

Panel processing

Leitz Lexicon Edition 7

Version 2



Explanation of abbreviations

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

Notes to the Lexicon concerning the diagrams and tables

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

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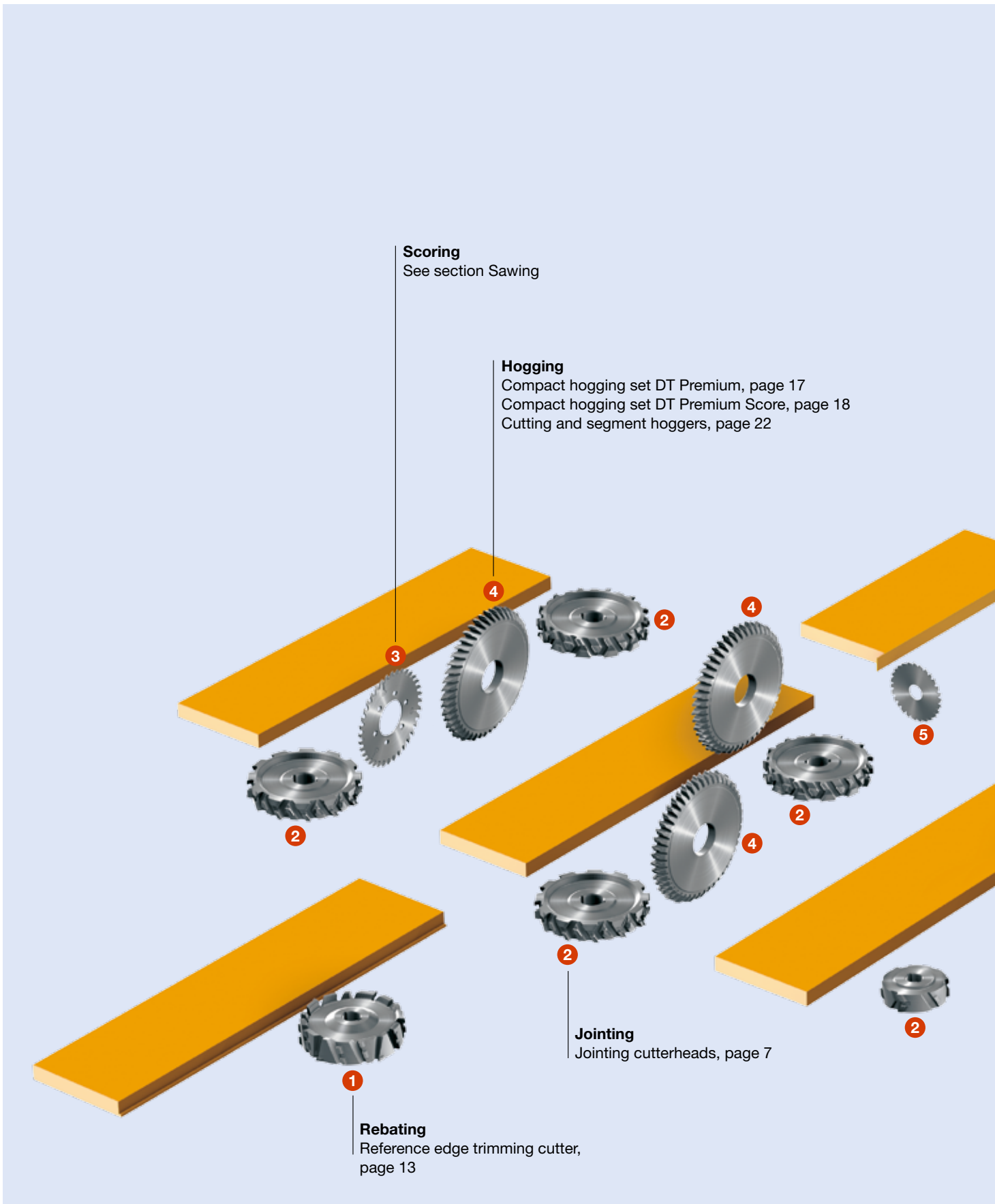
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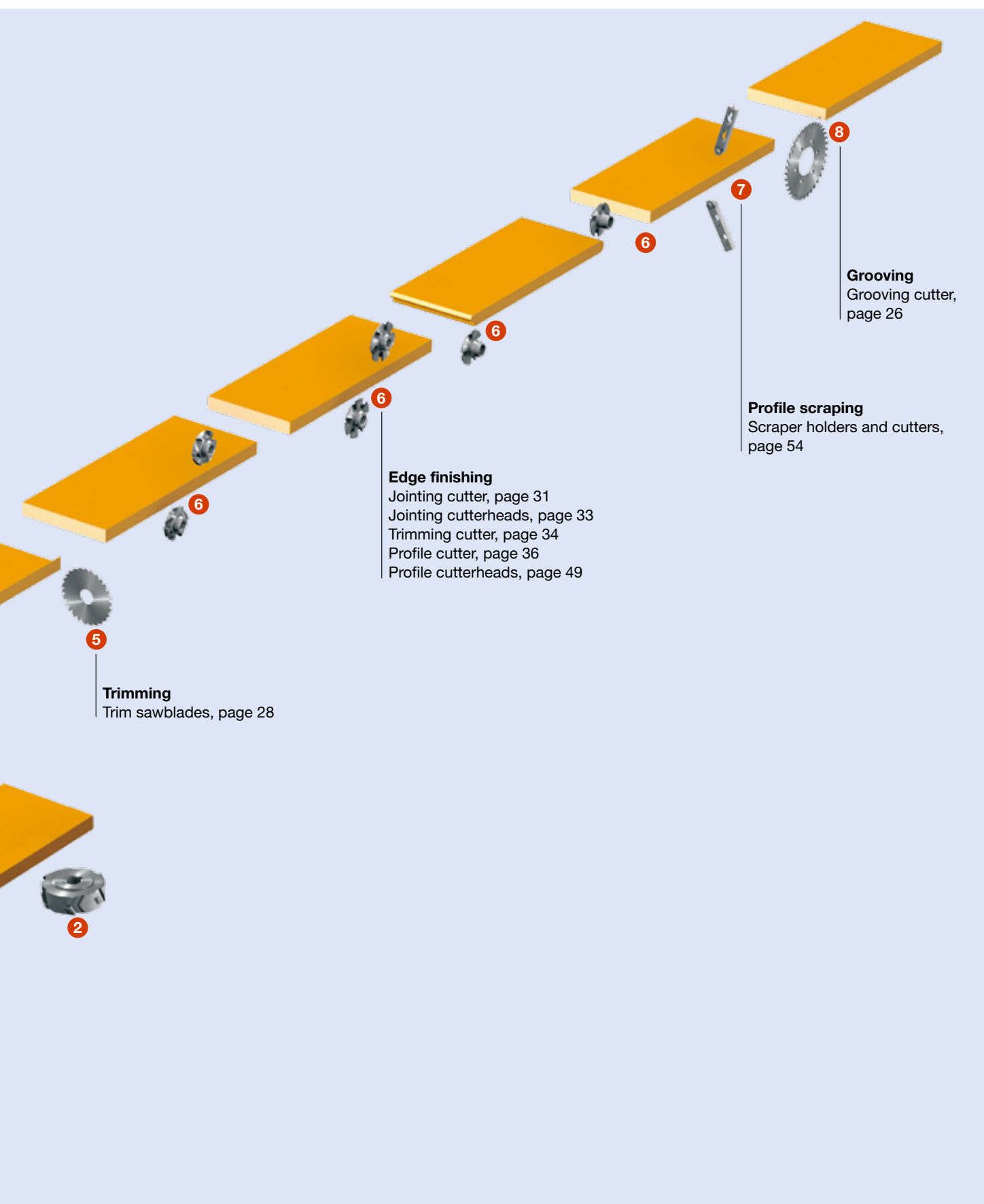
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2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters

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

Tool Designs



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

Diamond jointing cutter with alternate shear angle:

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

The tool can be used in RH and LH rotation.

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



2-part tools on synchronically adjustable sleeve:

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

Diamaster WhisperCut



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

Advantages at a glance:

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

2. Panel processing

2.1 Edge processing

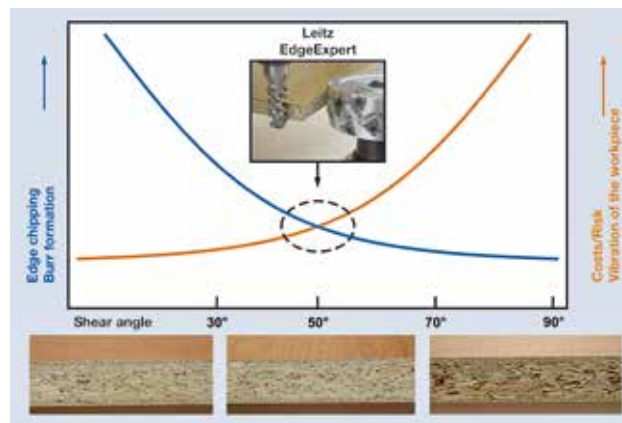
2.1.2 Jointing cutters

Diamaster EdgeExpert



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

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

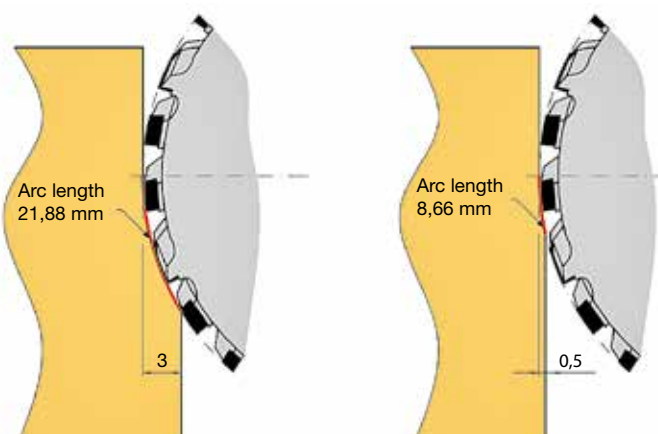


Dust collection

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

Chip removal

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



2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters

Noise emission

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

Service

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

Resharpener Diamaster WhisperCut



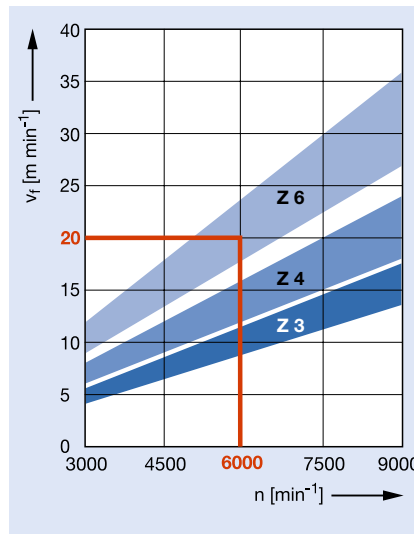
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

Diamaster WhisperCut – The jointing cutterhead with exchan- geable knives

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

Feed speed related to RPM and number of teeth Z

Material: Chipboard with melamine
resin coating





WhisperCut jointing / milling cutter - cutterhead design

Application:

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

Machine:

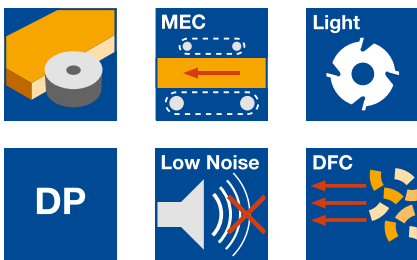
Edgebanding machines, copy shaping machines, double-end tenoners etc.

Workpiece material:

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

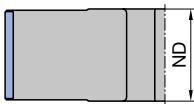
Technical information:

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

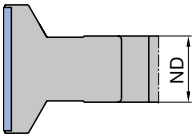


Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body

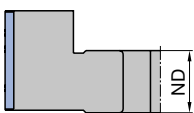
WF 230 2 DP, WM 230 2 01



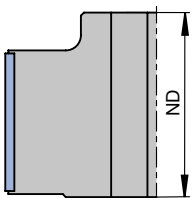
Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3



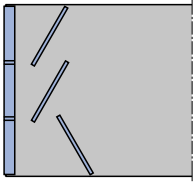
Position of boss (NAL) 4

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID	
									LH	RH
Biesse	80	45	53	30	DKN	1	2x4	8xB	S	192127 ● 192127 ●
Biesse	80	65	53	30	DKN	2	2x6	12xB	S	192128 ● 192128 ●
Biesse	100	43	75	30	DKN	1	3x4	12xA	S	192088 ● 192088 ●
Biesse	100	65	75	30	DKN	1	3x6	18xA	S	192089 ● 192089 ●
Biesse	125	43	40	30	DKN	2	3x4	12xE	S	075627 ● 075627 ●
Biesse	125	63	40	30	DKN	2	3x6	18xE	S	075626 ● 075626 ●
Brandt	100	43.6	40.6	25	DKN	3	2x4	8xA	AS	192211 ● 192212 ●
Brandt	100	43.6	40.6	30	DKN	3	3x4	12xA	AS	090885 ● 090886 ●
Brandt	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	090887 ● 090888 ●
Brandt	100	85	85	30	DKN	3	3x8	24xA	AS	090889 ● 090890 ●
Brandt	100	105	85	30	DKN	3	3x10	30xA	AS	090891 ● 090892 ●
Cehisa	100	54	25	20	DKN	2	2x5	10xA	AS	192078 ● 192079 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192278 ●
Felder	60	63	63.5	25	DKN	3	2x7	12xC2	AS°	192277 ●
Felder	80	48.5	64	25	DKN	3	3x6	12xF	AS°	192281 ● 192282 ●
Felder	80	64	64	25	DKN	3	2x7	12xF	AS°	192299 ●
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192279 ●
Felder	80	64	64	25	DKN	3	3x7	18xF	AS°	192280 ●
Fraval	60	63	63.5	25	DKN	3	2x7	12xC	AS°	192248 ●
Fraval	60	63	63.5	25	DKN	3	2x7	12xC2	AS°	192247 ●
Fraval	60	84	61	25	DKN	3	2x8	14xC	AS°	192242 ●
Fraval	60	84	61	25	DKN	3	2x8	14xC2	AS°	192241 ●
Fraval	100	65	56.5	30	DKN	3	2x6	12xA	AS	192243 ● 192244 ●
Fraval	100	84	56.5	30	DKN	3	2x8	14xA	AS°	192286 ●
Fraval	100	84	56.5	30	DKN	3	2x8	14xA2	AS°	192285 ●
Fraval	100	84	56.5	30	DKN	3	2x8	14xA1	AS°	192285 ●

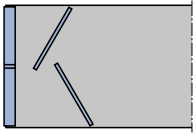
2. Panel processing

2.1 Edge processing

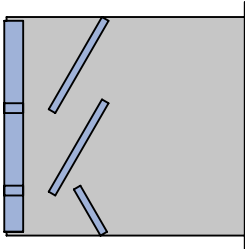
2.1.2 Jointing cutters



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



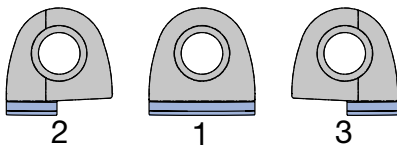
Type AS° = asymmetric tip arrangement with a narrow row of teeth below

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Fravol	100	124	96	30	DKN	2	2x11	22xA	AS	192245 ● 192246 ●
Hebrock/EBM	70	43	61	25	DKN	4	2x4	8xB	AS	192237 ● 192238 ●
Hebrock/EBM	70	63	81	25	DKN	4	2X6	12xB	AS	192239 ● 192240 ●
Hebrock/EBM	100	43	61	30	DKN	4	2x4	8xB	AS	192233 ● 192234 ●
Hebrock/EBM	100	63	81	30	DKN	4	2x6	12xB	AS	192235 ● 192236 ●
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°	192222 ●
1801/1802								2xD1		
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°	192221 ●
1801/1802								2xD2		
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°	192224 ●
1801/1802								2xD1		
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°	192223 ●
1801/1802								2xD2		
Holz-Her 1804	100	63	39.5	30	DKN	2	3x6	18xB	S	192147 ● 192148 ●
Holz-Her 1891	100	43	25	30	DKN	2	2x4	8xA	AS	192082 ● 192083 ●
Holz-Her 1891	100	65	25	30	DKN	2	2x6	12xA	AS	192084 ● 192085 ●
Homag	125	42.6	54	30	DKN	3	3x4	12xA	AS	192287 ● 192288 ●
Homag	125	43	40	30	DKN	2	3x4	12xE	S	075627 ● 075627 ●
Homag	125	63	40	30	DKN	2	3x6	18xE	S	075626 ● 075626 ●
Homag	125	64.4	54	30	DKN	3	3x6	18xA	AS	192289 ● 192290 ●
IMA	125	32	34	30	DKN	2	3x4	12xD	AS	192092 ● 192093 ●
IMA	125	43	42	30	DKN	2	3x5	15xD	AS	192094 ● 192095 ●
IMA	125	63	42	30	DKN	3	3x7	21xD	AS	192096 ● 192097 ●
IMA	125	43	57	30	DKN	4	3x5	15xD	AS	192098 ● 192099 ●
Advantage										
IMA	125	65	57	30	DKN	4	3x7	21xD	AS	192100 ● 192101 ●
Advantage										
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	192209 ●
								3xB1		
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	192210 ●
								3xB2		
Ott	85	65	45	30	DKN	2	3x6	18xB	AS	192227 ● 192228 ●
Ott	85	85	50	30	DKN	3	3x8	24xB	AS	192229 ● 192230 ●
SCM	100	51	60	30	DKN	3	2x6	8xB	AS°	192215 ● 192216 ●
								2xB1		
								2xB2		
SCM	100	51	60	30	DKN	3	3x6	12xB	AS°	192217 ● 192218 ●
								3xB1		
								3xB2		
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	192213 ●
								2xB1		
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	192214 ●
								2xB2		
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	192219 ●
								3xB1		
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	192220 ●
								3xB2		
Stefani	100	51	60	30	DKN	3	2x6	8xB	AS°	192215 ● 192216 ●
								2xB1		
								2xB2		
Stefani	100	51	60	30	DKN	3	3x6	12xB	AS°	192217 ● 192218 ●
								3xB1		
								3xB2		
Stefani	100	66	60	30	DKN	3	2x7	12xB	AS°	192213 ●
								2xB1		
Stefani	100	66	60	30	DKN	3	2x7	12xB	AS°	192214 ●
								2xB2		
Stefani	100	66	60	30	DKN	3	3x7	18xB	AS°	192219 ●
								3xB1		
Stefani	100	66	60	30	DKN	3	3x7	18xB	AS°	192220 ●
								3xB2		
Törk Makine	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	090887 ● 090888 ●

2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters



Shape of WhisperCut spare knives
SB 6.7 / 14 mm

Spare knives:

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

Eroded spare knives for quick and easy knife change.

Spare parts:

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



WhisperCut jointing / milling cutter - cutterhead design

Application:

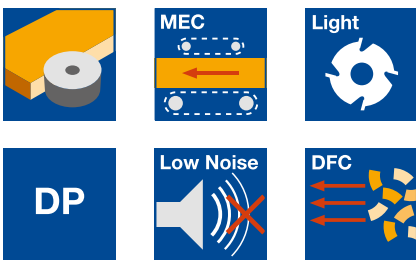
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

Machine:

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

Workpiece material:

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

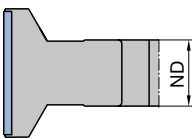


Technical information:

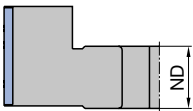
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for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

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

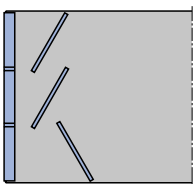
Machine	D	SB	ND	BO	NAL	n_{max}	Z	Type	ID	ID
	mm	mm	mm	mm		min^{-1}			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
Biesse	125	63	40	30 DKN	2	13700	3x8	S	192250 ●	192250 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192251 ●	192252 ●
IMA	125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



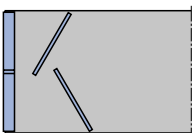
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



WhisperCut jointing / milling cutter - cutterhead design

Application:

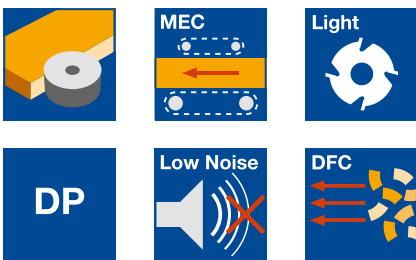
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

Machine:

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

Workpiece material:

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



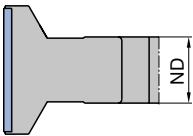
Technical information:

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

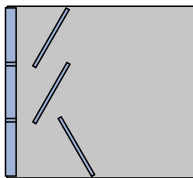
Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body

WM 230 2 02

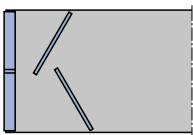
Machine	D	SB	ND	BO	NAL	n_{max}	Z	Type	ID	ID
	mm	mm	mm	mm		min^{-1}			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192256 ●	192257 ●



Position of boss (NAL) 2



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



Jointing / milling cutter on hydro sleeve

Application:

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

Machine:

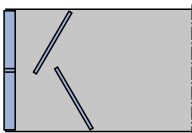
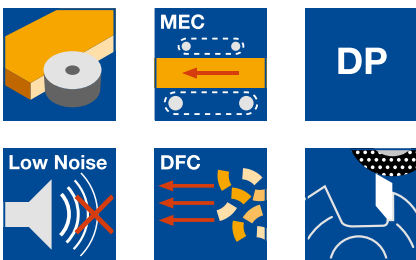
Edgebanding machines with zero joint technology.

Workpiece material:

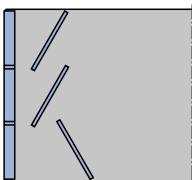
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

Technical information:

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



Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement

Diamaster PRO mounted on hydro sleeve

HF 230 2, HF 230 2 DP

Machine	D mm	SB mm	BO mm	n _{max} min ⁻¹	Z	Type	ID	
							LH	RH
Homag	125	43	30	13600	5x4	S	192133 □	192134 □
Homag	125	63	30	13600	5x6	S	192135 □	192136 □
Homag	150	43	30	13600	5x4	S	192205 □	192206 □
Homag	150	63	30	13600	5x6	S	192207 □	192208 □

Diamaster WhisperCut EdgeExpert mounted on hydro sleeve

HM 230 2 01

Machine	D mm	SB mm	BO mm	n _{max} min ⁻¹	Z	Type	ID	
							LH	RH
IMA	125	43	30	13700	4x6	AS	192259 □	192258 □
IMA	125	63	30	13700	4x8	AS	192261 □	192260 □
IMA	150	43	30	13700	4x6	AS	192263 □	192262 □
IMA	150	63	30	13700	4x8	AS	192265 □	192264 □

Spare parts:

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

2. Panel processing

2.1 Edge processing

2.1.2 Jointing cutters



Jointing / milling cutter on HSK-F 63 arbor

Application:

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

Machine:

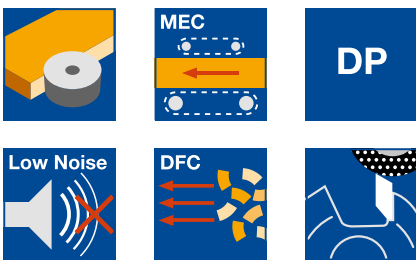
Edgebanding machines with zero joint technology.

Workpiece material:

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

Technical information:

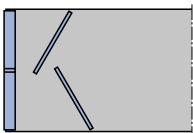
Increase of the processing quality through zero clearance HSK adaptor. Composite tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces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



Diamaster PRO mounted on HSK-F 63 mod.

WF 230 2 DP

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



Type S = symmetric knife arrangement



Jointing / milling cutter

Application:

For jointing/milling rebates in panel edges.

Machine:

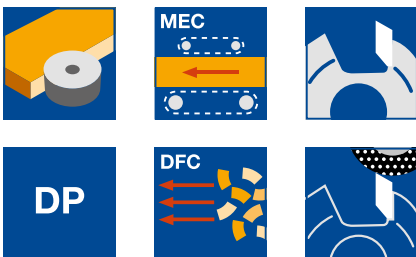
Edgebanding machines and double-end tenoners.

Workpiece material:

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

Technical information:

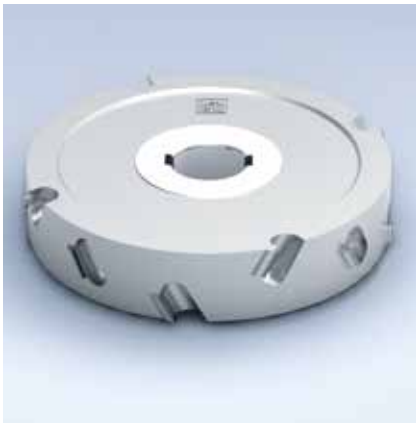
Composite tool with alternate shear angle for tear-free edges. DFC design for chip flow and efficient chip clearance (>95%). 1.5 mm resharpening area.



Diamaster PRO - DFC

WF 230 2 DP

D mm	SB mm	ND mm	BO mm	n_{max} min ⁻¹	Z	ID LH	ID RH
150	45	39	30 DKN	11400	4x5	192266	192267
150	64	39	30 DKN	11400	4x7	192268	192269



Protection milling / jump cutting

Application:

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

Machine:

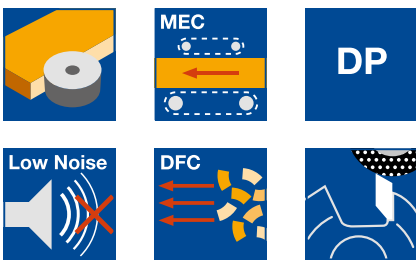
Edgebanding machines and double-end tenoners.

Workpiece material:

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

Technical information:

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



Diamaster PRO - DFC, LowNoise

WF 230 2 DP

Machine	D mm	SB mm	ND mm	BO mm	NAL	n _{max} min ⁻¹	Z	Type	ID	ID
									LH	RH
Homag, IMA	180	34	42	35	DKN 1	9500	4x3	AS	090851	090852
Homag, IMA	180	43	46	35	DKN 1	9500	4x4	AS	090841 ●	090842 ●
Homag, IMA	180	63	46	35	DKN 3	9500	4x6	AS	090839 ●	090840 ●



Protection milling / jump cutting

Application:

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

Machine:

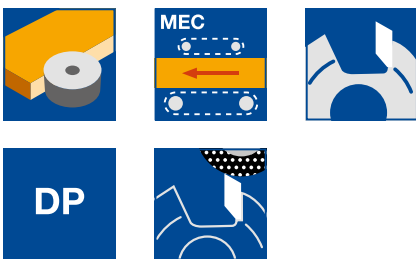
Edgebanding machines and double-end tenoners.

Workpiece material:

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

Technical information:

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



Diamaster PLUS

WF 230 2

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

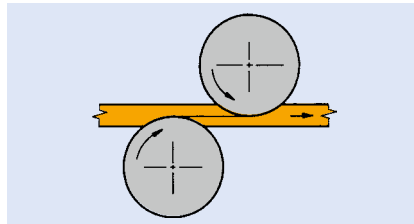
Recommended feed rate for 6000 min⁻¹ for veneered or coated particle and fibre materials.

Z=4	25 m min ⁻¹
Z=6	35 m min ⁻¹
Z=8	45 m min ⁻¹
Z=10	55 m min ⁻¹
Z=12	65 m min ⁻¹
Z=14	80 m min ⁻¹

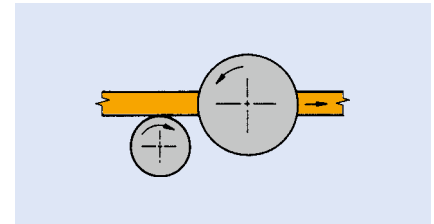
2. Panel processing

2.1 Edge processing 2.1.3 Compact hoggers - DP

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

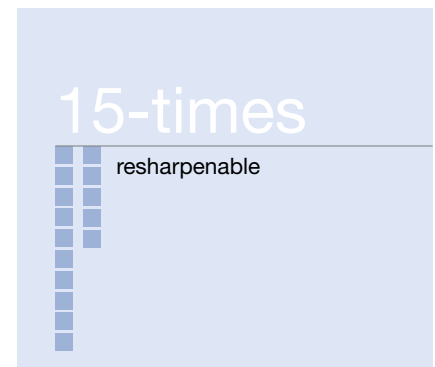
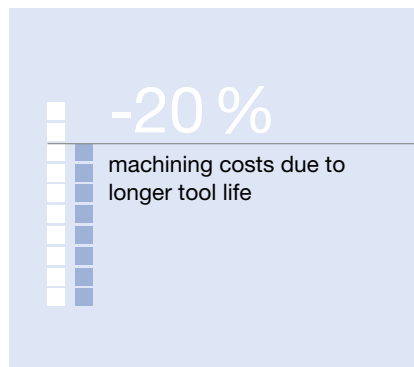


Double hogging: Both hogs cut with feed.



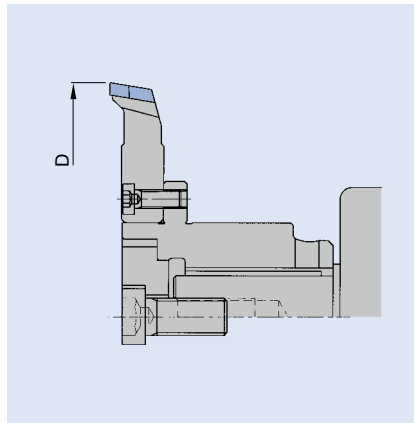
Scoring/hogging: Scoring saw cuts with feed, hogger against feed.

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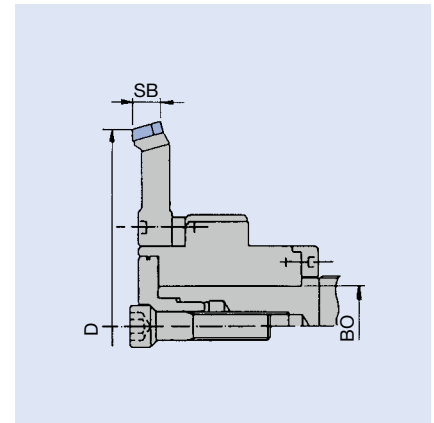


Productivity & efficiency	<p>Maximum economic efficiency through long tool life</p> <ul style="list-style-type: none"> – Long tool life even under difficult operating conditions thanks to new tooth shape – Reduction of set-up costs due to long tool life – Efficient chip removal due to innovative gullet geometry and integrated chipbreaker – Cost efficient processing of various materials – Ideal also for batch size 1 due to adapted cutting geometries – Resharpenable up to 15 times through larger resharpening area
Quality	<p>Perfect edges and cutting surfaces</p> <ul style="list-style-type: none"> – Excellent edge quality and smooth cutting surfaces through adapted cutting geometries – Clean workpiece finishes due to efficient chip removal with DFC®-Technology – Constant cutting width over the entire life cycle
Sustainability	<p>Longer tool life time, less dust and noise</p> <ul style="list-style-type: none"> – Reduced noise due to special tool design – Reduction of noise and vibration through damping elements – Longer tool life time through larger resharpening area

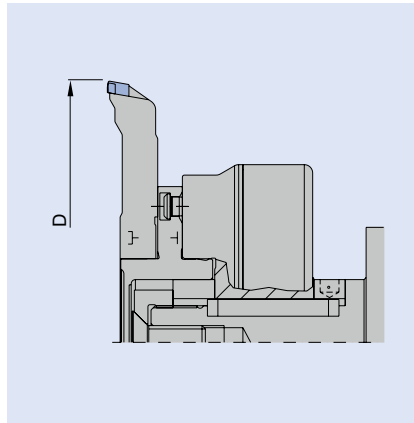
Designs



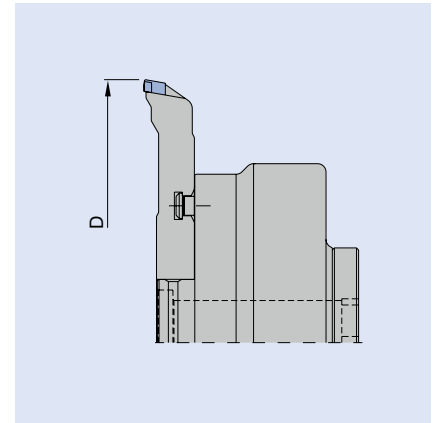
Tooth shape: top bevel decreasing.
Hogger on standard flange.



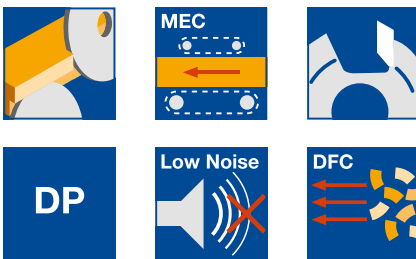
Tooth shape: top bevel increasing.
Hogger on HF hydro sleeve.



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



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



Diamaster DT Premium

Application:

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

Machine:

Double-end tenoners, edgebanding machines etc.

Workpiece material:

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

Technical information:

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

Diamaster DT Premium

HZ 210 2

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

Order example:

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

Special information:

Including assembly, machine model

Tooth shape 1 (ZF 1):

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

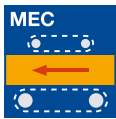
Tooth shape 2 (ZF 2):

For processing veneers, paper, honeycomb panels.

Further dimensions on request.

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

* Recommended feed rate.



Diamaster DT *Premium Score*

Application:

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

Machine:

Double-end tenoners, edgebanding machines etc.

Workpiece material:

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

Technical information:

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

Diamaster DT *Premium Score*

HZ 210 2

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

Order example:

Hogging set D-250 mm, Z 36, right

Hogging set consisting of:

DT Premium Score hogger D-250

ID **190443**

Hydro clamping sleeve ID **061702**

Special information:

Including assembly, machine model

Tooth shape 1 (ZF 1):

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

Tooth shape 2 (ZF 2):

For processing veneers, paper, honeycomb panels.

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

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

* Recommended feed rate.



Compact hogger

Application:

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

Machine:

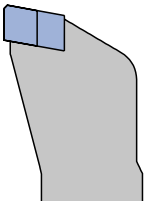
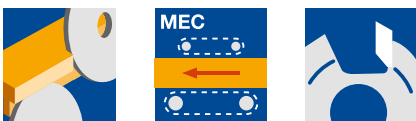
Double-end tenoners, edgebanding machines etc.

Workpiece material:

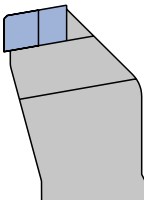
Particle and fibre materials (MDF etc.) uncoated, veneered, plastic and paper coated, lightweight panels (honeycomb).

Technical information:

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



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



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

For mounting on hydro clamping or hydro quick clamping sleeve

HZ 210 2

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

For mounting on flanged sleeve or quick clamping sleeve

HZ 210 2

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

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

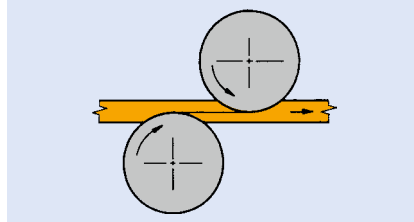
* Recommended feed rate for coated chipboard materials and fibre materials.

2. Panel processing

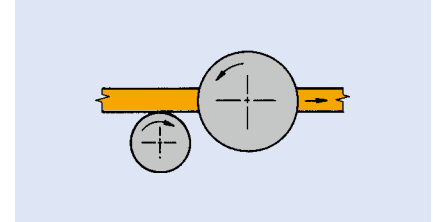
2.1 Edge processing 2.1.4 Cutting and segment hoggers

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

Application



Double hogging:
Both hogs cut with feed.



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

Recommended tooth shape hogger sawblades

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

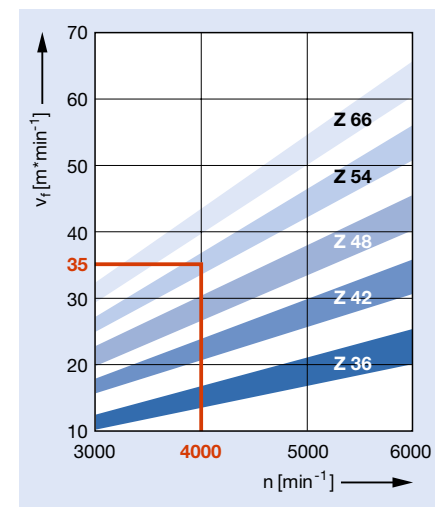
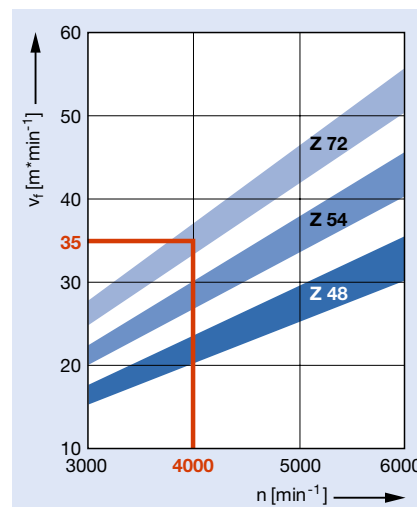
- suitable
- partly suitable

Cutting width and RPM

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

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

Segment hogger



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

2. Panel processing

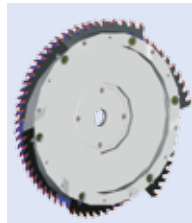
2.1 Edge processing

2.1.4 Cutting and segment hoggers

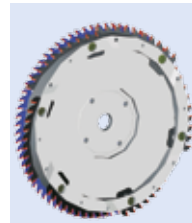
Segment hogger

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

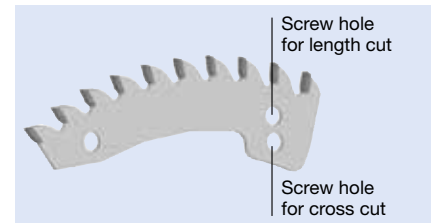
- Solid wood
- Wood derived materials without coating
- Wood derived materials with coating, with veneer, with paper etc.
- Composite materials



Cross cut



Length cut



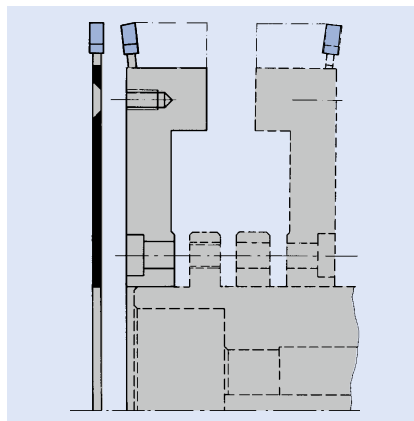
The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.

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

Saw hogger

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

Assembly design/examples



Segment hogger with extension hogger.



Hoggers

Application:

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

Machine:

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

Workpiece material:

Solid wood and wood derived materials.

Technical information:

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



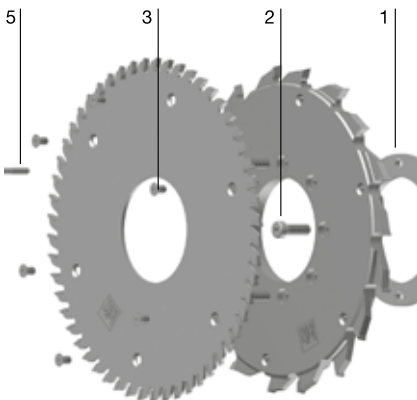
Basic hogger - steel tool body without flanged sleeve

WZ 210 2 01

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

Spare parts:

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



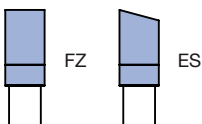
Additional hogger - steel tool body

WZ 210 2 02

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

Application:

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



Circular sawblade

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

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	4.4	80	54	FZ	HW	061825 ●	061826 ●
250	4.4	80	54	ES	HW	061837 ●	061838 ●
250	4.4	80	72	FZ	HW	061945 ●	061946 ●
260	4.4	80	72	ES	HW	061860 ●	061861 ●
260	4.4	80	72	FZ	HW	061947 ●	061948 ●
300	4.4	80	48	FZ	HW	061827 ●	061828 ●
300	4.4	80	48	ES	HW	062028 ●	062029 ●
300	4.4	80	72	FZ	HW	061949 ●	061950 ●



Segment hoggers

Application:

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

Machine:

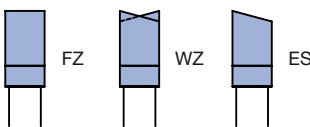
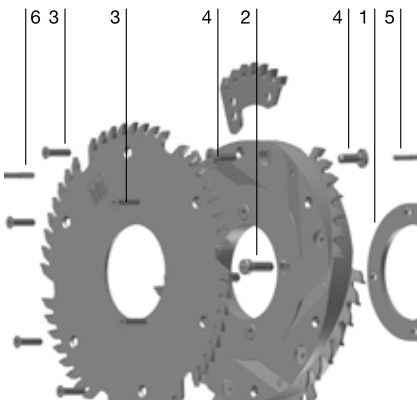
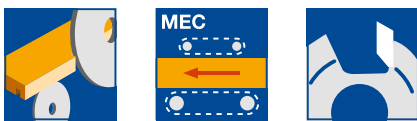
Double-end tenoners, finger joint machine with trimming aggregate, plug cutter.

Workpiece material:

All types of solid wood, chip and fibre boards (MDF etc.) raw, veneered, plastic and paper coated.

Technical information:

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



Steel basic and extension hoggers without flanged sleeve

WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	26.0	80	6x7	FZ	HW	064410 ●	064411 ●
300	31.5	30	6x9	FZ	HW	064412 ●	064413 ●
350	36.5	30	6x10	FZ	HW	064414 ●	064415 ●

Spare parts:

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

Spare circular sawblade for segment hogging set

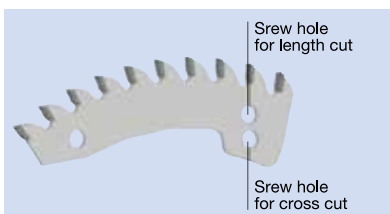
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

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

Spare segments for segment hogger

TM 170 0

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

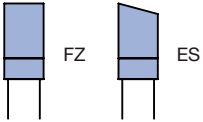
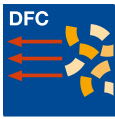


Spare segments for segment hogger

2. Panel processing

2.1 Edge processing

2.1.4 Cutting and segment hoggers



DFC segment hogger available on special request.

Spare circular sawblade for DFC segment hogger

WK 801 2, WK 801 2 05

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

Circular sawblades:

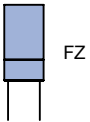
Tooth shape **ES** is optimised to cut across grain on softwood, hardwood, wood derived materials, veneered and paper coated and veneered composite materials.

Segments for DFC hogger (6 pieces / hogger)

TM 170 0

D	Z	ZF	QAL	ID	ID
mm				LH	RH
246	5	FZ	HW	064974 ●	064975 ●

DFC segment hogger available on special request.



Circular sawblade for non-Leitz segment hoggers

WK 800 2 46

Type	D	SB	BO	Z	ZF	QAL	ID	ID
	mm	mm	mm				LH	RH
1	250	4	80	48	FZ	HW	061870 ●	061871 ●
1	250	4	100	48	FZ	HW	061872 □	061873 □

Type 1 for Leuco.

Segments for non-Leitz segment hogger

TM 170 0

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

Type 1 for Leuco.

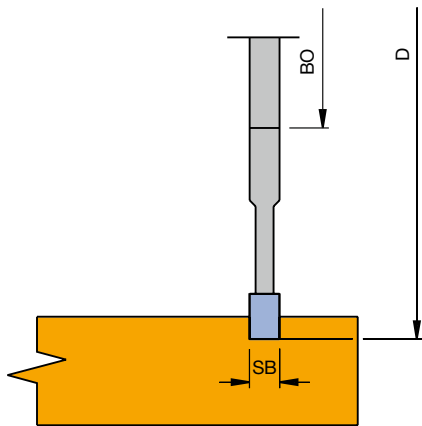
2. Panel processing

2.1 Edge processing

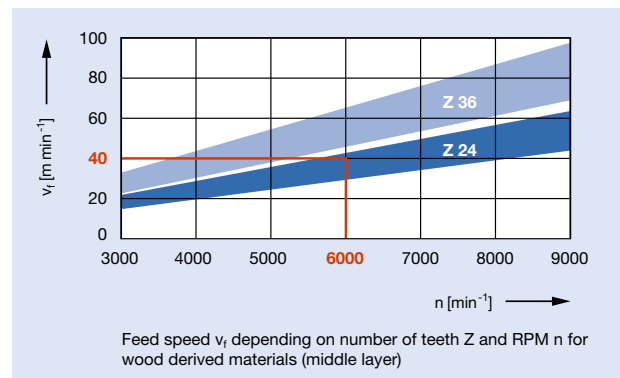
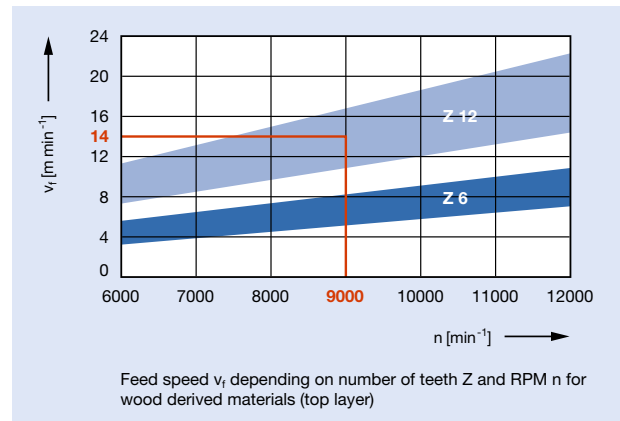
2.1.5 Grooving cutters

Grooving with feed

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



Cutting rear panel grooves

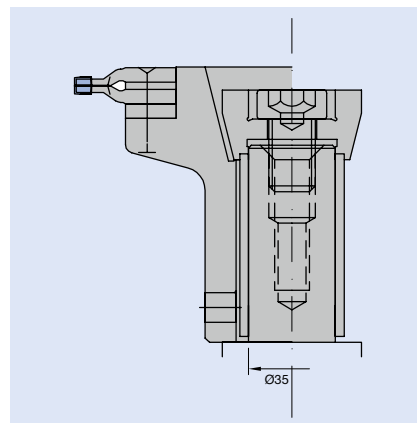


Grooving against feed

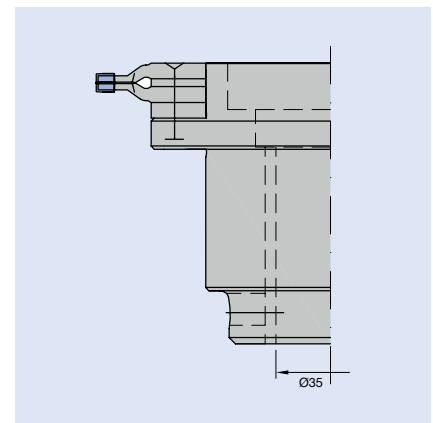
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

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

Tools for grooving against feed available on request.



Assembly example:
Spindle 30 KN or DKN



Assembly example:
Spindle 35 KN or DKN



Grooving cutter for mechanical feed

Application:

Grooving with feed (climb cut).

Machine:

Moulders and double-end tenoners.

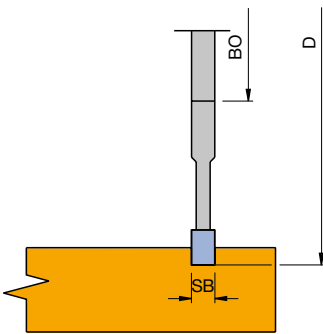
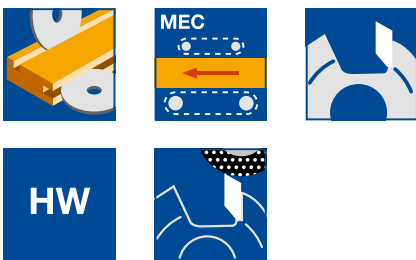
Workpiece material:

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

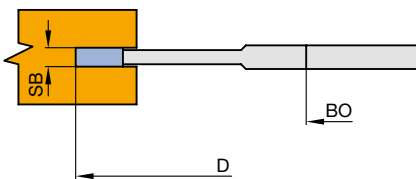
Z 12, HW tipped

WF 100 2 02

D	SB	TDI	BO	BO _{max}	Z	n _{max} min ⁻¹	ID
mm	mm	mm	mm	mm			
125	1.5	0.8	30	50	12	13700	020145 ●
125	2.0	1.2	30	50	12	13700	020147 ●
125	2.5	1.4	30	50	12	13700	020149 ●
125	3.0	2.0	30	50	12	13700	020150 ●
125	3.5	2.2	30	50	12	13700	020151 ●
125	4.0	2.5	30	50	12	13700	020152 ●
125	4.5	3.0	30	50	12	13700	020153 ●
125	5.0	3.5	30	50	12	13700	020191 ●
125	6.0	4.5	30	50	12	13700	020192 ●
125	7.0	5.0	30	50	12	13700	020193 ●
125	8.0	6.0	30	50	12	13700	020194 ●
125	9.0	6.5	30	50	12	13700	020195 ●
125	10.0	7.0	30	50	12	13700	020196 ●
150	3.0	2.0	30	60	12	11400	020154 ●
150	3.5	2.2	30	60	12	11400	020155 ●
150	4.0	2.5	30	60	12	11400	020156 ●
150	4.5	3.0	30	60	12	11400	020157 ●
150	5.0	3.5	30	60	12	11400	020158 ●
150	6.0	4.5	30	60	12	11400	020159 ●
150	7.0	5.0	30	60	12	11400	020160 ●
150	8.0	6.0	30	60	12	11400	020161 ●
150	9.0	6.5	30	60	12	11400	020162 ●
150	10.0	7.0	30	60	12	11400	020163 ●



Cutting the rear panel groove



Grooving the narrow side



Grooving cutter for mechanical feed

Application:

Grooving with feed (climb cut).

Machine:

Moulders and double-end tenoners.

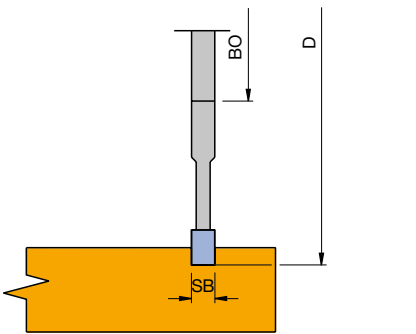
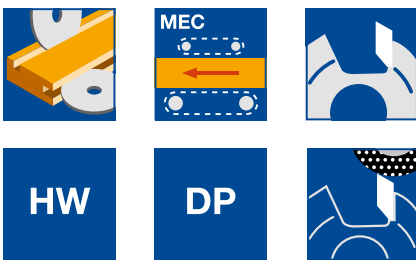
Workpiece material:

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

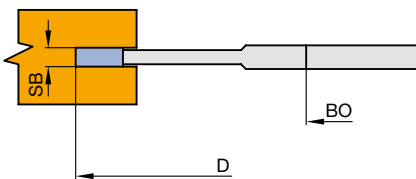
Z 18, HW tipped

WF 100 2 03

D	SB	TDI	BO	BO _{max}	DKN	Z	QAL	n _{max}	ID
mm	mm	mm	mm	mm	mm			min ⁻¹	
150	1.5	0.8	30	60		18	HW	11400	020164 ●
150	2.0	1.2	30	60		18	HW	11400	020166 ●
150	2.5	1.4	30	60		18	HW	11400	020168 ●
150	3.0	2.0	30	60		18	HW	11400	020169 ●
150	4.0	2.5	30	60		18	HW	11400	020170 ●
150	5.0	3.5	30	60		18	HW	11400	020171 ●
150	6.0	4.5	30	60		18	HW	11400	020172 ●
150	8.0	6.0	30	60		18	HW	11400	020173 ●
150	8.5	6.0	30	60		18	HW	11400	020319 ●
150	10.0	7.0	30	60		18	HW	11400	020174 ●
180	2.0	1.2	30	70		18	HW	9500	020202 ●
180	2.5	1.4	30	70		18	HW	9500	020203 ●
180	3.0	2.0	30	70		18	HW	9500	020204 ●
180	3.5	2.2	30	70		18	HW	9500	020205 ●
180	4.0	2.5	30	60		18	HW	9500	020197 ●
180	5.0	3.5	30	60		18	HW	9500	020198 ●
180	6.0	4.5	30	60		18	HW	9500	020199 ●
180	8.0	6.0	30	60		18	HW	9500	020200 ●
180	8.5	6.0	30	60		18	HW	9500	020320 ●
180	10.0	7.0	30	60		18	HW	9500	020201 ●
200	2.0	1.2	35	80	10x45	18	HW	8500	020299 ●
200	2.5	1.4	35	80	10x45	18	HW	8500	020301 ●
200	3.0	2.0	35	80	10x45	18	HW	8500	020302 ●
200	4.0	2.5	35	80	10x45	18	HW	8500	020303 ●
200	5.0	3.5	35	80	10x45	18	HW	8500	020304 ●
200	6.0	4.5	35	80	10x45	18	HW	8500	020305 ●
200	8.0	6.0	35	80	10x45	18	HW	8500	020306 ●
200	8.5	6.0	30	80	10x45	18	HW	8500	020321 ●
200	10.0	7.0	35	80	10x45	18	HW	8500	020307 ●



Cutting the rear panel groove



Grooving the narrow side

Z 18, DP tipped

WF 100 2 DP

D	SB	TDI	BO	BO _{max}	DKN	Z	QAL	n _{max}	ID
mm	mm	mm	mm	mm	mm			min ⁻¹	
150	4.0	2.5	30	60		18	DP	11400	192304 ●
180	4.0	2.5	30	60		24	DP	9500	192305 ●
200	4.0	2.5	30	80	10x45	24	DP	8500	192306 ●



Circular sawblade for end trim on edgebanding machines

Application:

For low noise edgebanding trim cuts.

Machine:

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

Workpiece material:

Softwood, hardwood, veneered, melamine and plastic edging.

Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

Veneered and plastic edging:

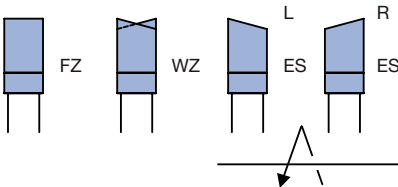
Edging thickness ≥ 2.0 mm - crosscut saw ES pos.

Edging thickness < 2.0 mm - crosscut saw ES neg.

Solid wood edging and multi-purpose application:

Edging thickness ≥ 2.0 mm - crosscut saw WZ pos.

Edging thickness < 2.0 mm - crosscut saw WZ neg.



Circular sawblade - LowNoise

SK 499 2, WK 101 2, WK 250 2, WK 300 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 350 0, WK 350 2, WK 360 2, WK 370 2, WK 372 2, WK 380 2, WK 850 2

Machine	D mm	SB mm	BO mm	Z	ZF	n _{max} min ⁻¹	ID	
							LH	RH
Biesse	115	3.2	52	30	ES pos.	19900	166421	166420
Biesse	115	3.2	56	30	ES pos.	19900	166423	166422
Biesse	130	3.6	30	24	ES pos.	17600	166425 ●	166424 ●
Biesse	140	3.2	30	36	ES pos.	16300	166426 ●	166427 ●
Biesse	160	3.2	20	48	WZ pos.	14300	166428 ●	166428 ●
Brandt	100	2.6	32	30	ES neg.	22900	166400 ●	166401 ●
Brandt	100	2.6	32	30	ES pos.	22900	166429 ●	166430 ●
Brandt	100	2.6	32	30	WZ pos.	22900	166431 ●	166431 ●
Brandt	110	2.4	32	40	ES pos.	20800	166432	166433
Brandt	125	2.4	32	24	WZ pos.	18300	166402 ●	166402 ●
Brandt	125	2.6	32	30	ES neg.	18300	166403 ●	166404 ●
Brandt	150	2.8	20	36	ES pos.	15200	166434 ●	166435 ●
Cehisa	100	3.0	32	30	ES pos.	22900	166436 ●	166437 ●
Felder	100	3.2	22	20	WZ pos.	22900	166438 ●	166438 ●
Felder	110	3.2	30	20	WZ pos.	20800	166475 ●	166475 ●
Fravol	100	3.2	22	24	ES pos.	22900	166407 ●	166406 ●
Fravol	100	2.6	30	30	WZ pos.	22900	166473 ●	166473 ●
Fravol	125	3.2	22	30	ES pos.	18300	166411 ●	166410 ●
Hebrock/EBM	100	2.4	22	20	WZ neg.	22900	166405 ●	166405 ●
** Holz-Her	110	3.6	22	20	WZ pos.	20800	065663 ●	065663 ●
Holz-Her	120	3.2	22	20	WZ pos.	19000	166474 ●	166474 ●
Holz-Her	140	3.2	22	36	WZ pos.	16300	166441 ●	166441 ●
** Holz-Her	140	3.2	22	36	WZ pos.	14300	065667 ●	065667 ●
Holz-Her	160	3.2	20	48	WZ pos.	14300	166428 ●	166428 ●
Holz-Her	160	2.8	30	24	WZ pos.	14300	166442 ●	166442 ●
** Holz-Her	160	3.2	30	24	WZ pos.	14300	065664 ●	065664 ●
Holz-Her 1918/KA701	110	3.6	22	16	ES pos.	20800	160016 ●	160017 ●
Homag	80	3.2	34	30	ES pos.	28600	166444 ●	166443 ●
Homag	92	3.0	32	20	ES pos.	22900	166471 ●	166470 ●
* Homag	100	3.0	32	20	ES pos.	22900	166445 ●	166446 ●
Homag	100	3.0	32	20	ES pos.	22900	166448 ●	166447 ●
Homag	100	3.2	32	20	ES neg.	22900	166449 ●	166450 ●
Homag	100	3.6	32	20	WZ pos.	22900	166451 ●	166451 ●
Homag	100	2.6	32	30	ES pos.	22900	166429 ●	166430 ●
Homag	100	2.6	32	30	WZ pos.	22900	166431 ●	166431 ●
Homag	110	3.6	32	20	WZ pos.	20800	166452 ●	166452 ●
Homag	110	2.4	32	40	ES pos.	20800	166432	166433
Homag	110	1.7	40	30	FZ/TR pos.	20800	166453 ●	166453 ●
Homag	120	3.6	40	24	WZ pos.	19000	166419 ●	166419 ●
* Homag	120	3.2	40	30	ES pos.	19000	166454 ●	166455 ●
Homag	120	3.2	40	36	WZ pos.	19000	166456 ●	166456 ●
Homag	120	3.6	40	36	WZ pos.	19000	166457 ●	166457 ●
Homag	125	2.4	30	36	WZ pos.	18300	058234 ●	058234 ●
Homag	150	2.8	20	36	ES pos.	15200	166434 ●	166435 ●

Machine	D	SB	BO	Z	ZF	n_{\max}	ID	ID
	mm	mm	mm			min^{-1}	LH	RH
Homag	150	3.5	30	40	ES pos.	15200	166459	166458
Homag	170	3.2	30	36	WZ pos.	13400	166412 ●	166412 ●
Homag	180	3.2	30	54	WZ pos.	12700	166460 ●	166460 ●
IDM	90	3.0	30	20	FZ pos.	25400	166461	166461
IMA	160	3.5	22	36	WZ neg.	14300	166462 ●	166462 ●
IMA	160	3.2	22	48	WZ neg.	14300	166414 ●	166414 ●
IMA	180	3.2	22	48	WZ pos.	12700	166463 ●	166463 ●
IMA	180	3.2	22	48	WZ neg.	12700	166464 ●	166464 ●
IMA	200	3.2	30	64	WZ pos.	11400	166465 ●	166465 ●
IMA 08.415	180	3.5	22	42	WZ neg.	12700	166415 ●	166415 ●
IMA 08.492	160	3.0	22	36	WZ pos.	12700	166413 ●	166413 ●
Ott	140	3.2	16	36	WZ pos.	16300	166466 ●	166466 ●
Raimann	100	3.6	32	20	WZ pos.	22900	166451 ●	166451 ●
Raimann	120	3.2	32	20	WZ neg.	19000	166467 ●	166467 ●
SCM	115	3.2	30	30	WZ pos.	19900	166416 ●	166416 ●
SCM	150	3.8	35	30	ES pos.	15200	166468 ●	166469 ●
Törk Makine	140	3.2	30	36	ES pos.	16300	166417 ●	166418 ●
Wilmsmeyer	100	3.2	32	20	ES neg.	22900	166449 ●	166450 ●

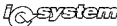
* = For 2 part set SK 499 2 use mounting flange ID **066750**.

** = Special version for solid wood edges.

2. Panel processing

2.1 Edge processing

2.1.7 Edge finishing tools

Working processes	<p>Finishing plastic, veneered and solid wood edges of wood material boards.</p> <ul style="list-style-type: none"> – Pre-cutting to remove asymmetric edge protrusions on top and bottom edges and edge trimming solid wood edges. – Profiling a bevel or round edge on top and bottom edges. – Profiling a bevel and round edges on top and bottom edges and front and back. – Profile scrapers to remove knife marks. – Flat scrapers for excellent alignment of edge and workpiece.
Workpiece material	<p>Thick plastic edgebanding made from PVC, PP, ABS, thin plastic edgebanding made from melamine resin, veneer edgebanding, solid wood banding and edgebanding.</p>
Machines	<p>Single or double-sided edgebanding machines, double-end tenoners.</p>
Application	<p>Against feed for plastic edgebanding, preferably with feed for solid wood edge lippings.</p>
Technical features	<p>The tools are designed for the machine, the diameters and axial dimensions match the positions of the tracing rollers. Constant diameters are required for traced tools, ideally cutterheads with replaceable tips or DP tools that are not sharpened. Sharpening on the periphery is only possible with additional tracing rollers.</p>
Chip disposal	<p>Tools marked with the symbol  are optimised for these machines, and guide the chips from the tool cutting edge into the extraction. Even at low extraction air speeds more than 97% of the chips are collected. This improves not only process efficiency and productivity, but also the working environment. New machines require less extraction.</p>



Pre / finishing edge trimming cutter

Application:

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

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

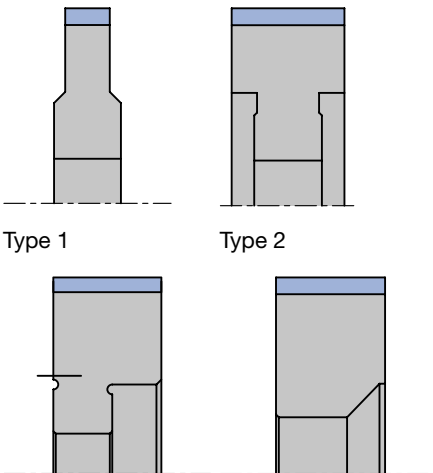
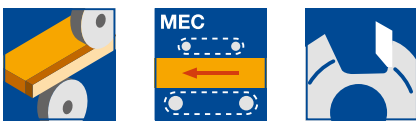
Technical information:

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

Joining cutter

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

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



Trimming of edges on horizontal spindle
- top motor tracing.

Bevelling of edges with inclined spindle.

Type 3

Type 4

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Pre / finishing edge trimming cutter *iQsystem*

Application:

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

Machine:

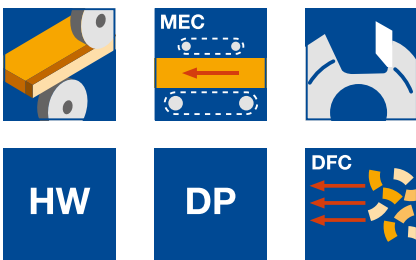
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Jointing cutter *iQsystem* - HSK 25 R

WF 200 2 DP, WF 210 2

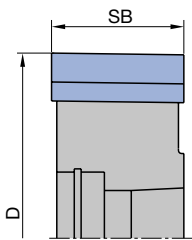
Machine	D	SB	BO	Z	QAL	n_{\max} min ⁻¹	ID	ID
	mm	mm	mm				LH	RH
Homag, IMA	70	25	HSK 25 R	4	HW	18000	073092 ●	073093 ●
Homag, IMA	70	8	HSK 25 R	4	DP	18000	198472 ●	198473 ●
Homag, IMA	70	8	HSK 25 R	6	DP	18000	198474 ●	198475 ●
Homag, IMA	70	8	HSK 25 R	8	DP	18000	198404 ●	198405 ●
Homag, IMA	70	15	HSK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

Recommended number of teeth:

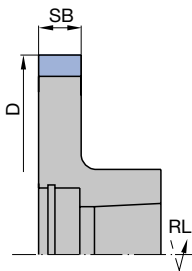
Feed rates of up to 35 m min⁻¹ Z 4

Feed rates of up to 60 m min⁻¹ Z 6

Feed rates of up to 100 m min⁻¹ Z 8 (thin edge)



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



DP jointing cutter with HSK 25 R adaptor



Pre / finishing edge trimming cutter cutterhead design

Application:

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

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

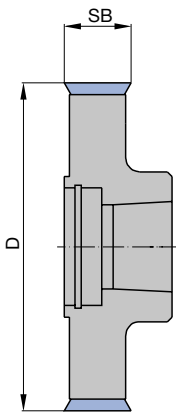
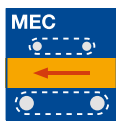
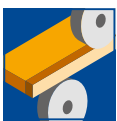
Technical information:

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

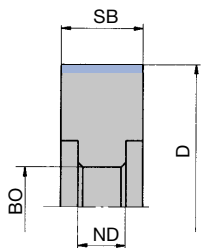
Joining cutterhead

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

Machine	Type	D mm	SB mm	BO mm	Z	n_{max} min ⁻¹	ID LH	ID RH
Brandt	1	70	14.3	16 DKN	4	18000	025130 ●	025130 ●
Homag	1	70	14.3	HSK 25 R	4	12000	073599 ●	073600 ●
Homag	2	70	20	16 DKN	4	18000	025079 ●	025079 ●
Ott, Holz-Her	2	70	20	16	4	18000	025078	025078
Holz-Her 1962	2	80	40	30 KN	4	18000	024415	024415



Type 1: WW 200 2 25



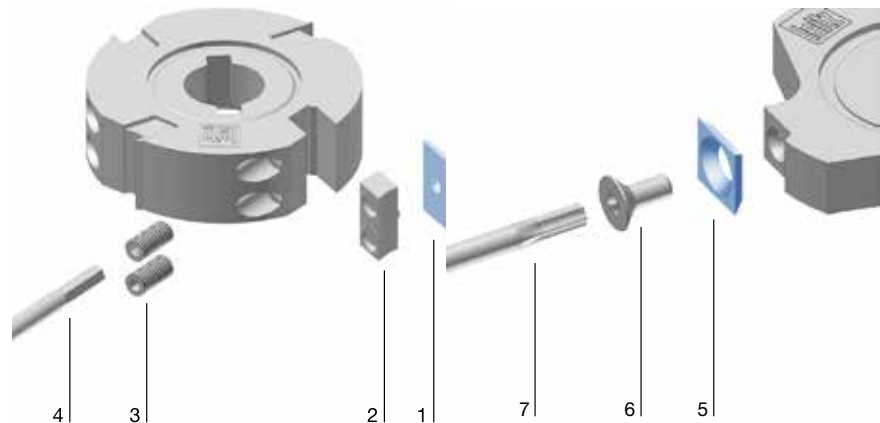
Type 2: WW 200 2 06

Spare knives:

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

Spare parts:

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





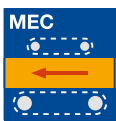
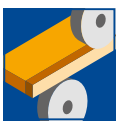
Bevel cutter

Application:
To bevel edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

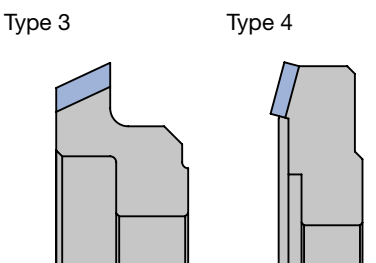
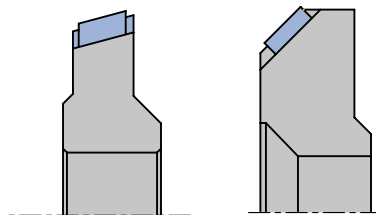
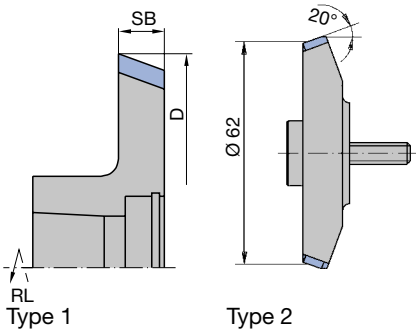
Technical information:
DP tipped tools with cylindrical bore, HSK 25 R or HSK 32 adaptor for FK aggregates.
DP tools - 3 mm tip height.

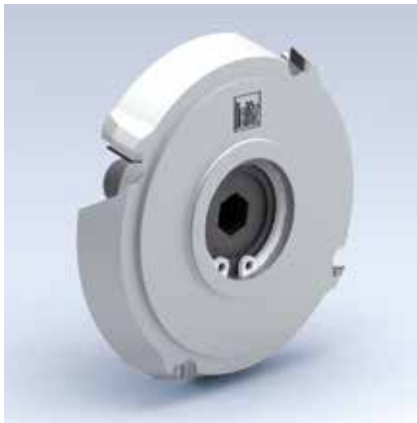


Various bevel angles - DP tipped

WF 300 2 DP, WF 350 2 DP

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





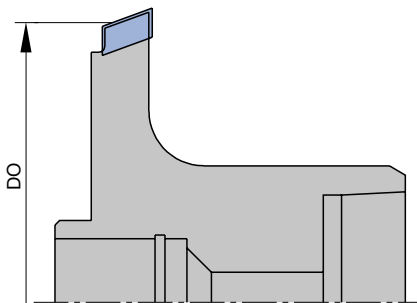
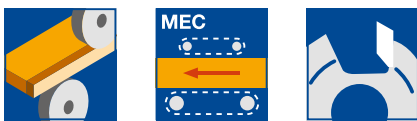
Bevel cutter *iQ-system*

Application:
To bevel edgebandings.

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

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

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



Bevel cutter with HSK 32 adaptor for FK aggregates

Various bevel angles *iQ-system* - Diamaster PRO

WF 350 2 DP

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



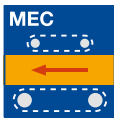
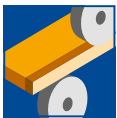
Profile cutter

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

Technical information:
DP tipped tools with cylindrical bore or HSK 25 R adaptor. D_0 = constant reference diameter.
DP tools - 3 mm tip height.

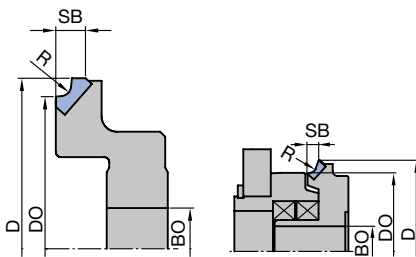


Various radii

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

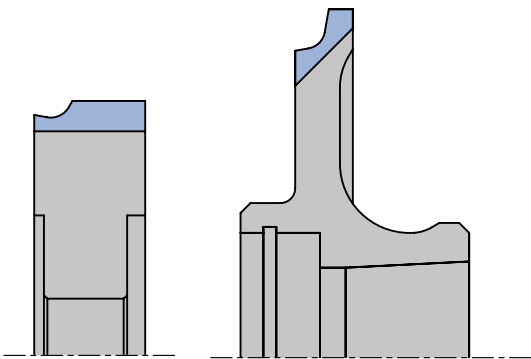
Machine	D	D_0	BO	Z	QAL	R	Type	n_{max}	ID	ID
	mm	mm	mm			mm		min^{-1}	LH	RH
Biesse	67	60	16 DKN	6	DP	1.0	1	18000	091960 ●	091961 ●
Biesse	68	60	16 DKN	6	DP	2.0	1	18000	091962 ●	091963 ●
Biesse	70	60	16 DKN	6	DP	3.0	1	18000	091964 ●	091965 ●
Biesse	72	70	16 KN	6	DP	1.0	5	18000	192518 ●	192519 ●
Biesse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

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



Type 1

Type 2



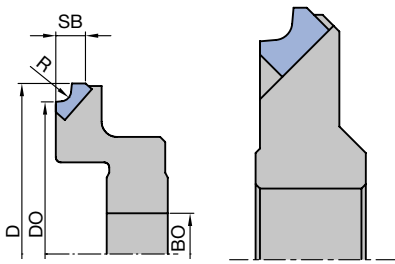
Type 5

Type 7

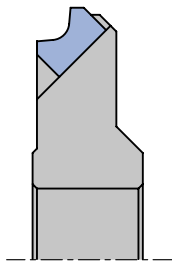
2. Panel processing

2.1 Edge processing

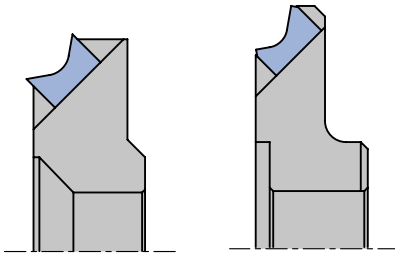
2.1.7 Edge finishing tools



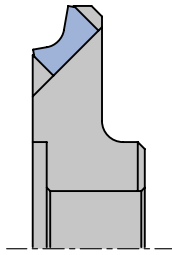
Type 1



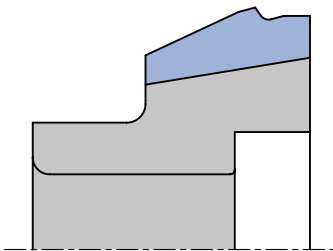
Type 3



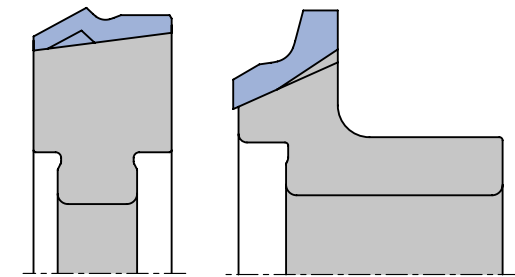
Type 4



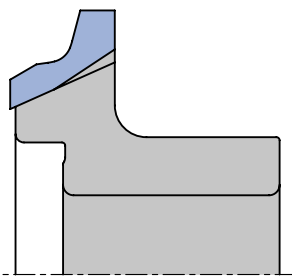
Type 6



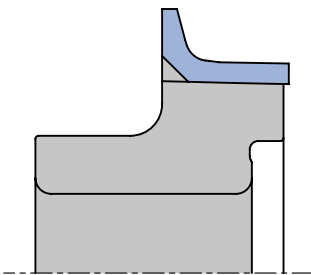
Type 8



Type 9



Type 10



Type 11

Various radii

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

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



Profile cutter

Application:

To round (profile) edgebandings on FK aggregate.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

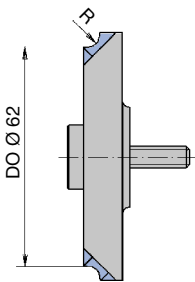
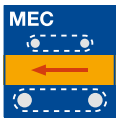
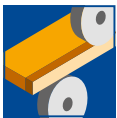
Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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

D_0 = constant reference diameter.

DP tools - 3 mm tip height.



Type 1

Various radii - Diamaster PRO, FK aggregate, HSK 32

WF 501 2 DP

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



Profile cutter

Application:

For a choice of radii or bevels on edgebandings.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

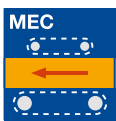
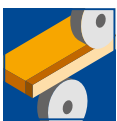
Technical information:

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

Profiling with e.g. radii 2.0 and 3.0 mm and bevel 20°.

D₀ = constant reference diameter.

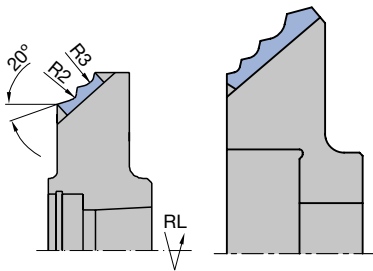
DP tools - 0.5 mm resharpening area.



Multi-profile cutter - Diamaster PRO

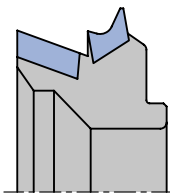
WF 501 2, WF 501 2 DP, WF 501 2 DP , WF 502 2 DP, WF 502 2 DP

Machine	D	D ₀	BO	Type	Z	R	FAW	n _{max}	ID	ID
	mm	mm	mm			mm	°	min ⁻¹	LH	RH
Biesse	75.4	60	16 DKN	2	6	1/2/3	25°	18000	091996 ●	091995 ●
Brandt	78	57.3	16 DKN	2	4	1.2/2/3	15°	18000	091967 ●	091968 ●
Holz-Her	58	50	20 DKN	3	2	2		18000	192530 ●	192531 ●
1826										
Holz-Her	58	50	20 DKN	3	2	2.5		18000	192532 ●	192533 ●
1826										
Holz-Her	58	50	20 DKN	3	2	3		18000	192534 ●	192535 ●
1826										
Holz-Her	71	68	16 DKN	6	4	3/2/1.3	45°	18000	192673 ●	192674 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	2/2/1.3	45°	18000	192675 ●	192676 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	2/1.3/1.3	45°	18000	192677 ●	192678 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	3/2/1.3	10°	18000	192679 ●	192680 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	1.3/1/0.8	45°	18000	192681 ●	192682 ●
FR 701										
Homag	74.33	62.99	16 DKN	5	4	1/2		18000	192683 ●	192684 ●
Homag	74.66	65.69	16 DKN	5	4	1.3/2		18000	192685 ●	192686 ●
Homag	85	65.2	HSK 25 R 1	4	2/3		20°	18000	091798 ●	091799 ●
IMA	85	65.2	HSK 25 R 1	4	2/3		20°	18000	091798 ●	091799 ●
Stefani	74.5	63.88	HSK 25 R 4	4	1/1.5/2		20°	18000	192655 ●	192656 ●
Stefani	74.5	63.88	HSK 25 R 1	4	1/1.5/2		20°	18000	192653 ●	192654 ●

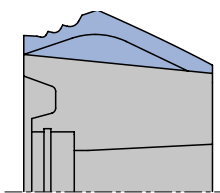


Type 1

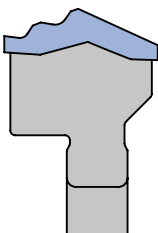
Type 2



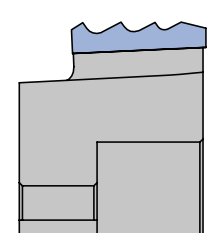
Type 3



Type 4



Type 5



Type 6

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



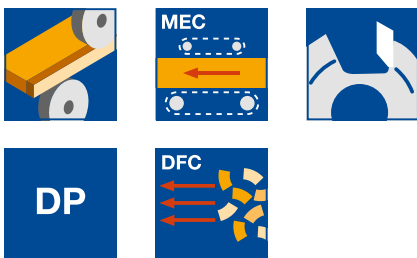
Profile cutter *iQsystem*

Application:
To round edgebandings.

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

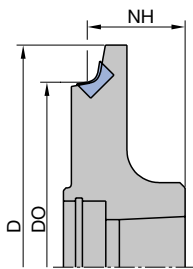
Workpiece material:
Plastic, softwood, hardwood and veneer edgebander.

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

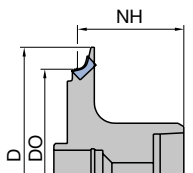


Various radii *iQsystem* - Diamaster PRO, HSK 25 R WF 501 2 DP

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



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 R adaptor for FK aggregates

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

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

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

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

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutter *iQsystem*

Application:

For a choice of radii or bevels on edgebandings.

Machine:

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

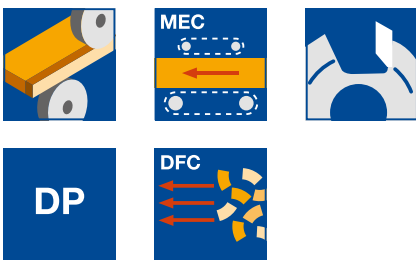
Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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

DP tools - 3 mm tip height.

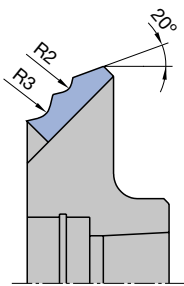


Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R

WF 501 2 DP

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

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



Multi-profile cutter i-System

2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutter *iQsystem*

Application:

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

Machine:

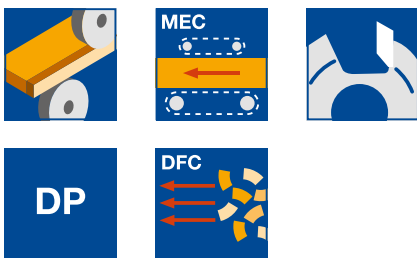
IMA edgebanding machine with KFA aggregates.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

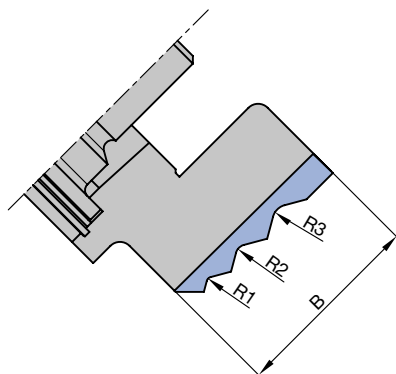
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. 3 mm tip height. Constant diameters. Low noise.



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

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

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



2. Panel processing

2.1 Edge processing 2.1.7 Edge finishing tools



Profile cutter *iQsystem*

Application:

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

Machine:

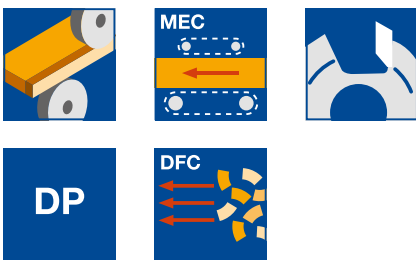
IMA edgebanding machines with MFA aggregates.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

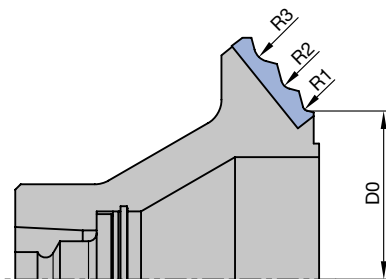
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. 3 mm tip height. Constant diameters. Low noise.



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

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

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





Profile cutter *IQsystem*

Application:

To round (profile trim) edgebandings on FK31 aggregates.

Machine:

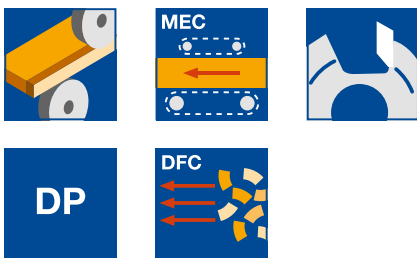
Homag edgebanding machines with profile FK31 trimming aggregate.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Diamaster PRO, FK31 aggregate - Tool 1 fixed

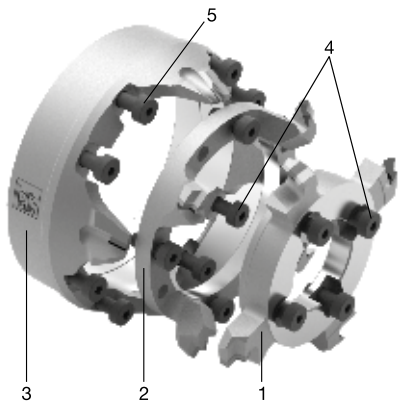
WF 501 2 DP

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

Diamaster PRO, FK31 aggregate - Tool 2 moveable

WF 501 2 DP

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



Diamaster PRO, FK31 aggregate - Tool 3 moveable

WF 300 2 DP, WF 501 2 DP

Machine	Tool no.	D mm	D_0 mm	BO mm	Z	QAL	R mm	FAW °	n_{max} min ⁻¹	ID LH	ID RH
Homag	3	92	80.1	73	4	DP	1.0		18000	192574 ●	192575 ●
Homag	3	92	80.1	73	4	DP	1.5		18000	192572 ●	192573 ●
Homag	3	92	80.1	73	4	DP	1.7		18000	192584 ●	192585 ●
Homag	3	92	80.1	73	4	DP	2.0		18000	192570 ●	192571 ●
Homag	3	92	80.1	73	4	DP		15°	18000	091520 ●	091521 ●
FK 31 PowerTrim											
Homag	3	92	80.1	73	4	DP		20°	18000	192118 ●	192119 ●
Homag	3	92	80.1	73	4	DP		30°	18000	192125 ●	192126 ●
Homag	3	92	80.1	73	4	DP		45°	18000	192116 ●	192117 ●

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

Spare parts:

Part-no.	BEZ	ABM mm	ID
4	Cylindrical screw with ISK	M5x12	114046 ●
5	Cylindrical screw with ISK	M5x30	114045 ●
	Allen key	SW 3	005444 ●

Tools supplied with mounting screws.



Profile cutter flexTrim

Application:

For multi-profile cutting with radii and bevelling of edges. Combination of two profiles for automatic profile resetting in the workpiece gap.

Machine:

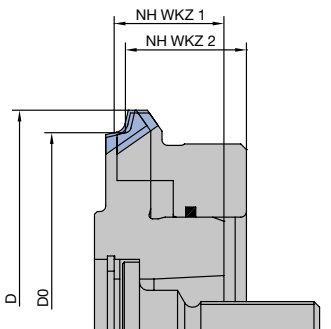
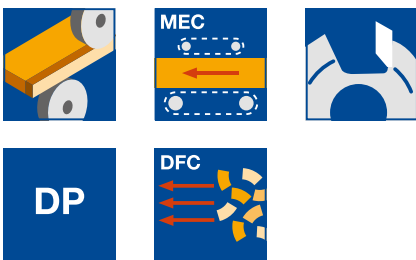
Homag edgebanding machines for cutting units types FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Multi-profile cutterset flexTrim - Diamaster PRO

SF 542 2 15

Machine	D	D_0	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	19.5	HSK 25 R	4	DP	1.5/1.0		194300 ●	194301 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.0		194302 ●	194303 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.5		194304 ●	194305 ●
Homag	78	70	19.5	HSK 25 R	4	DP	3.0/2.0		194306 ●	194307 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0	20°	194308 ●	194309 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0	45°	194310 ●	194311 ●

Tool 1 fix + tool 2 flexible

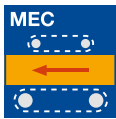
All tools and further profile variants available in various dimensions from blank at short notice. Further combinations possible on request.

Spare parts:

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



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



Profile cutter flexTrim3

Application:

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

Machine:

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

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

DP composite tool for setwise application. Maximum processing quality through high running accuracy and quiet running.

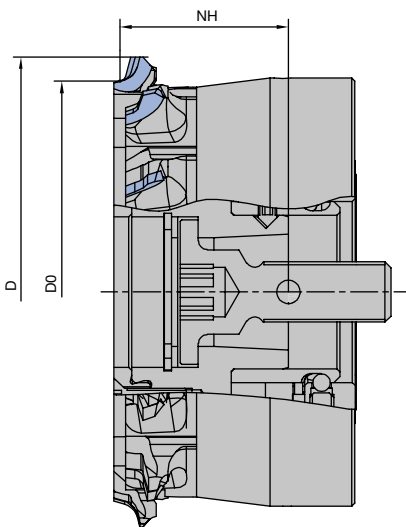
D_0 = constant reference diameter, RPM $n_{max} = 12.000 \text{ min}^{-1}$.

Multi-profile cutterset flexTrim3 - Diamaster PRO

SF 541 2 17

Machine	D	D_0	NH	BO	Z	QAL	R	ID	ID
	mm	mm	mm	mm			mm	LH	RH
Homag	78	70	28	HSK 25 R	4	DP	2/1.5/1	194500 ●	194501 ●
Homag	78	70	28	HSK 25 R	4	DP	2/1.3/1	194502 ●	194503 ●

Further profile variants and combinations possible on request.



Diamaster PRO - single tools

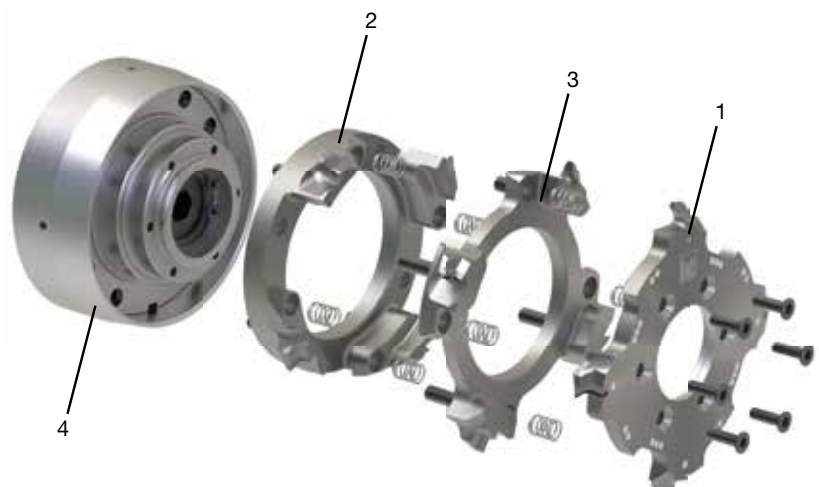
WF 501 2 17

Tool no.	D	D_0	BO	Z	QAL	R	ID	ID
	mm	mm	mm			mm	LH	RH
1	78	70	30	4	DP	2	194403 ●	194411 ●
2	78	70	45	4	DP	1.3	194417 ●	194425 ●
2	78	70	45	4	DP	1.5	194418 ●	194426 ●
3	78	70	40	4	DP	1	194432 ●	194440 ●

It is recommended to change single tools only in the course of a service by Homag or by the Leitz tool service. Single tools are delivered with appropriate compression springs and screws.

Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
4	Multi-profile cutter aggregate	D71x37.2xHSK25R	194350 ●





Profile cutter Quattro^{Form}

Application:

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

Machine:

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

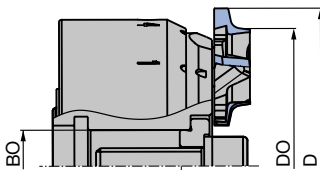
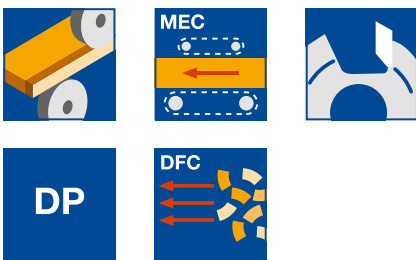
Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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

D₀ = constant reference diameter, RPM n = 18,000 min⁻¹.

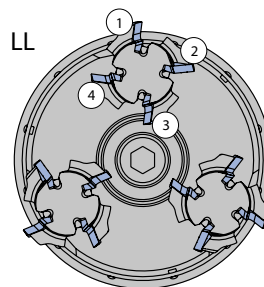


Multi-profile cutter Quattro^{Form} - Diamaster PRO

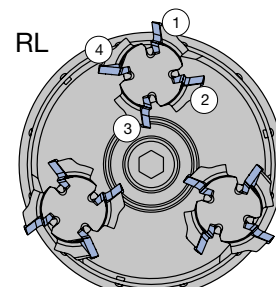
SF 540 2 10

Machine	D	D ₀	BO	Z	R	FAW	ID	ID
	mm	mm	mm		mm	°	LH	RH
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2	45°	194001 ●	194000 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	45°	194003 ●	194002 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	10°	194005 ●	194004 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3	45°	194007 ●	194006 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.5/1	45°	194009 ●	194008 ●
Holz-Her FF 701 Multi	70	61	16	3	0.8/1/1.3	45°	194011 ●	194010 ●

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



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



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



Profile cutter Multi-Edge

Application:

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

Machine:

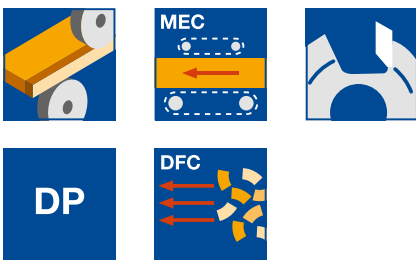
Stefani.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Diamaster PRO - Tool 1 fixed

WF 501 2 16

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

Diamaster PRO - Tool 2 movable

WF 501 2 16

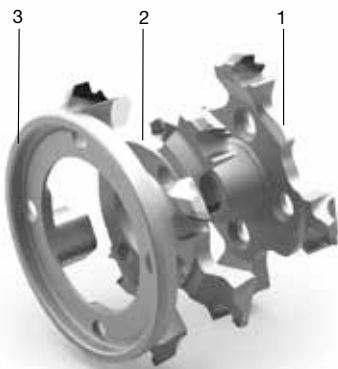
Machine	D	D_0	BO	Z	QAL	R	n_{max}	ID	ID
	mm	mm	mm			mm	min^{-1}	LH	RH
Stefani	68	61.7	23	4	DP	1.0	18000	192618 ●	192617 ●
Stefani	68	61.7	23	4	DP	1.3	18000	192620 ●	192619 ●
Stefani	68	61.7	23	4	DP	1.5	18000	192622 ●	192621 ●
Stefani	68	61.7	23	4	DP	2.0	18000	192624 ●	192623 ●
Stefani	68	61.7	23	4	DP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

Diamaster PRO - Tool 3 movable

WF 501 2 16

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

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



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



Profile cutterhead / bevel cutterhead

Application:

To round edgebandings.

Machine:

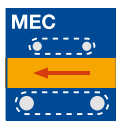
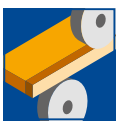
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Various radii - Brandt

WE 500 2

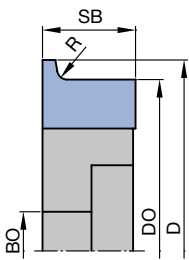
Machine	D	D ₀	SB	BO	Z	R	Type	n _{max}	ID	ID
	mm	mm	mm	mm		mm		min ⁻¹	LH	RH
Brandt	56	50	16	16 DKN	4	2	1	18000	075006	075005
Brandt	58	50	12	16 DKN	4	3	2	18000	075004	075004
Brandt	78	70	19	16 DKN	4	3	1	18000	075003	075002
Brandt	82	70	16	16 DKN	4	2	2	18000	075009	075009

Spare knives:

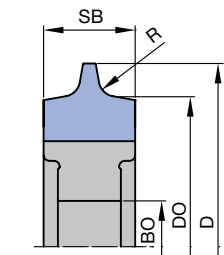
Part-no.	Type	BEZ	ABM	QAL	R	VE	ID	ID
			mm		mm	PCS	LH	RH
1	1	Exchange knife	16x13.4x2	HW	1.5	10	075325	075324
1	1	Exchange knife	16x13.4x2	HW	2.0	10	075327	075326
1	1	Exchange knife	16x13.4x2	HW	3.0	10	075329	075328
1	1	Exchange knife	19.6x15.2x2	HW	1.5	10	075334	075333
1	1	Exchange knife	19.6x15.2x2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

Spare parts:

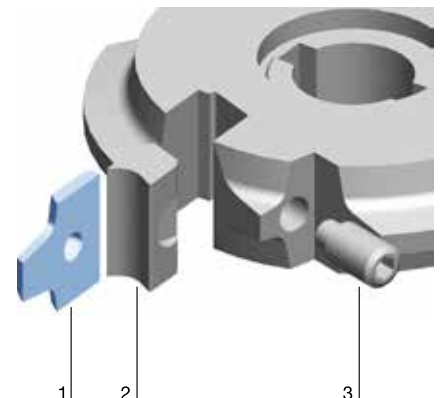
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge	10x11.5x7	075400
2	Clamping wedge	10x10.9x7	075403
2	Clamping wedge	13.5x11x7	075404
2	Clamping wedge	19	075401
2	Clamping wedge	19	075402
3	Allen screw	M6x12	006035
	Allen key	SW 3	005444
	Setting gauge for knives	1.0	005350

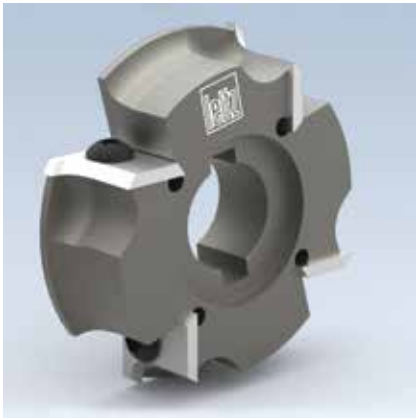


Type 1



Type 2





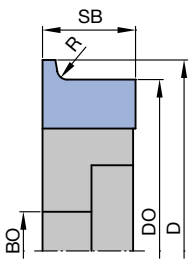
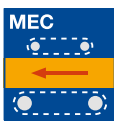
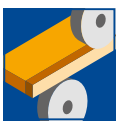
Profile cutterhead / bevel cutterhead

Application:
To round edgebandings.

Machine:
Single or double-sided edgebanding machines.

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

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



Type 1

Various radii - Hebrock/EBM

WE 500 2

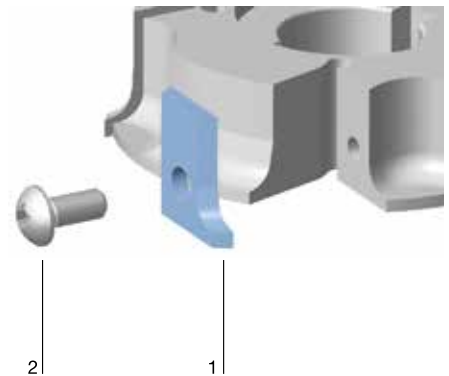
Machine	D	D_0	SB	BO	Z	R	Type	n_{max}	ID	ID
	mm	mm	mm	mm		mm		min^{-1}	LH	RH
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.0	1	18000	074559	074560
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.5	1	18000	074557	074558

Spare knives:

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

Spare parts:

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





Profile cutterhead / bevel cutterhead

Application:

To round and bevel edgebandings.

Machine:

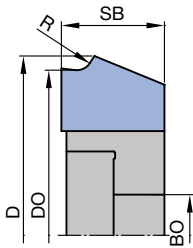
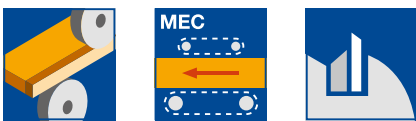
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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



Various profiles - DFC, Brandt

WE 500 2

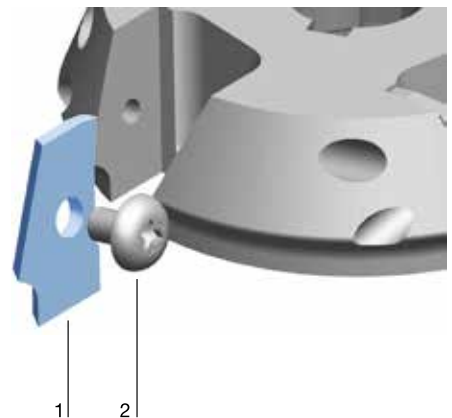
Machine	D	SB	BO	Z	R	FAW	Type	n_{max}	ID	ID
	mm	mm	mm		mm	°		min^{-1}	LH	RH
Brandt	70.23	20.28	16 DKN	4		15°	1	12000	075012	075013
Brandt	70.23	20.28	16 DKN	4		30°	1	12000	075014	075015
Brandt	69.98	20.28	16 DKN	4		45°	1	12000	075016	075017
Brandt	70.57	20.28	16 DKN	4	1.0		1	12000	075018	075019
Brandt	70.57	20.28	16 DKN	4	1.2		1	12000	075020	075021
Brandt	70.57	20.28	16 DKN	4	1.3		1	12000	075072	075073
Brandt	70.57	20.28	16 DKN	4	1.5		1	12000	075022	075023
Brandt	70.57	20.28	16 DKN	4	2.0		1	12000	075024	075025
Brandt	70.57	20.28	16 DKN	4	2.5		1	12000	075026	075027
Brandt	70.57	20.28	16 DKN	4	3.0		1	12000	075028	075029

Spare knives:

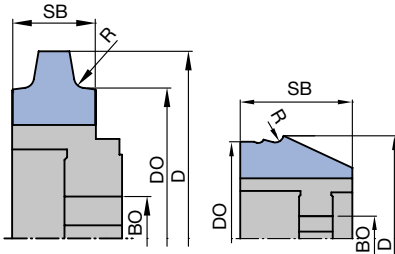
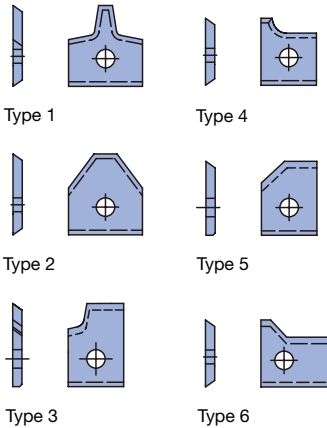
Part-no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	22.3x14x2	HW	1.0	10	10	075315	075314
1	1	Exchange knife	22.3x14x2	HW	1.2	10	10	075317	075316
1	1	Exchange knife	22.3x14x2	HW	1.3	10	10	075272	075271
1	1	Exchange knife	22.3x14x2	HW	1.5	10	10	075319	075318
1	1	Exchange knife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

Spare parts:

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

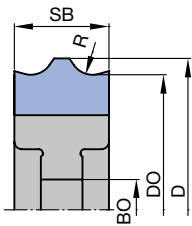


Profile cutterhead / bevel cutterhead

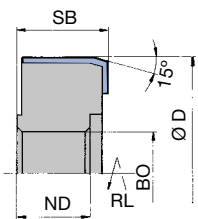


Type 1

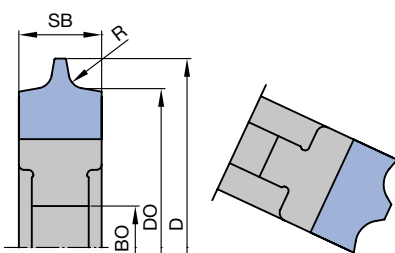
Type 2



Type 3



Type 4: WW 500 2 03



Type 1

Type 2

Profile knives for edge finishing

TM 135 0

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

Profile knives for system Biesse

TM 135 0

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

Profile knives for system Holz-Her

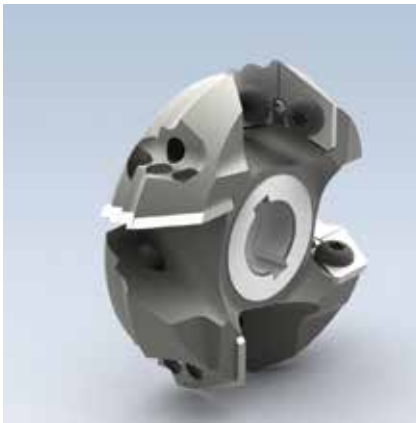
TM 435 0

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

Profile knives for system Ott

TM 135 0

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



Multi-profile cutterhead / bevel cutterhead

Application:

For a choice of radii or bevels on edgebandings.

Machine:

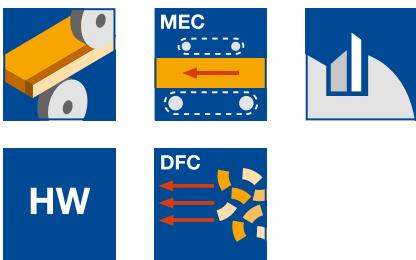
Single or double-sided edgebanding machines.

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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

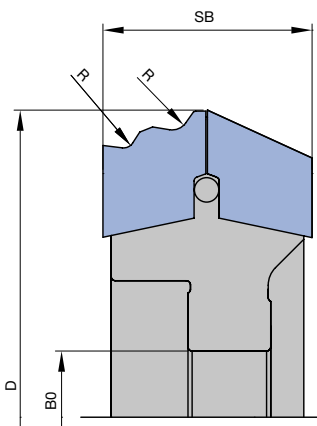


Various profiles - DFC, Brandt

WE 500 2

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

Further radii combinations available at short notice.



Type 1

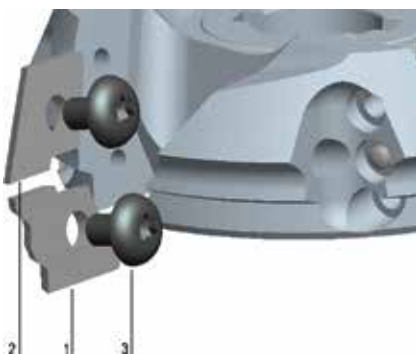
Spare knives:

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

Further radii combinations available at short notice.

Spare parts:

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





Profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

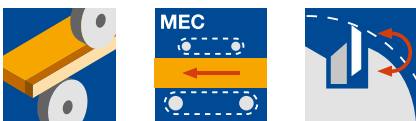
Plastic edgebandings.

Technical information:

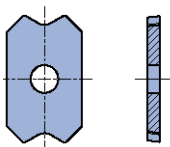
Bevel and radius scraper turnblade knives for scraper holder.

Turnblade knives - scrapers

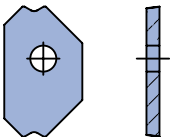
TM 435 0



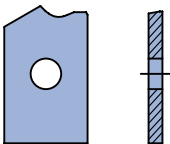
Machine	R mm	FAW °	ABM mm	Type	QAL	BEM	VE PCS	ID
Holz-Her, Homag, IMA		45°	12x20x2	1	HW		10	074037 ●
Holz-Her, Homag	1.0		12x20x2	1	HW	Profile relief 6°	10	074039 ●
Holz-Her, Homag	1.5		12x20x2	1	HW	Profile relief 6°	10	074074 ●
Holz-Her, Homag	2.0		12x20x2	1	HW	Profile relief 6°	10	074040 ●
Holz-Her,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



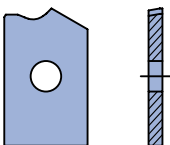
Turnblade scraper Type 1



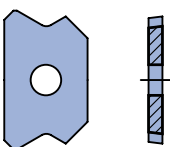
Turnblade scraper Type 2



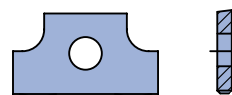
Turnblade scraper Type 3



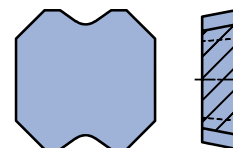
Turnblade scraper Type 4



Turnblade scraper Type 5



Turnblade scraper Type 6

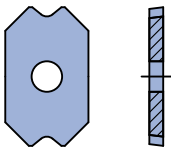


Turnblade scraper Type 7

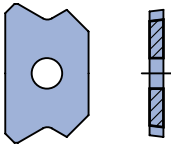
Additional scrapers available on request at short notice.

2. Panel processing

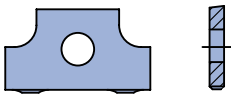
2.1 Edge processing 2.1.7 Edge finishing tools



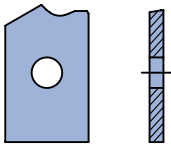
Type 1



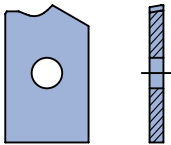
Type 2



Type 3



Type 4



Type 5

Technical information:

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

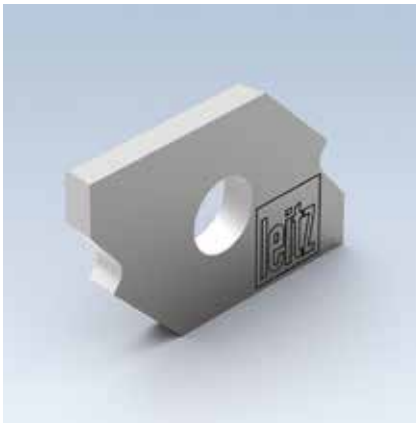
Radii scrapers with anti-stress-whitening bevel

TM 435 0

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

Spare parts:

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



Profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

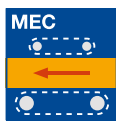
Plastic edgebandings.

Technical information:

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

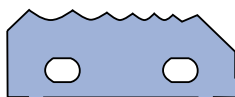
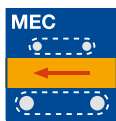
Profile scrapers - Holz-Her, aggregate ZK701

TM 435 0



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

Additional scrapers available on request at short notice.



Multi-profile scraper

Profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

Plastic edgebandings.

Technical information:

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

Multi-profile scrapers

TM 135 0

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

Spare parts:

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

Technical information:

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

Multi-profile scraper with anti-stress-whitening bevel

TM 135 0

Machine	BEM	QAL	ID	
			LH	RH
Homag	R 1/1,5/2/2,5/3/20°	HW	073104 ●	073105 ●

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

Spare parts:

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



Profile scrapers

Application:

For scraping edgebandings with radii or bevels.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

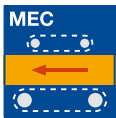
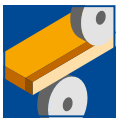
Plastic edgebandings.

Technical information:

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

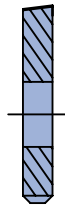
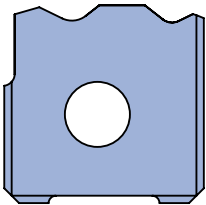
Multi-profile scraper - Brandt

TM 135 0



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

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



Spare parts:

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

Multi-profile scraper



Profile scrapers

Application:

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

Machine:

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

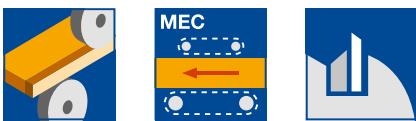
Workpiece material:

Plastic edgebandings as PP, ABS, PMMA, etc.

Technical information:

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

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

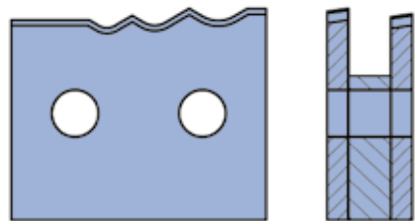


Duo multi-profile scraper

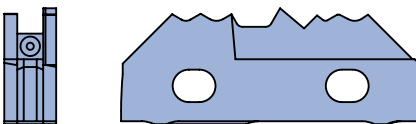
TM 135 0, TM 435 0

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

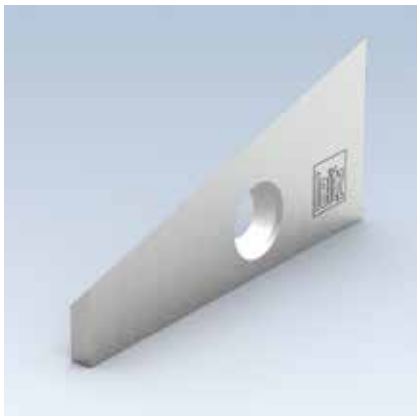
Further radii combinations available at short notice.



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



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



Flat scrapers

Application:

For scraping edgebandings and glue.

Machine:

Single or double-sided edgebanding machines.

Workpiece material:

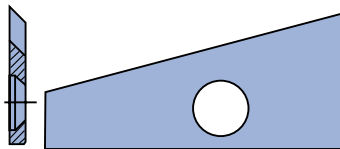
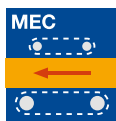
Plastic edgebandings.

Technical information:

Different profile flat scrapers.

Flat scraper knives

TC 105 0, TM 135 0, TM 440 0



Flat scraper

Machine	ABM mm	QAL	FAW °	ID LH	ID RH
Biesse	16x16x4.7	HW			074556 ●
Biesse	22.9x22.9x2.5	HW			074555 ●
Brandt, Ott	15x14.3x2.5	HW	6°	074500 ●	074501 ●
Fravol	20x12x1.5	HW			074638 ●
Hebrock/EBM	36x30x3	HW		074634	074635
Holz-Her	HW:14x14x2	HW			009546 ●
Homag	32x55x4.5	HW	15°	074047 ●	074048 ●
IMA	14.3x14.3x2.5	HW			074305 ●
IMA	55x25x3	HW	15°	074023 ●	074024 ●
IMA BAZ	11x14.3x2.5	HW			074306 ●

Spare parts:

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



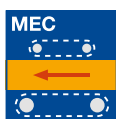
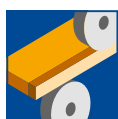
Profile cutterhead / bevel cutterhead for stationary machines

Application:
To round/bevel edgebandings.

Machine:
Homag BAZ.

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

Technical information:
Cutterheads with HW knives for edge trimming cutter aggregate. The same cutterhead tool body suitable for R 1.0 to 3.0 mm. D₀ = constant reference diameter.



Various radii / bevels - Homag
WE 500 2

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

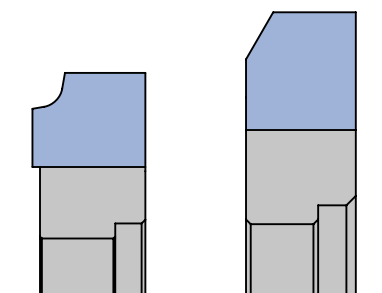
Type 3 for special thin edgebandings.

Spare knives:

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

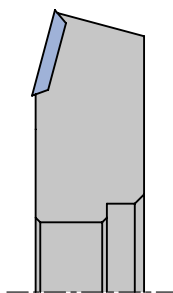
Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge RH	11.5x14.4x7	073400
2	Clamping wedge LH	11.5x14.4x7	073401
3	Allen screw	M6x12	006035
3	Countersink screw, Torx® 20	M6x0.5x4.9	006243
	Allen key	SW 3	005444
	Torx® key	Torx® 20	006091
	Setting gauge for knives	1.0	005350

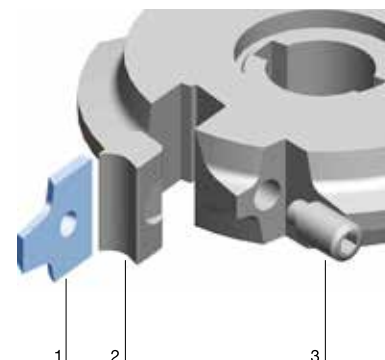


Type 1

Type 2



Type 3





Profile cutter / bevel cutter for stationary machines.

Application:

To round/bevel edgebandings.

Machine:

Homag BAZ.

Workpiece material:

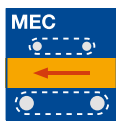
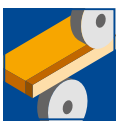
Plastic, softwood, hardwood and veneer edgebander.

Technical information:

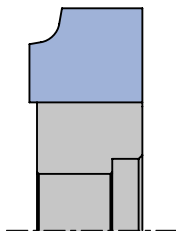
DP tipped tool with cylindrical bore. D_0 = constant reference diameter.

Radii cutter DP - Homag

WF 501 2 DP



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



Type 1



Profile cutter / bevel cutter for stationary machines.

Application:

To round/bevel edgebandings.

Machine:

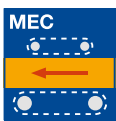
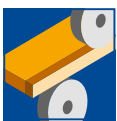
IMA (BIMA).

Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

Technical information:

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

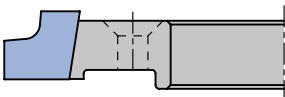
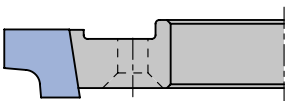
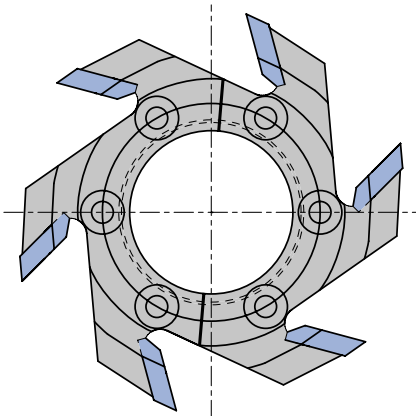


Various radii / bevels - IMA

WF 501 2

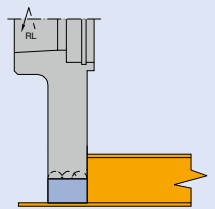
D	D ₀	SB	BO	Z	QAL	R	FAW	Type	n _{max}	ID	ID
mm	mm	mm	mm			mm	°		min ⁻¹	LH	RH
64.4	55	10.2	30	6	HW	1.5		1	18000	074062 <input type="checkbox"/>	074063 <input type="checkbox"/>
64.4	55	10.2	30	6	HW	2.0		1	18000	074064 <input type="checkbox"/>	074065 <input type="checkbox"/>
64.4	55	10.2	30	6	HW	3.0		1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

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



Rebating
Rebating cutter, page 67

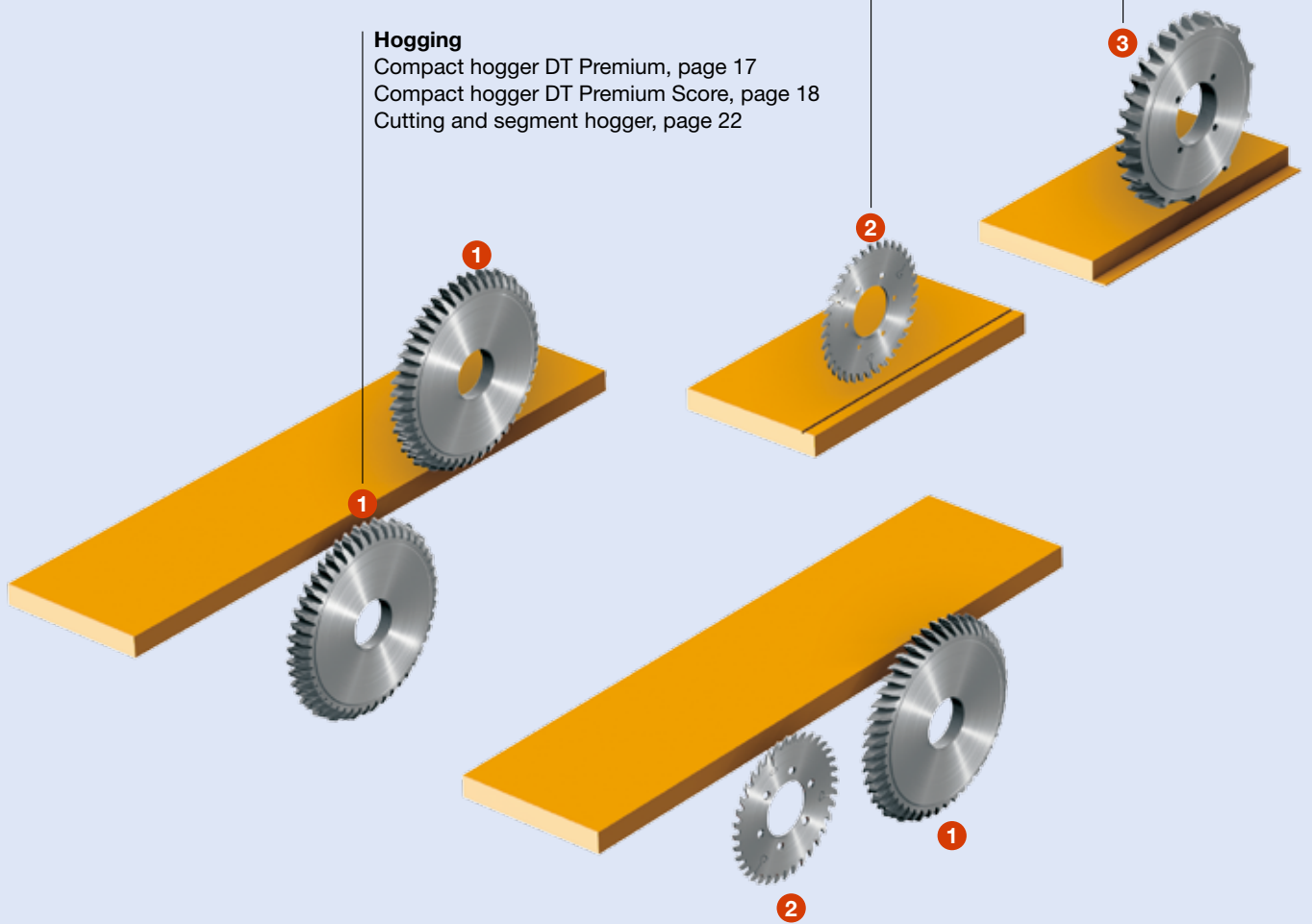
Milling off the wooden composite board to uncover the cover layer, application mostly with feed.

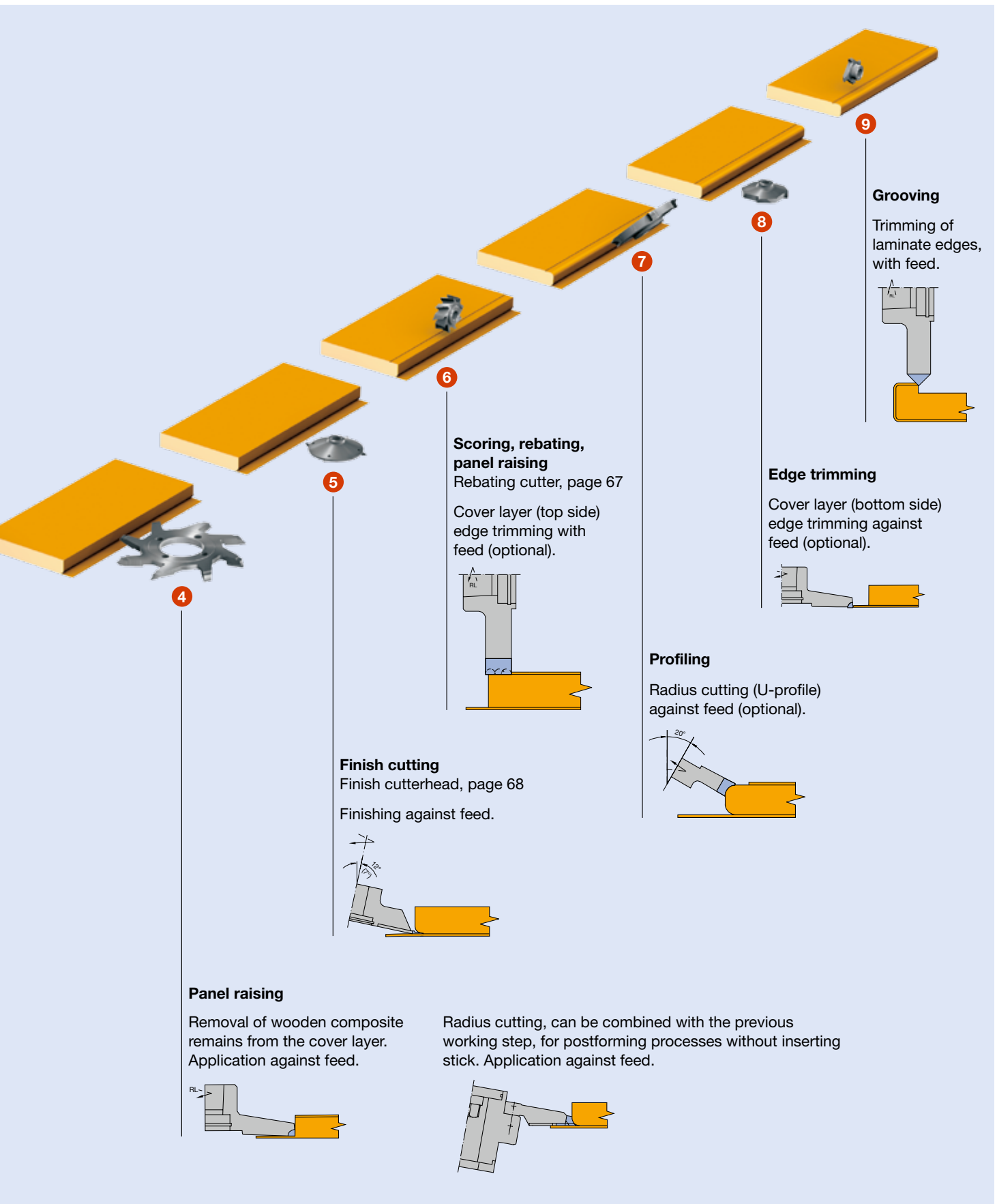


Scoring

Hogging

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





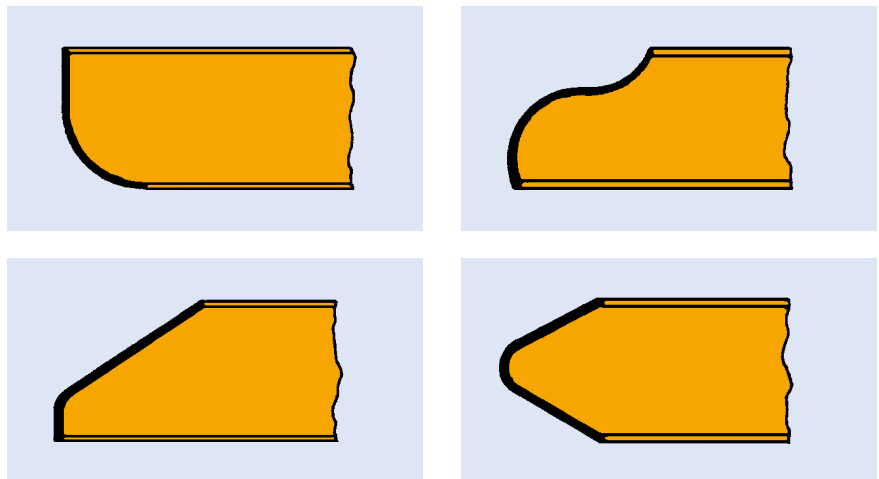
2. Panel processing

2.2 Postforming processing

2.2.2 Postforming tools

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

Profile examples



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



Rebating cutter

Application:

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

Machine:

Postforming machines.

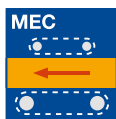
Workpiece material:

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

Technical information:

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

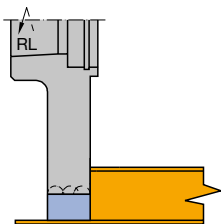
DP tools - 2.0 mm resharpening area.



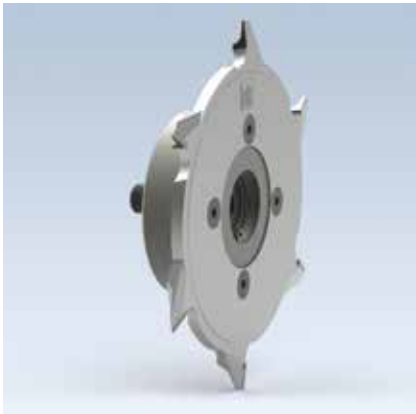
Diamaster PRO

WF 499 2

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



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



Finishing cutterhead

Application:

For finish cutting of radii on postforming profiles.

Machine:

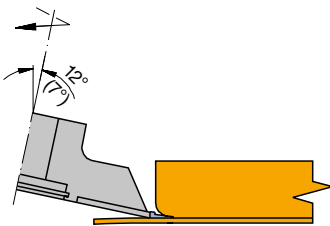
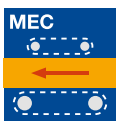
Postforming units.

Workpiece material:

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

Technical information:

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



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

7° inclined spindle

WF 556 2

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

Technical information:

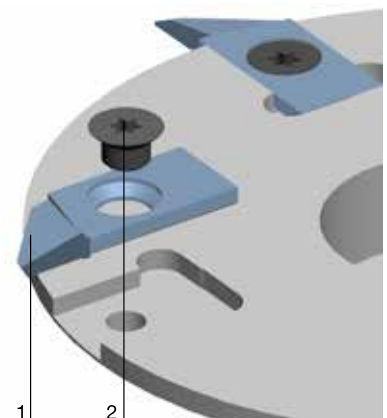
Spare knives for cutterhead with DP profile knives and cylindrical bore or HSK 25 R adaptor. Suitable for finish cutting radii up to R 14. Non-resharpenable knives 0.5 mm optimised for sensitive coatings, veneer postforming and maximum contour accuracy.

Spare knives for finishing cutterheads

TM 160 0

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

Spare knives for 7° and 12° inclined spindles.



2. Panel processing

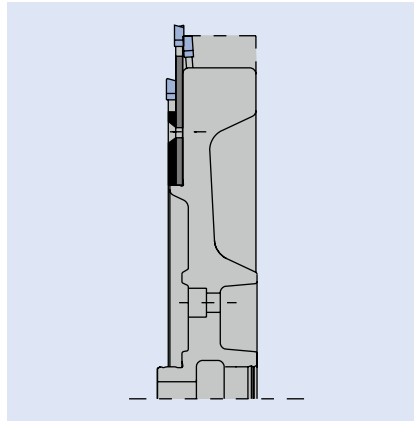
2.3 Panel processing

2.3.1 Segment hoggers for sizing

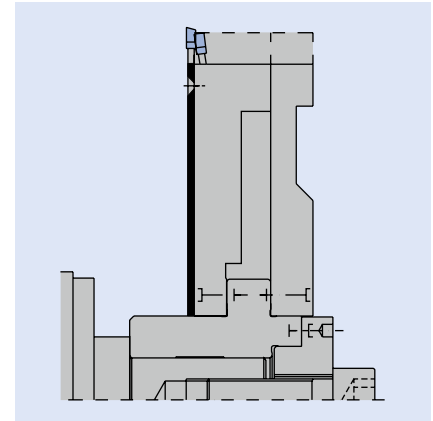
Segment hogger

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

Designs



Toolset for finish-production unit with sizing and finish cut



Toolset for sizing unit mounted on flanged sleeve



Segment hogger for sizing unit

Application:

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

Machine:

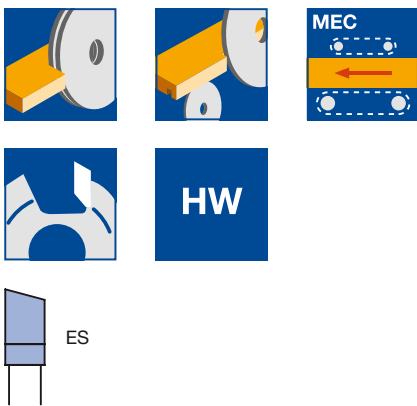
Sizing station in production lines.

Workpiece material:

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

Technical information:

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



Hogger for sizing unit

SZ 300 2, SZ 301 2

Machine	D	SB	BO	Z/ZF _{Sawblade}	QAL	ID	ID
	mm	mm	mm			LH	RH
Siempelkamp	305	60.1	30	60/ES	HW	064700 □	064701 □
Siempelkamp	355	60.5	40 DKN	72/ES	HW	064702	064703

Spare parts:

Part-no.	BEZ	ABM	BEM	ID
		mm		
1	Countersink screw, Torx® 20	M6x12	Torx® 20	006084 ●
2	Screw with ISK	M8x17	for D = 250/350/305/355	006237 ●
3	Cylindrical screw with ISK	M8x60	for D = 305	005878 ●
3	Cylindrical screw with ISK	M8x35	for D = 305/350	005874 ●
3	Cylindrical screw with ISK	M8x25	for D = 355	005947 ●

Hogging sawblade

WK 801 2

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

Technical information:

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

Basic hogger

WZ 300 2

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

Extension hogger

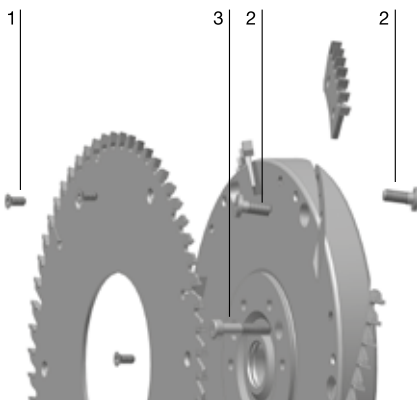
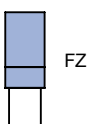
WZ 300 2

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

Segments (6 per hogger)

TM 170 0

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





Segment hogger for splitting unit

Application:

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

Machine:

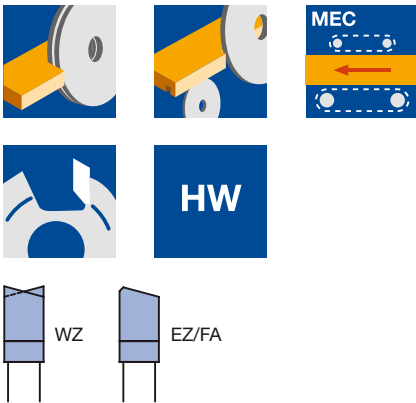
Sizing station in production lines.

Workpiece material:

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

Technical information:

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



Hogger for splitting unit

SZ 300 2

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

Spare parts:

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

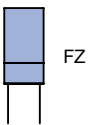
Technical information:

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

Hogging sawblade

WK 802 2, WK 850 2

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



Basic hogger with segments

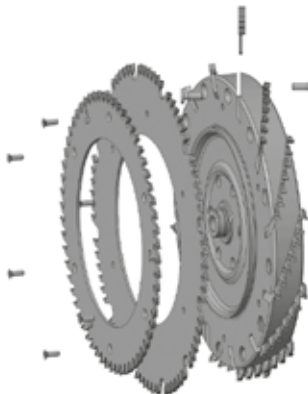
WZ 300 2

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

Segments (12 per hogger)

TM 170 0

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

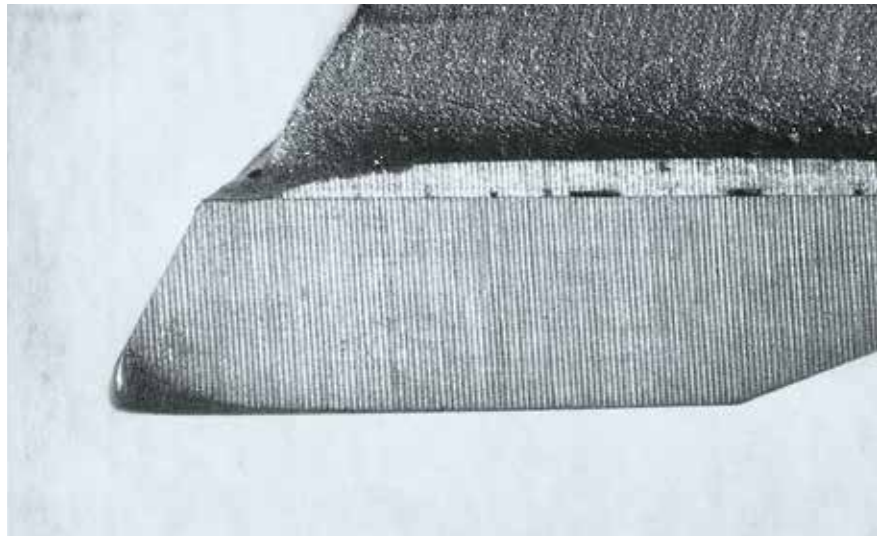


Problem	Possible cause	Action
Break outs at the edge of the workpiece top edge	- Incorrect height adjustment of hogging motor and tilt in feed direction	Correct setting Check position of tools in feed direction, adjust standard value of 0.1 mm to the panel edge
	- Too much axial play in spindle bearing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

Rounding of the cutting edge

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

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



Typical cutting edge wear when machining solid wood.

Cutting edge destruction through improper use

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

Action:

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



Cutting edge destruction through improper use.

Cutting edge destruction through overstress

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

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



Destruction of saw tooth through overstress.

2. Panel processing

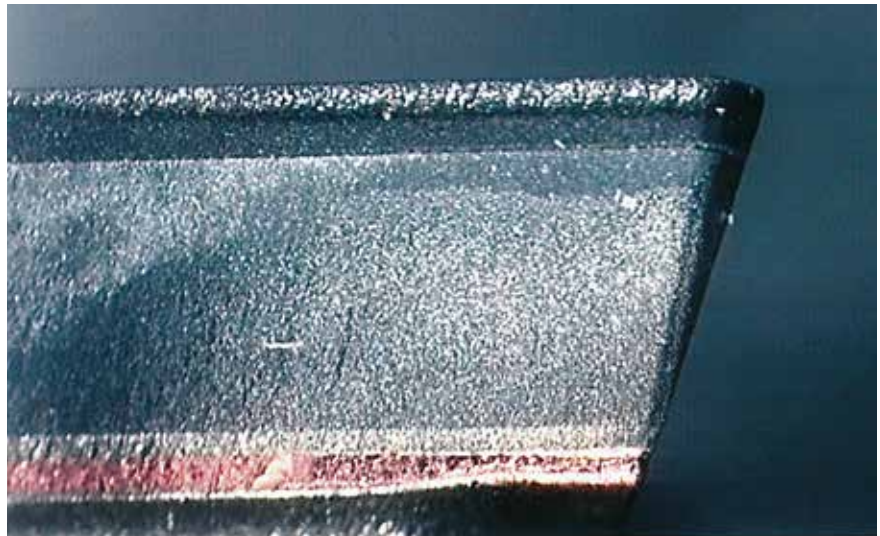
Signs of wear on the DP cutting edges

Rounding of cutting edges

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

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

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

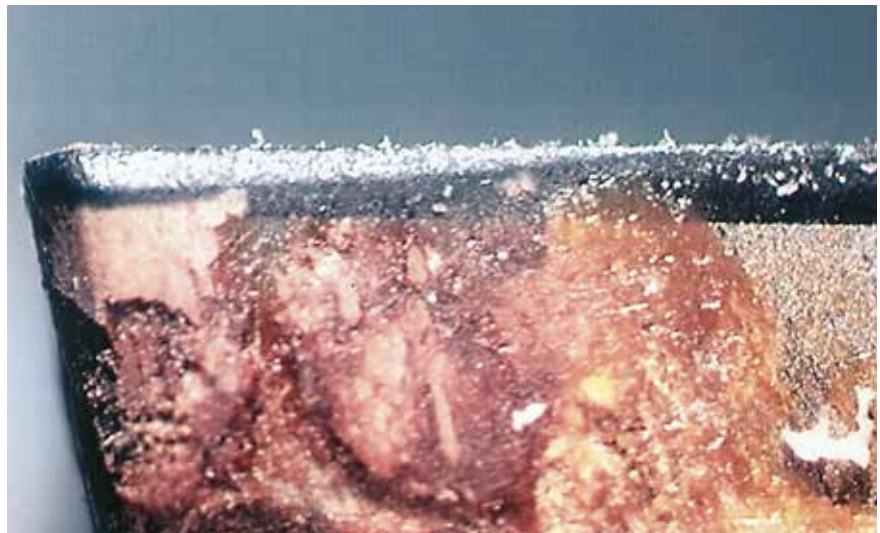


Wear to cutting edges after machining MDF.

Cutting edge rounding and resin build up

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

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

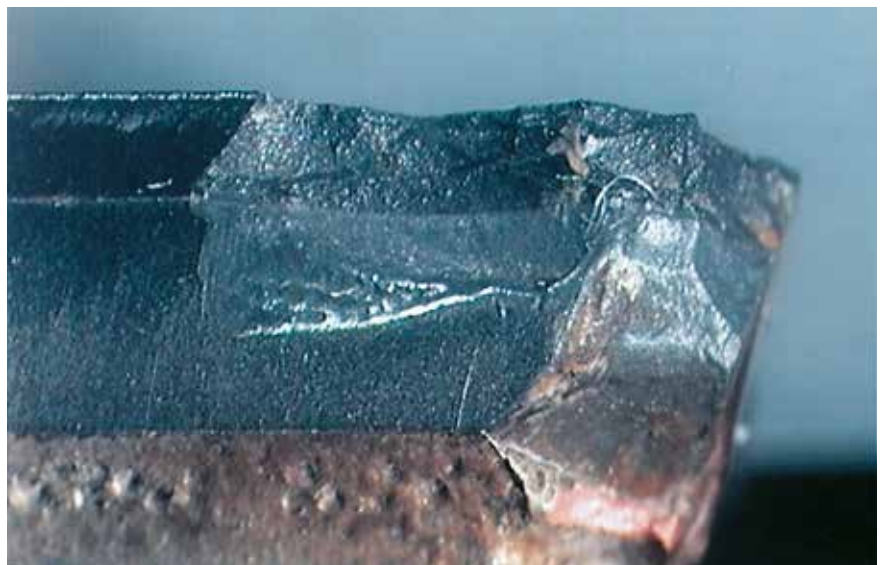


Wear to cutting edges and resin build-up after machining chipboard.

Cutting edge destruction

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

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



Cutting edge destruction from metallic particles.

Enquiry/order form special tools – panel processing

Customer details: Customer number:

(if known)

Enquiry
 Order

Delivery date: (not binding) CW

Company: _____

Street: _____

Post code/place: _____

Country: _____

Phone/fax: _____

Contact person: _____

Signature: _____

Date: _____

Enquiry/order no.: _____

Tool ID: (if known) _____

No. of pieces: _____

Workpiece material:

Type: _____

Moisture content (of solid wood) _____ %

Direction of machining

along grain across grain

Cutting quality: _____

Pre-hogging

Coating: Yes No

Type (of wood derived material): _____

Hogging width: _____ mm

Material thickness: _____ mm

Finish hogging

Machine:

Manufacturer: _____

Type: _____

Model: _____

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

RPM: _____ min⁻¹

Feed: _____ m min⁻¹

Hogging motor:

Against feed

With feed

Application scoring/hogging

Application hogging/hogging

Tool:

Tool type (see selection):

Hogging set in cutter design

Hogging set with segments

Compact hogging set

Other

Dimensions:

Diameter _____ mm

Cutting width _____ mm

Bore _____ mm

Adaptor:

Mechanical

Quick change

Hydraulic

No. of teeth:

Hogging sawblade _____

Hogger _____

Cutting material:

HW (TC)

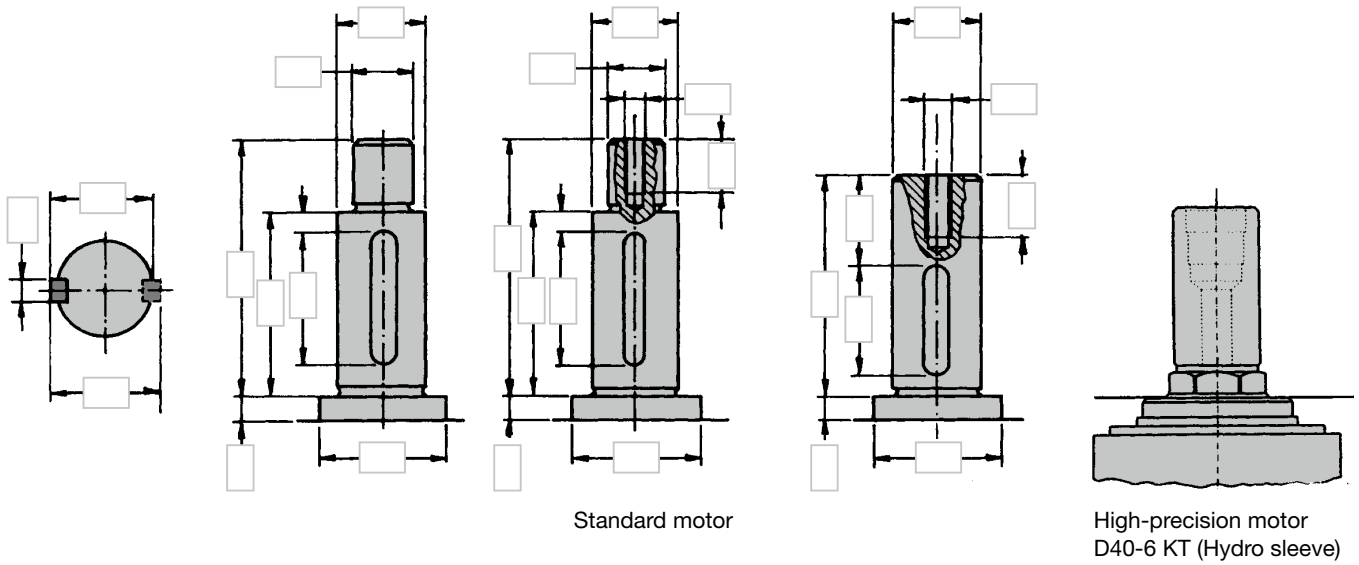
DP (DIA)

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

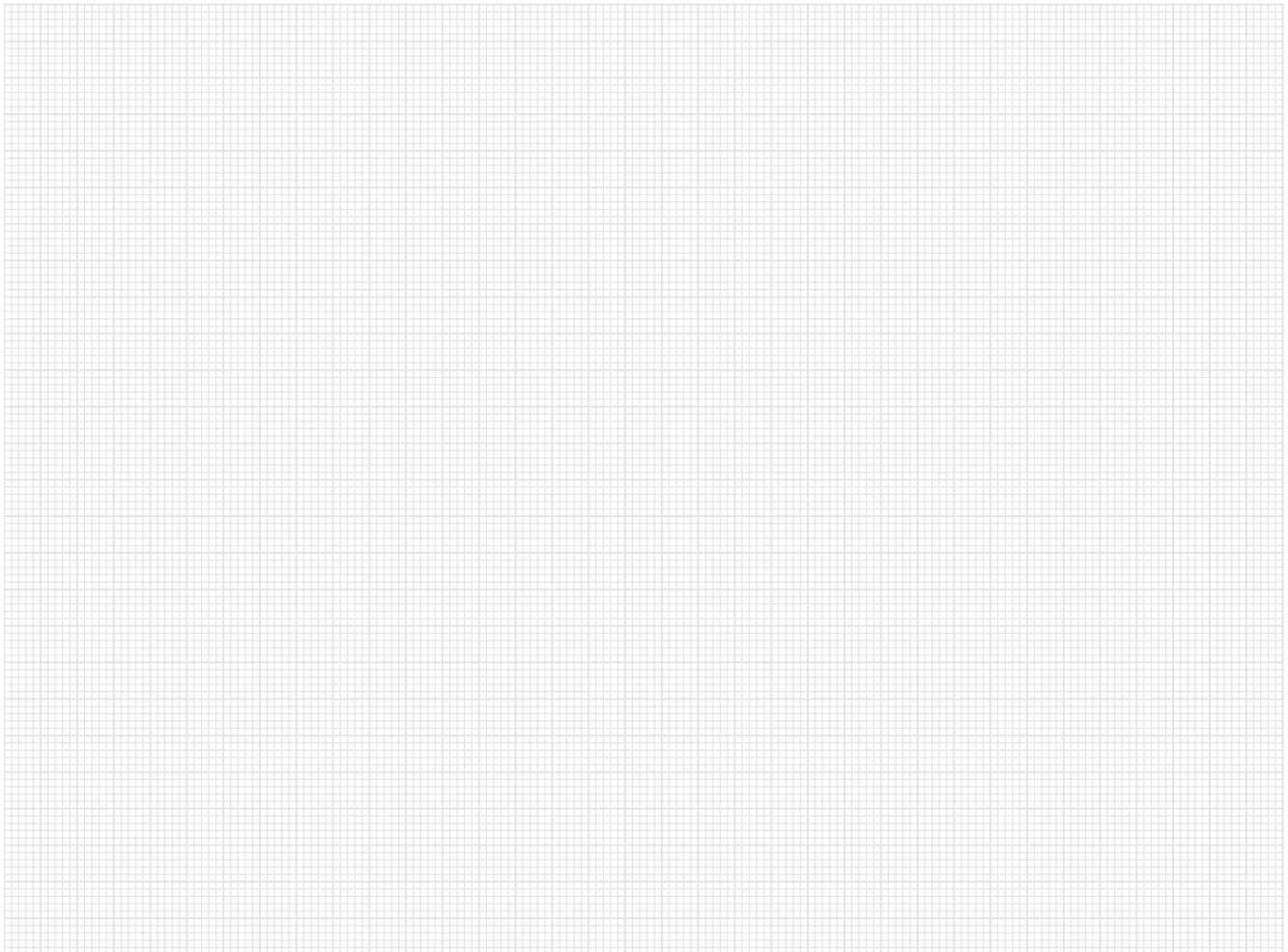
Enquiry/order form special tools – panel processing

Hogging motor/spindle details:

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



Sketch for application plan, motor spindle etc.



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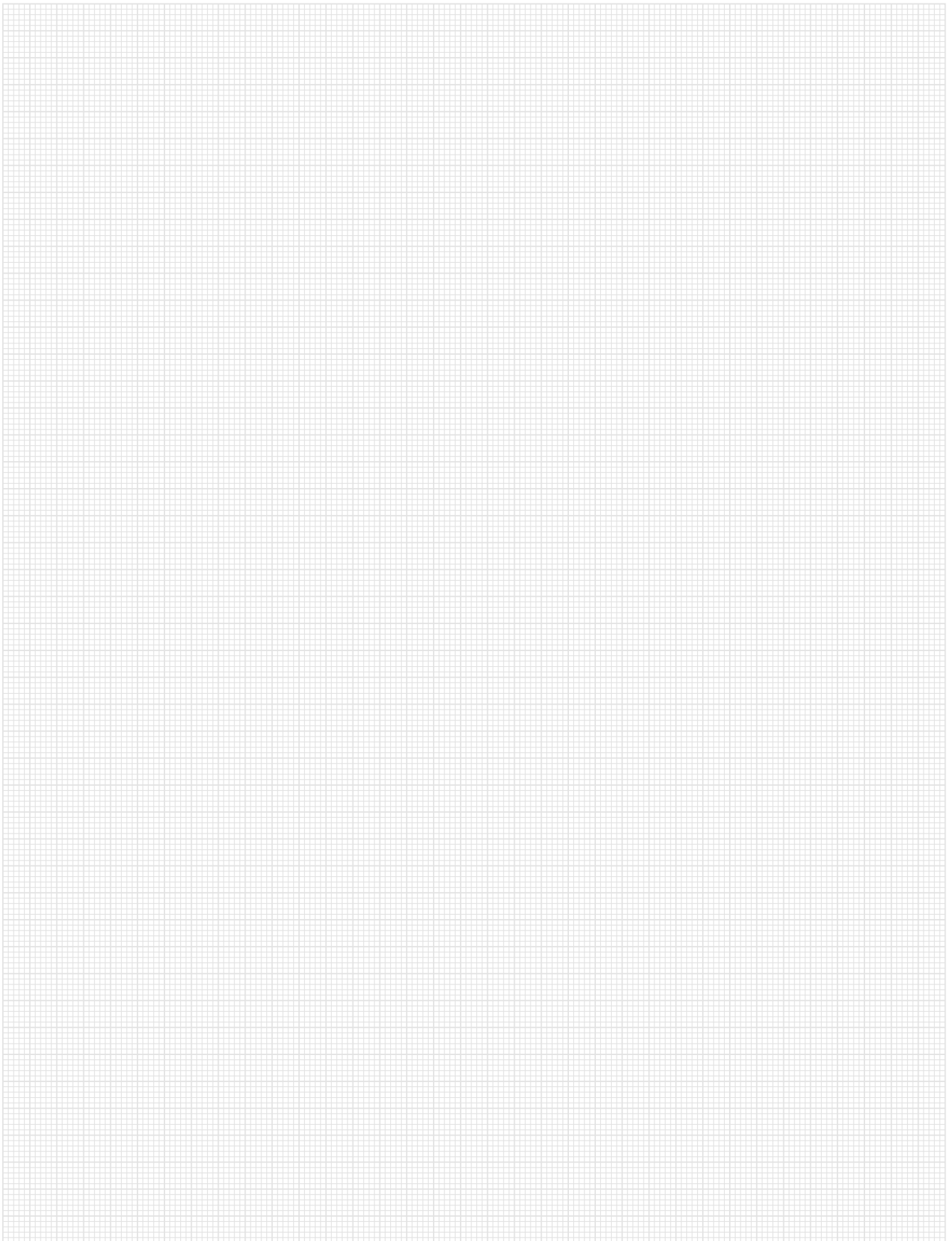
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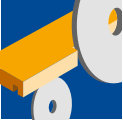











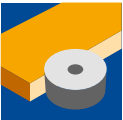

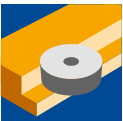





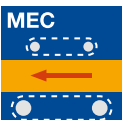
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075040	□ 53	091507	□ 38	091976	34	166448	● 28	190392	□ 17	190453	18
075041	□ 53	091508	□ 38	091977	34	166449	● 29	190393	□ 17	190454	18
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075359	● 58	091677	38	166403	● 28	166468	● 29	190412	□ 17	192059	14
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075378	● 58	091798	39	166414	● 29	190360	● 19	190421	□ 17	192082	● 8
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090887	● 7-8	091961	● 36	166431	● 28	190377	19	190438	18	192103	● 31
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Key to pictograms

	Scoring hogging		Tipped tool
	Hogging		Light alloy body
	Double hogging		Interchangeable knives
	End trimming		Mechanical knife clamping, reversible
	Edge trimming		Resharpenable cutting face
	Grooving, horizontal and vertical		Resharpenable clearance face
	Jointing		Low noise
	Rebating		DFC Optimised chip flow
	Profiling		HW Tungsten carbide
	Profiling joints		DP Polycrystalline diamond (PCD)
	MEC Mechanical feed		

