	16	45	100	1 + 1	181057	181058
18	43	20	45	100	1 + 1	181055	181056
18	43	25	55	110	1 + 1	181053	181054
20	52	25	55	120	1 + 1	181051	181052



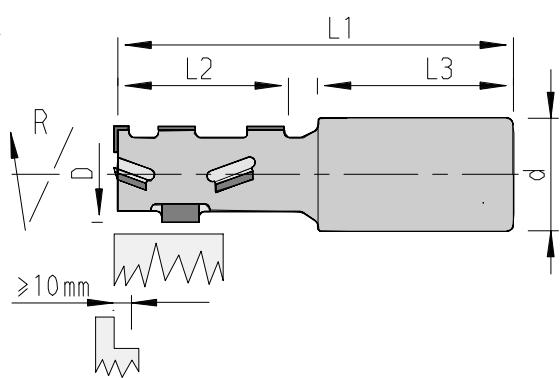


**For jointing, rabbeting, grooving and copying on CNC routers
"Inch-Programm"**

- very suitable for the machining of:
 - coated panel- and MDF-boards
 - hard solid woods
 - several plastics and mineral boards
- resharpenable several times which leads to economic efficiency
- optimum cutting quality due to huge shear angle, alternating top and bottom
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- smooth running thanks to 3-wing design offers high cutting quality additionally
- the spiral chip gullet ensures good chip removal and thus long edgelives
- high reliability of tool thanks to its increased stability through special design of brazing area
- with length adjusting screw for shank Ø 5/8"
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.222

Ø D inch	L2 inch	Ø d inch	L3 inch	L1 inch	Z	Ident.-No.
1/2 "	1 "	1/2 "	1 3/8 "	2 2/3 "	1 + 1	181090
5/8 "	1 "	1/2 "	1 3/8 "	2 7/8 "	1 + 1	181092 #
3/4 "	1 "	5/8 "	1 3/4 "	3 3/8 "	1 + 1	181094 s
3/4 "	1 5/8 "	5/8 "	1 3/4 "	3 7/8 "	1 + 1	181096

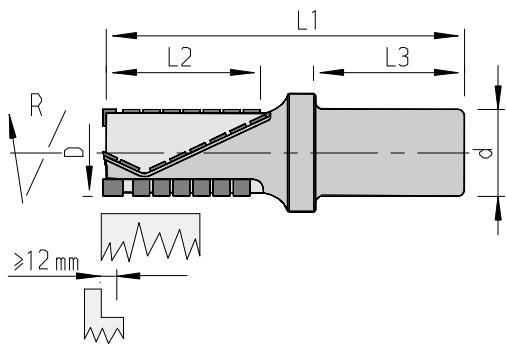


For sizing and dividing cuts on CNC routers

- very suitable for the machining of:
-coated panel- and MDF-boards
-hard solid woods
-several plastics and mineral boards
- resharpenable several times which leads to economic efficiency
- optimum cutting quality due to huge shear angle, alternating top and bottom
- with HW plugging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- high reliability of tool thanks to its increased stability through special design of brazing area
- chip gullets
- optimal chip flow
- high cutting quality: reduced vibrations due to variable pitch, resulting in efficient cutting
- feed speed
-up to 20 m/min in the case of forming
-up to 12 m/min in the case of sizing
- very suitable for sizing cuts
- nmax = 30.000 min-1
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.222

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	Ident.-No.	
L	R						
20	28	20	55	95	2 + 2	181113	181114
20	28	25	55	95	2 + 2	181107	181108
20	38	20	55	105	2 + 2	181115	181116
20	38	25	55	105	2 + 2	181109	181110
20	48	20	55	115	2 + 2	181117	181118
20	48	25	55	115	2 + 2	181111	181112

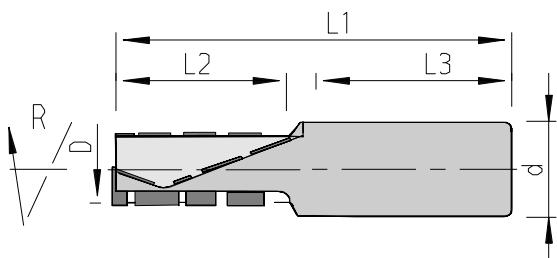


For sizing and dividing cuts on CNC routers

- high performance tool for rough and finish milling
- in particle board and MDF panels, raw, melamine and paper laminated
- in HPL, foil laminated, veneered, polyester-coated and polyester-cast panel materials
- resharpenable
- with LEUCODIA plugging insert for diagonal plunge-cutting
- $n_{max} = 30.000 \text{ min}^{-1}$
- with LEUCODIA plugging insert
 - spiral cut configuration results in highest cutting quality
 - feed rate up to 30 m/min
 - applicable for sizing cuts

229.022

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	Ident.-No.	
						L	R
25	110	28	62	25	3	181472	181473
25	120	38	62	25	3	181474	181475
25	130	48	62	25	3	181476	181477

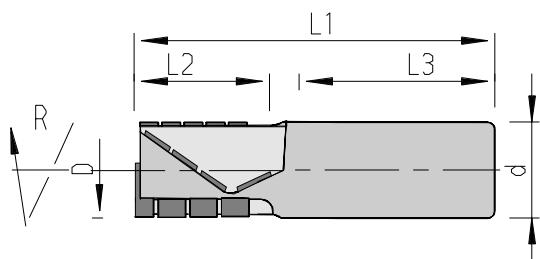


For sizing and dividing cuts on CNC routers

- high performance tool Z=2+1+2 for rough and finish milling.
- Z=1 in middle layer and Z=2 in covering layer
- in particle board and MDF panels, raw, melamine and paper laminated
- in HPL panel materials
- resharpenable
- optimum cutting lengths suitable for most popular panel thicknesses
- good cutting quality on top and bottom edge thanks to opposing shear angles
- high cutting quality: low load alteration thanks to uneven arrangement of cutting edges thus leading to smooth cutting
- very good chip-disposal
- bottom-cutting for ramp-plunging
- feed speed up to 20 m/min when jointing
- feed speed up to 12 m/min when sizing
- nmax = 30.000 min-1
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.022

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	board thickness	Ident.-No.	
						mm	L	R
18	95	22	60	25	2 + 1 + 2	5-19	181478	181479
20	100	28	60	25	2 + 1 + 2	12-25	181480	181481
25	110	35	60	25	2 + 1 + 2	18-32	181482	181483
25	120	42	60	25	2 + 1 + 2	25-40	181484	181485
25	120	48	62	25	2 + 1 + 2	32-45	181486	181487

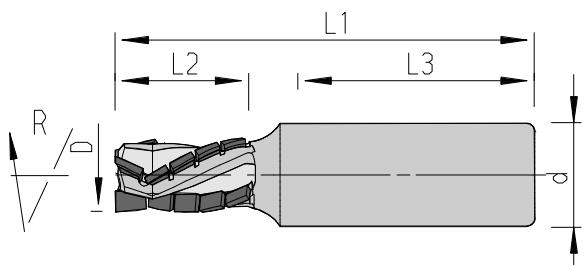


For sizing and dividing cuts on CNC routers

- high performance tool for rough and finish milling
- in particle board and MDF panels, raw, melamine and paper laminated
- in HPL, foil laminated, veneered, polyester-coated and polyester-cast panel materials
- resharpenable
- optimum cutting lengths suitable for most popular panel thicknesses
- good cutting quality on top and bottom edge thanks to opposing shear angles
- version Chip-Meister:
very good chip-disposal thanks to toward spiral
- bottom-cutting for ramp-plunging
- feed speed up to 30 m/min when jointing
- feed speed up to 15 m/min when sizing
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E
- nmax = 30.000 min-1

229.022

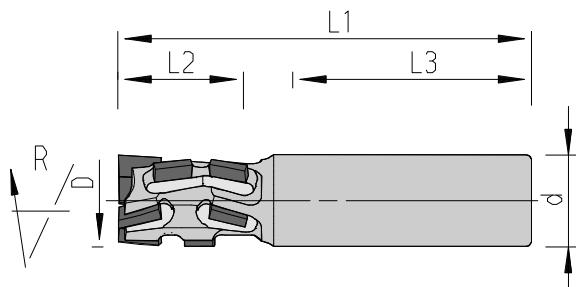
Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	board thickness mm	Ident.-No. L	R
20	22	25	60	95	3 + 3	- 19	181941	181942
20	28	25	60	100	3 + 3	- 25	181943	181944
25	28	25	60	100	3 + 3	- 25	181945	181946
25	38	25	60	110	3 + 3	- 35	181947	181948
25	48	25	60	120	3 + 3	- 45	181949 s	181950
25	52	25	60	125	3 + 3	- 49	181951	181952

**For ripping and cross-cutting on CNC-milling machines**

- high-performance tool for pre- and finish-milling
- used for:
 - raw panel and MDF boards, melamine-resin-, paper-coated
 - HPL-, foil-covered, veneered, lacquered, polyester-primed and -casted panel materials
- resharpening area 3 mm
- high cutting quality on top and bottom edge thanks to alternating shear angle
- face cutting for ramp plunging
- feed speeds up to 30 m/min for jointing cuts
- feed speeds up to 15 m/min for dividing cuts
- for use in PS-2000 E the length-adjusting screw Ident.-No. 172921 is required
- nmax = 24.000 min⁻¹

229.020

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	board thickness mm	Ident.-No. R
18	28	25	60	102	3 + 3	- 25	182177

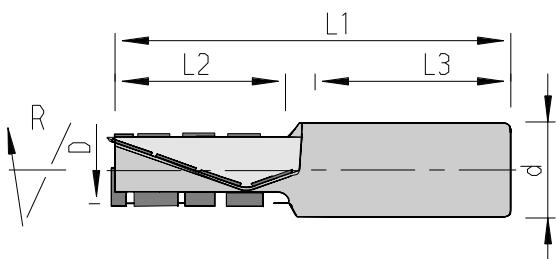


For sizing and dividing cuts on CNC-shapers

- high-performance tool Z=3+2+3 for pre and finish cutting as well as trimming cutting of panel boards with Nesting-technology in finish cut quality
- for machining of:
 - raw, melamine- and paper-laminated panel and MDF boards
 - HPL-laminated, foiled, veneered, lacquered, polyester-primed and cast panel materials
 - multiplex and other composite materials
 - plastics, Corian
 - Trespa
- resharpenable
- optimal determination of cutting width for the conventional panel thicknesses
- specially adapted cutting edges for finish cuts in coated panels and for optimum chip removal
- DP-plunge tip
- feed speed up to 25 m/min
- nmax = 24.000 min-1

229.022

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	optimal board thickness	Ident.-No. L
16	22	16	45	72	3+2+3	16-19	182394

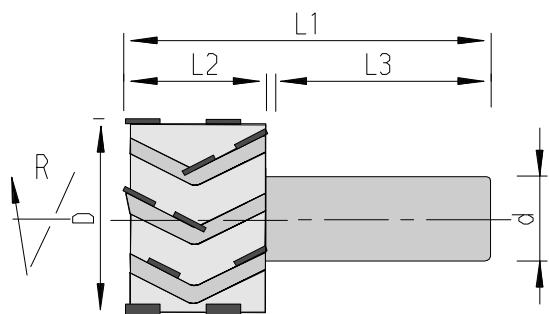


For sizing and dividing cuts on CNC routers

- high performance tool for rough and finish milling, as well as panel sizing with Nesting-technology
- use in:
 - particle board and MDF panels, raw, melamine and paper laminated
 - HPL, foil laminated, veneered, polyester-coated and polyester-cast panel materials
 - Multiplex and other composite materials
 - plastics, Corian
 - Trespa
- resharpenable
- optimum cutting lengths suitable for most popular panel thicknesses
- spiral cutting edge geometry, thus high cutting quality and smooth milling
- very good chip
- bottom-cutting for ramp-plunging as well as DP-plunging tip
- feed speed up to 25 m/min
- nmax = 24.000 min-1

229.022

Ø D mm	L2 mm	Ø d mm	L3 mm	L1 mm	Z	optimal board thickness	Ident.-No.
12	21	16	45	73	3	16-19	181935
12	28	16	45	80	3	22-25	181936
12	30	16	45	82	3	28	181937
14	35	16	45	87	3	32	181938
14	41	16	45	93	3	38	181939

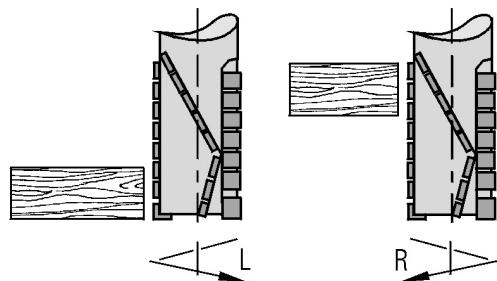


For trimming cuts on CNC-Routers

- high performance tool Z=4+2+4 for finish cuts
- preferably for finish cut operations on pre-sized workpieces
- to be used in:
 - particle board- and MDF-boards raw, melamine-, raisin-, paper-faced
 - HPL-, foil-covered, veneered, laquered, polyester-filled board materials
- optimally defined cutting lengths suitable for the most common board thicknesses
- good cutting quality on top and bottom edge thanks to alternating seahr angles of 40 degrees
- very good surface through large cutting circle diameter of cutting edges resulting in optimum cutting conditions
- 4 cutting edges working in top layer ensure high feed rates (up to 35 m/min) and good edge quality
- 2 cutting edges working in core of board guarantee optimal cutting conditions even on poorly pressed chips, as well as minimized formation of dust
- Rabbeting possible thanks to PCD bottom tip

229.320

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	board thickness		Ident.-No.	
						mm	L	R	
48	85	22	62	25	4 + 2 + 4	16-19	181498 s	181499	
48	91	28	62	25	4 + 2 + 4	22-25	181500 s	181501	
48	98	35	62	25	4 + 2 + 4	28-32	181502 s	181503	



High performance tool for sizing and finishing on CNC-routers

- application:

- particle and MDF boards, raw, melamine-, resin- and paper-faced
- HPL-, foil-covered and veneered board materials

- resharpenable

- lower part of the cutting edge can be made into left hand rotation by adjusting the Z axis and changing the direction of rotation. This allows optimum machining of frail edges utilizing only one spindle

- Z=3 on righthand cutting section for highest feed rates

- Z=1 on lefthand cutting section

- L_{2 eff.} = real cutting lenght
this tool has Z=3. The difference to L₂ is Z=2. This allows the machining of all current panel boards.

- workpiece must be secured on vacuum blocks

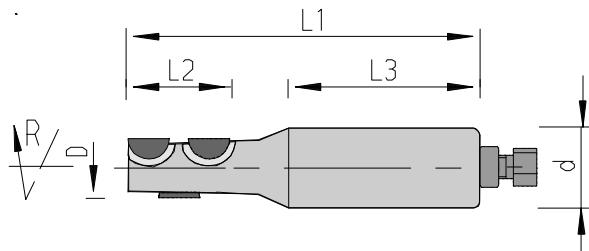
229.020

Ø D mm	L1 mm	L2 mm	L2 eff. mm	L3 mm	Ø d mm	Z	Ident.-No.
25	129	2x22	19,5	62	25	3 / 1	179497
25	137	2x26	23,3	62	25	3 / 1	179498 s
25	145	2x30	27	62	25	3 / 1	179499
25	145	2x34	31	62	25	3 / 1	179500



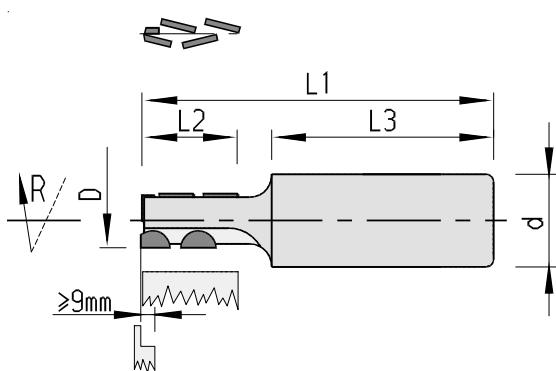
For pre-moulding with high feed speed

- for counter edge banding machine and CNC routers / machining centers
- - in particle and MDF boards raw, melamine and paper coated
- - in Panel materials HPL, foil coated and veneered etc.
- the finishing of the contour requires further operations
- tool attachment in LEUCO-PS-System
- max. feed speed 30m/min
- n max 18 000 min⁻¹



229.021

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	Tmax mm	Ident.-No.
18	120	36	65	25	1 + 1	32	R 179024
18	120	36	65	25	1 + 1	32	L 182111 s



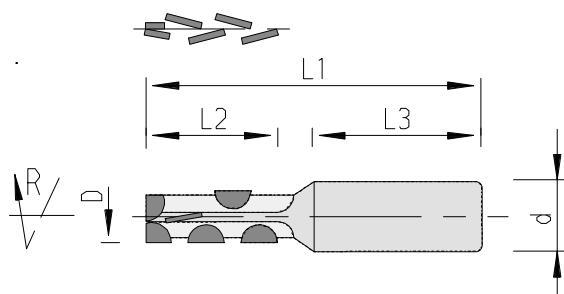
For jointing, rabbeting, grooving and copying on CNC routers

- large shear angle for long tool life and optimum quality of cut:
- in particleboard and MDF-panels raw; melamine and paper laminated
- in HPL and foil laminated and veneered panel materials etc.
- hard and exotic woods
- plastics: thermoplastics, duroplastics. Corian, Varicor etc.
- resharpenable
- straight cutter axis
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- shear angle, alternating top and bottom
- Ø 10 mm and Ø 12 mm with solid carbide cutting edge carrier
- with length adjusting screw for shank Ø 16 mm and Ø 25 mm, fits PS-System
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.022

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	L	Ident.-No. R
10	60	22	30	10	1 + 1		171412 s
10	60	22	30	12	1 + 1		171413 s
10	85	22	50	16	1 + 1		170377 s
10	100	22	60	25	1 + 1		170106 s
12	60	22	30	10	1 + 1		171414 s
12	60	22	30	12	1 + 1		171415 s
12	85	22	50	16	1 + 1		170380 s
12	100	22	60	25	1 + 1		169110 s
14	65	25	30	10	1 + 1		172506 s
14	65	25	30	12	1 + 1		172507 s
14	80	25	43	16	1 + 1		170384 s
14	95	25	55	25	1 + 1		170111 s
16	65	25	30	10	1 + 1		171418 s
16	65	25	30	12	1 + 1		171419 s
16	80	25	45	16	1 + 1	171420 s	170387 s
16	95	25	55	25	1 + 1	171421 s	170113 s
16	75	35	30	10	1 + 1		172508 s
16	75	35	30	12	1 + 1		172509 s
16	90	35	45	16	1 + 1	172511 s	172510 s
16	105	35	55	25	1 + 1	172513 s	172512 #



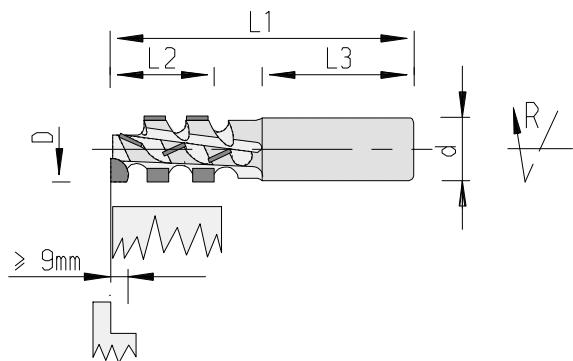


For jointing, rabbeting, grooving and copying on CNC routers

- large shear angle for long tool life and optimum quality of cut:
 - in particleboard and MDF-panels raw; melamine and paper laminated
 - in HPL and foil laminated and veneered panel materials etc.
- hard and exotic woods
- plastics: thermoplastics, duroplastics, Corian, Varicor etc.
- resharpenable
- straight cutter axis
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- shear angle, alternating top and bottom
- type B: Z = 3 fully tipped for high feed rates
- with length adjusting screw for shank Ø 16 mm and Ø 25 mm, fits PS-System
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.022

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	type	L	Ident.-No. R
18	85	25	45	16	3	B	171435 s	171434 s
18	90	35	45	16	3	B	172515 s	172514 s
18	100	43	45	16	3	B	171443 s	171442 s
18	100	25	55	25	3	B	171437 s	171436 s
18	105	35	55	25	3	B	172517 s	172516
18	115	43	55	25	3	B	171445 s	171444 s



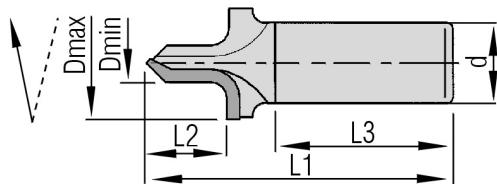
For jointing, rabbeting, grooving and copying on CNC routers

- large shear angle for long tool life and optimum quality of cut:
 - in particleboard and MDF-panels raw; melamine and paper laminated
 - in HPL and foil laminated and veneered panel materials etc.
- hard and exotic woods
- plastics: thermoplastics, duroplastics, Corian, Varicor etc.
- resharpenable
- straight cutter axis
- with HW plunging insert for diagonal plunge-cutting (traveling plunge-cut using Z and X axis)
- shear angle, alternating top and bottom
- Z = 1+1
 - spiral gullet area
 - staggered cutting edges
 - plunge-cutting only using Z and X axis
- with length adjusting screw for shank Ø 16 mm and Ø 25 mm, fits PS-System
- length adjusting screw Ident.-No. 172921 is required for PS 2000-E

229.022

Ø D mm	L1 mm	L2 mm	L3 mm	Ø d mm	Z	Ident.-No.
18	85	25	45	16	1 + 1	R 178987 s
18	85	25	45	16	1 + 1	L 178988 s
18	90	35	45	16	1 + 1	R 178989 s
18	90	35	45	16	1 + 1	L 178990 s
18	100	25	55	25	1 + 1	R 178991 s
18	100	25	55	25	1 + 1	L 178992 s
18	105	35	55	25	1 + 1	R 178993 s
18	105	35	55	25	1 + 1	L 178994 s
18	115	43	55	25	1 + 1	R 178995
18	115	43	55	25	1 + 1	L 178996 s
22	120	50	60	25	1 + 1	R 173340
22	120	50	60	25	1 + 1	L 173341 s
25	108	38	60	25	1 + 1	R 173338 s
25	108	38	60	25	1 + 1	L 173339 s
25	114	44	60	25	1 + 1	R 173336 s
25	114	44	60	25	1 + 1	L 173337 s



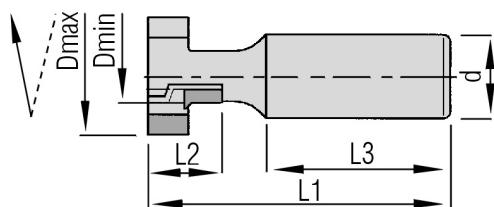


For profiling on CNC routers and machining centers

- in particle board and MDF (raw and coated)
- resharpenable (resharpening area 2 mm)
- overlap-free cut through continuous PCD tablets
- optimum cutting quality in MDF by means of polished cutting edge face
- shear angle leads to optimum edge quality
- tool can be delivered individually according to customer specification within the shortest possible time
- further options are possible at a surcharge:
 - opposing shear angle version (Z = 1+1)
 - Z = 2 version
 - different shank length
(option price list chapt. 12)
 - Topline with ultra fine eroded cutting edge

229.063 / 229.363

D max mm	D min mm	L1 max mm	L2 max mm	L3 mm	d mm	Z	n max min-1	drawing foil
35	12	95	25	55	25	1	24000	DP1A
35	12	95	25	45	20	1	24000	DP1A
35	12	85	25	45	16	1	24000	DP1A
35	12	85	25	45	12	1	18000	DP1A
26	10	95	25	55	25	1	24000	DP1AK
26	10	85	25	45	20	1	24000	DP1AK
26	10	85	25	45	16	1	24000	DP1AK
26	10	75	25	35	12	1	24000	DP1AK



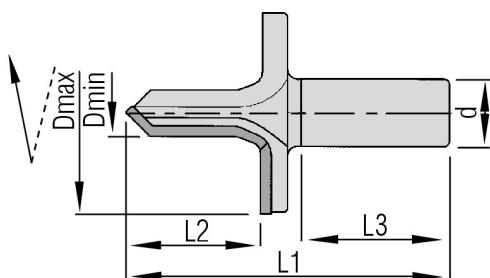
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 - Z = 2 version
 - different shank length
(option price list chapt. 12)
 - Topline with ultra fine eroded cutting edge

229.063 / 229.363

D max mm	D min mm	L1 max mm	L2 max mm	L3 mm	d mm	Z	n max min-1	drawing foil
35	10	90	22	55	25	2 + 1	24000	DP1B
35	10	80	22	45	20	2 + 1	24000	DP1B
35	10	80	22	45	16	2 + 1	24000	DP1B
35	10	70	22	35	12	2 + 1	15700	DP1B



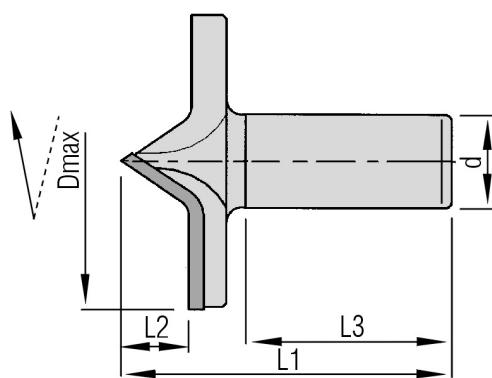


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229.063 / 229.363

D max mm	D min mm	L1 max mm	L2 max mm	L3 mm	d mm	Z	n max min-1	drawing foil
55	16	100	15	55	25	1	24000	DP1CK
55	16	90	15	45	20	1	24000	DP1CK
55	16	90	15	45	16	1	24000	DP1CK
75	18	120	30	55	25	1	24000	DP1D
75	18	110	30	45	20	1	20500	DP1D
75	18	110	30	45	16	1	11200	DP1D
75	18	100	15	55	25	1	17000	DP1DK
75	18	90	15	45	20	1	12900	DP1DK

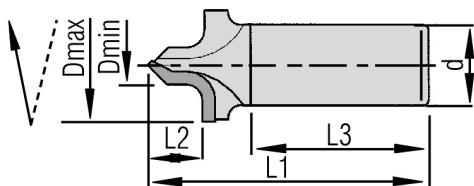


For profiling on CNC routers and machining centers

- in particle board and MDF (raw and coated)
- resharpenable (resharpening area 2 mm)
- overlap-free cut through continuous PCD tablets
- optimum cutting quality in MDF by means of polished cutting edge face
- shear angle leads to optimum edge quality
- tool can be delivered individually according to customer specification within the shortest possible time
- further options are possible at a surcharge:
 - opposing shear angle version (Z = 1+1)
 - Z = 2 version
 - different shank length
(option price list chapt. 12)
 - Topline with ultra fine eroded cutting edge

229.063 / 229.363

D max mm	D min mm	L1 max mm	L2 max mm	L3 mm	d mm	Z	n max min-1	drawing foil
55	18	110	25	55	25	1	24000	DP1F
55	18	100	25	45	20	1	22000	DP1F
55	18	100	25	45	16	1	12000	DP1F
79		88	18	55	25	1	22000	DP1G
79		78	18	45	20	1	22000	DP1G
79		78	18	45	16	1	15000	DP1G
99		98	13	55	25	1	18000	DP1H
99		88	13	45	20	1	16300	DP1H

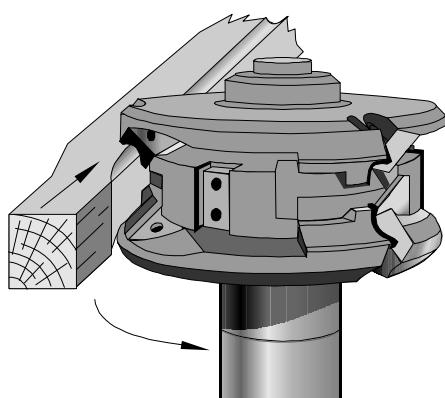


For profiling on CNC routers and machining centers

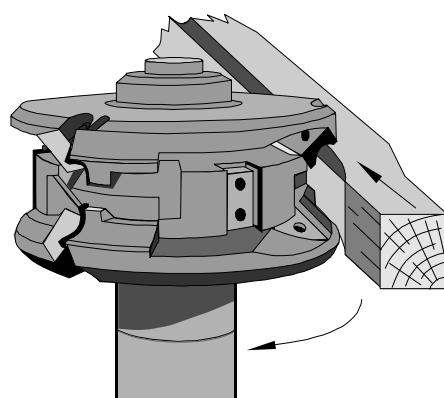
- in particle board and MDF (raw and coated)
- resharpenable (resharpening area 2 mm)
- overlap-free cut through continuous PCD tablets
- optimum cutting quality in MDF by means of polished cutting edge face
- shear angle leads to optimum edge quality
- tool can be delivered individually according to customer specification within the shortest possible time
- further options are possible at a surcharge:
 - opposing shear angle version (Z = 1+1)
 - Z = 2 version
 - different shank length
(option price list chapt. 12)
 - Topline with ultra fine eroded cutting edge

229.063 / 229.363

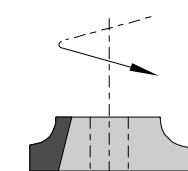
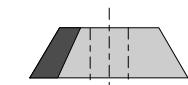
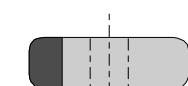
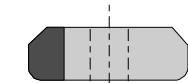
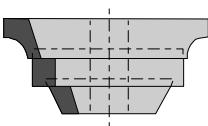
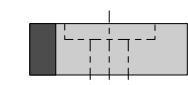
D max mm	D min mm	L1 max mm	L2 max mm	L3 mm	d mm	Z	n max min-1	drawing foil
35	12	90	12,5	55	25	1	24000	DP1M
35	12	90	12,5	45	20	1	24000	DP1M
35	12	80	12,5	45	16	1	24000	DP1M
35	12	70	12,5	45	12	1	18000	DP1M
26	10	90	12,5	55	25	1	24000	DP1MK
26	10	80	12,5	45	20	1	24000	DP1MK
26	10	80	12,5	45	16	1	24000	DP1MK
26	10	70	12,5	35	12	1	24000	DP1MK

right

Counter-Clockwise

left

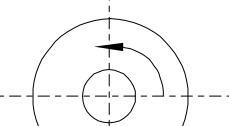
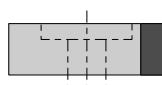
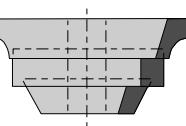
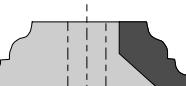
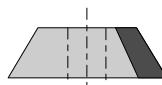
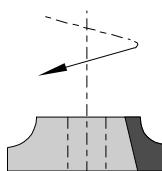
Clockwise

Examples of Order SpecificationsSmall Dia. UP
or
Large Dia. DOWNSmall Dia. UP
or
Large Dia. DOWNSmall Dia. UP
or
Large Dia. DOWNSmall Radius UP
or
Large Radius DOWNChamfered End UP
or
Radius End DOWNLarge Tool Dia. UP
or
Small Tool Dia. DOWN

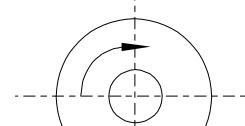
Recessed End UP



Scoring Edge UP



Counter-Clockwise



Clockwise

DIAMOND → The hardest material on earth !

Advantage

- ✧ high performance
- ✧ extreme cost efficiency
- ⇒ by using LEUCO diamond tools

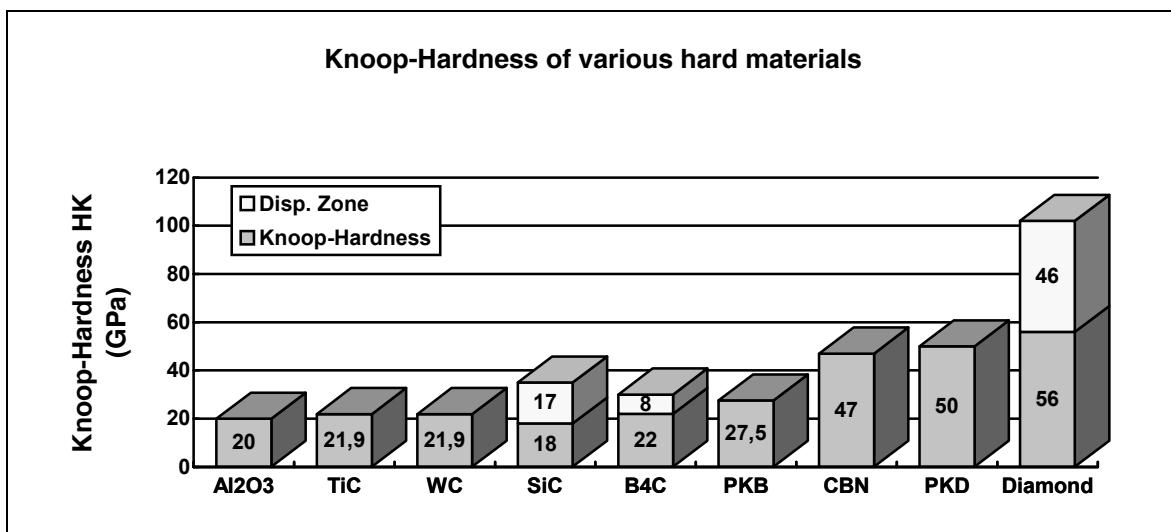
Polycrystalline Diamond (PCD)

Polycrystalline Diamonds are manufactured with enormous pressure and extremely high temperatures.

Diamond grains are sintered onto a carbide blank. The cobalt that is released from the carbide binds the diamond grains to the blank.

The result is an extremely hard cutting material that is very resistant to wear.

Since the cobalt phase is conductive, the PCD material can be profiled and sharpened with electrical erosion.



Physical Properties of various cutting materials

Hard Materials	Density (g/cm ³)	Knoop-Hardness (N/mm ²)	Bending Failure Strength s_B (N/mm ²)	Wear Factor x
Tungsten Carbide K05 - K10	14 ... 15	16.000 ... 17.000	1.700 ... 1.800	2
PCD	3,5...4,2	50.000	390 ... 460	250
Ceramic Oxyde Al ₂ O ₃	3,9 ... 4,0	22.000 ... 25.000	300 ... 500	180

LEUCODIA is PCD made by leading manufacturers with different grain size for different applications.

Cutting tool geometry for a number of different applications with PCD tools. manufactured by **LEUCO's** skillful staff.

LEUCODIA -Qualities

The application and the material to be cut determine, which LEUCODIA Quality will be used.

LEUCODIA is a polycrystalline diamond (PCD).

LEUCO uses PCD in three grain size:

Description	Medium Grain Size (μm)	General Designation
002	2	extra fine
010	10	fine
025	25	regular

Edge Life

Difference in edge life are normal, due to differences in the board materials to be cut.

These differences can be extreme for different types of wood and wood materials. In addition, the materials may contain mineral deposits that negatively affect the edge life

The basic requirements for longer edge life are the expertise of the tool manufacturer, a trained staff and the necessary CNC machines.

Service

Diamond tools are serviced

- ◊ quickly
- ◊ dependably
- ◊ precise

at LEUCO Service Locations.

LEUCODIA Circular Saw Blades

⇒ for **scoring**

- resharpenable design
- DIAMAX with reduced resharpenable area

⇒ for **sizing and dividing**

- resharpenable design

Available from Ø 70 mm to Ø 570 mm

LEUCO competitors

We used our more than forty years of experience in designing and manufacturing carbide tipped circular saw blades and applied it to the development of LEUCODIA circular saw blades.

Use

LEUCODIA circular saw blades are used wherever the material to be cut and the extremely high set-up costs per-foot-costs must be reduced.

Streamlining

These tools allow streamlining for the following reasons:

- ◊ lower tooling costs (new tools and sharpening)
- ◊ much longer tool life
- ◊ reduced machine downtimes

LEUCODIA efficiency

The combination of tools and cutting materials (diamond or tungsten carbide) depends solely on what is efficient.

LEUCO will provide an *efficiency calculation* of each individual application with the appropriate requirements to the quality of cut and the tool life.

The achievable tool life is 80 to 120 times higher than that of carbide tipped saw blades while maintaining consistently high quality of cut.

LEUCO solves your problems

Highly trained professionals in all areas guarantee quality and precision. Our technical consultants will inform you about the many options on how costs can be cut.

LEUCO offer problem solutions not only for diamond tools but also for carbide tools.

LEUCO produces custom diamond tooling that is manufactured specifically for your application (machine and material to be cut).

LEUCODIA Circular Saw Blade Program:

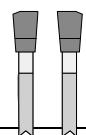
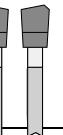
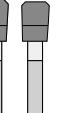
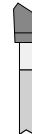
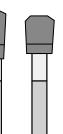
- ❖ **scoring saws**
- ❖ **hogging saws**
- ❖ **sizing and panel sizing saws**

These tools are manufactured on state-of-the-art CNC controlled machines.

Over 20 years of experience in manufacturing and designing diamond tools ensure best quality and precision.

LEUCODIA circular saw blades can reduce your tooling and set-up costs by up to 50 % as opposed to carbide tipped saw blades.

Tooth Configurations

	Designation / Application		Designation / Application
	F_{FA} (flat tooth with chamfer) for scoring with feed		W_SF_A (alternating top bevel with chamfer) for duroplastics and thermoplastics
	K/W_S (conical/alternating top bevel) for scoring with feed		TR/F_{FA} (triple chip flat with chamfer) for sizing and panel sizing saws
	E_SF_A (top bevel with chamfer) for hogging with feed		D_A/F_{FA} (v-point / flat with chamfer) for sizing and panel sizing saws

Depending on application and material to be cut several tooth configurations can be used.

Number of Teeth / Feed Rate

- ❖ scoring and hogging saws:

The number of teeth depends on the feed rate and is indicated with the tool description on the appropriate catalog pages.

- ❖ sizing and panel sizing saws:

The number of teeth depends on the following criteria:

- type of feed
- spindle RPM
- diameter of the circular saw blade
- material to be cut
- required quality of cut (sizing cut / finish cut)
- cutting height (single boards / stack)
- stack height (number of single boards)

Recommended cutting speed for the following materials

Particleboard and MDF panels

● raw	65 - 100 m/s
● plastic laminated	65 - 100 m/s
● veneered	65 - 100 m/s
● foil laminated	65 - 100 m/s

Hardboard raw and laminated 60 - 90 m/s

CLV boards 70 - 100 m/s

Chipboard 60 - 90 m/s

high-density plywood 50 - 80 m/s

compressed woods 50 - 80 m/s

thermoplastics 60 - 80 m/s

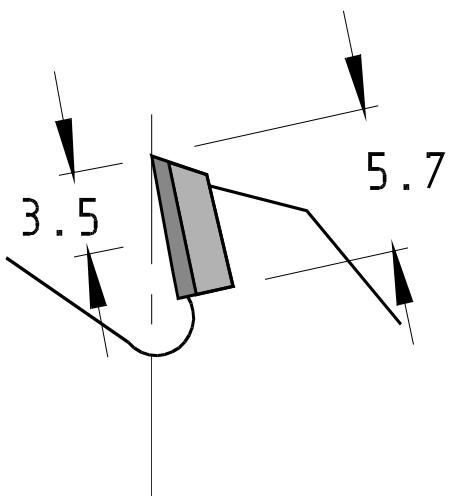
duroplastics 50 - 80 m/s

GFK and CFK 40 - 60 m/s

LEUCODIA Service

LEUCODIA circular saw blades can be resharpened several times.

The number of the resharpenings depends on the wear land, the resulting diamond wear and the resharpenable area of the individual cutting edges.

Resharpenable area:Example panel sizing
saw blades

The resharpenable areas for the individual LEUCODIA saw blades are indicated on the appropriate catalog pages.

LEUCODIA and LEUCODUR**Program:**

- **Twin Tec Hoggers Topline Compact and Saw Design** Ø 220 mm n max 7.200 min⁻¹
- **Compact Hoggers** Ø 250 mm n max 7.200 min⁻¹
- **Segmented Hoggers** Ø 200 and Ø 250 mm n max 7.200 min⁻¹
- **Segmented Hoggers** Ø 300 - Ø 430 mm
- **Power Tec Hoggers** Ø 250 mm n max 7.200 min⁻¹

All systems are modular.

Acronyms for: ♦ scoring / hogging ➔ RZ
 ♦ double hogging ➔ DZ

- **Clamping Systems:**

Hogger Type	Hydro S-System	S-System	Hydro Bushing	Bushing	without Bushing
Twin Tec "Topline"	☒	☒			
Compact Hoggers Ø 250 mm	☒	☒	☒	☒	
Segmented Hoggers Ø 200 mm / 250 mm		☒		☒	
Segmented Hoggers Ø 300 - Ø 430 mm				☒	☒
Power Tec Hoggers Ø 250 mm	☒	☒	☒	☒	☒

Hydro Systems are used on high precision motors with shaft Ø 40 mm and hexagon fitting.

LEUCODIA Cutter Program:**❖ Straight-edged and profiled**

- LEUCODIA Topline cutting edges with polished face and precise clearance angle
- LEUCODIA resharpenable design
- DIAMAX with reduced resharpenable area

These tools are manufactured on state-of-the-art CNC-machines.

More than 20 years of experience in manufacturing and designing diamond tools ensure optimum quality and precision.

LEUCODIA cutters can lower your tooling costs and downtimes by up to 50 % as opposed to carbide tipped tools and turnover knives.

❖ Feed rate and number of teeth

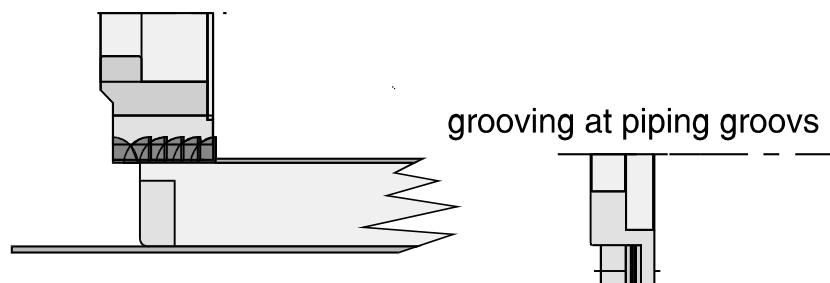
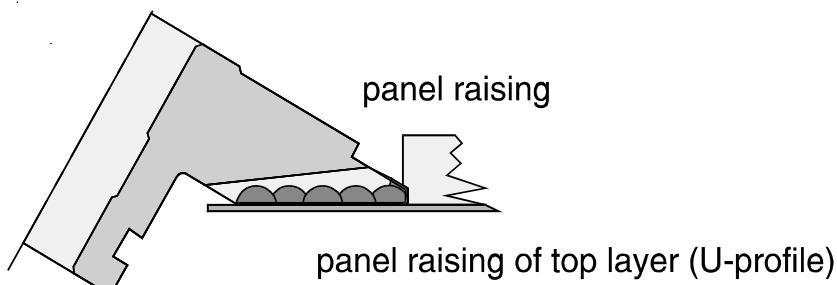
The feed rate depends on:

- the spindle RPM
- the material to be cut
- the desired quality of cut
- the work process
- the hogging volume

LEUCODIA-Tools

➔ for the complete postforming process

- with inlay strip



- without inlay strip

