

# Manual feed

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   | $\text{min}^{-1}$   | = revolutions per minute (RPM)                |
| AL                  | = working length  | MK                  | = morse taper                                 |
| AM                  | = number of knives  | $\text{m min}^{-1}$ | = metres per minute                           |
| AS                  | = anti sound (low noise design)                               | $\text{m s}^{-1}$   | = metres per second                           |
| b                   | = overhang  | n                   | = RPM   |
| B                   | = width   | $n_{\text{max}}$    | = maximum permissible RPM                     |
| BDD                 | = thickness of shoulder                                       | NAL                 | = position of hub                             |
| BEM                 | = note  | ND                  | = thickness of hub                            |
| BEZ                 | = description   | NH                  | = zero height                                 |
| BH                  | = tipping height  | NL                  | = cutting length                              |
| BO                  | = bore diameter   | NLA                 | = pinhole dimensions                          |
| CNC                 | = Computerized Numerical Control                              | NT                  | = grooving depth                              |
| d                   | = diameter  | P                   | = profile                                     |
| D                   | = cutting circle diameter                                     | POS                 | = cutter position                             |
| D0                  | = zero diameter   | PT                  | = profile depth                               |
| DA                  | = outside Diameter  | PG                  | = profile group                               |
| DB                  | = diameter of shoulder  | QAL                 | = cutting material quality                    |
| DFC                 | = Dust Flow Control (optimised chip clearance)                | R                   | = radius                                      |
| DGL                 | = number of links   | RD                  | = right hand twist                            |
| DIK                 | = thickness   | RH                  | = right hand rotation                         |
| DKN                 | = double keyway   | RP                  | = radius of cutter                            |
| DP                  | = polycrystalline diamond                                     | S                   | = shank dimension                             |
| DRI                 | = rotation  | SB                  | = cutting width                               |
| FAB                 | = width of rebate   | SET                 | = set   |
| FAT                 | = depth of rebate   | SLB                 | = slotting width                              |
| FAW                 | = bevel angle   | SLL                 | = slotting length                             |
| FLD                 | = flange diameter   | SLT                 | = slotting depth                              |
| $f_z$               | = tooth feed  | SP                  | = tool steel                                  |
| $f_{z \text{ eff}}$ | = effective tooth feed  | ST                  | = Cobalt-basis cast alloys,<br>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<br>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.

## 4. Manual feed



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## 4. Manual feed

### 4.1 Grooving

|                           |   |
|---------------------------|---|
| <b>Application</b>        | To produce different groove widths, manual or mechanical feed, along or across the grain.   |
| <b>Workpiece material</b> | Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.                               |
| <b>Machines</b>           | Portable machines, spindle moulders, moulders, double-end tenoners, machining centres, edgebanding machines etc.  |
| <b>Type of feed</b>       | Manual feed:<br>Application only against feed.<br><br>Mechanical feed:<br>Application with or against feed,<br>for minimum tear out, use with feed necessary. |

#### Tool design



Tipped tools:  
With HW or DP. DP tips suitable for abrasive materials.

Replaceable tip tools:  
Design with HW turnblade cutters for constant diameter and constant cutting widths.

Two and multiple part tools:  
Designed so the cutting width can be adjusted either by spacers (adjustment steps of 0.10 mm) or by a continuously adjustable sleeve for HW or DP tipped tools.

Single tools:  
Suitable for use as set.

Optimised gullet design DFC:  
The DFC concept directs the chips away from the workpiece, so leaving the tool cutting area unhindered. DFC increases tool performance.

Benefits:  
– Better product quality by eliminating chip marks or damage to the workpiece edges.  
– Reduced tool cutting edge wear by eliminating multiple cutting.

#### Recommended value for tooth feed rate $f_z$ (in mm)

|                                     |                |
|-------------------------------------|----------------|
| <b>Solid wood</b>                   |                |
| Along                               | 0.60 – 0.80 mm |
| Across                              | 0.30 – 0.40 mm |
| <b>Glulam</b>                       | 0.40 – 0.50 mm |
| <b>Chipboard and fibre material</b> |                |
| Without coating                     | 0.50 – 0.70 mm |
| Coated                              | 0.20 – 0.40 mm |
| Veneered                            | 0.10 – 0.15 mm |
| <b>Wood derived materials</b>       |                |
| Middle layer                        | 0.30 – 0.60 mm |
| Top layer                           | 0.08 – 0.12 mm |
| Plastic                             | 0.20 – 0.50 mm |
| Polymer compound                    | 0.05 – 0.05 mm |
| Non-ferrous metals                  | 0.03 – 0.05 mm |

$$v_f = f_z \cdot n \cdot Z / 1000$$

## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



### Grooving cutters for manual feed

**Application:**

For grooving with (MEC) or against feed (MAN).

**Machine:**

Spindle moulders, moulders and double-end tenoners.

**Workpiece material:**

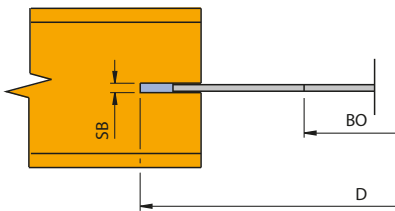
Solid wood; uncoated, coated and veneered wood derived materials.

**Technical information:**

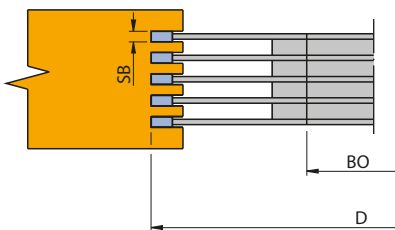
Tool body design with round, closed shape.

**Z 12**

WF 100 1 05



Scheme: Grooving in middle layer



Scheme: Set assembly for lock corner joint

| D<br>mm | SB<br>mm | TDI<br>mm | BO<br>mm | BO <sub>max</sub><br>mm | Z  | n<br>min <sup>-1</sup> | ID       |
|---------|----------|-----------|----------|-------------------------|----|------------------------|----------|
| 125     | 1.5      | 0.8       | 30       | 50                      | 12 | 6200 - 13700           | 020241 ● |
| 125     | 2.0      | 1.2       | 30       | 50                      | 12 | 6200 - 13700           | 020243 ● |
| 125     | 2.5      | 1.4       | 30       | 50                      | 12 | 6200 - 13700           | 020245 ● |
| 125     | 3.0      | 2.0       | 30       | 50                      | 12 | 6200 - 13700           | 020246 ● |
| 125     | 3.5      | 2.2       | 30       | 50                      | 12 | 6200 - 13700           | 020247 ● |
| 125     | 4.0      | 2.5       | 30       | 50                      | 12 | 6200 - 13700           | 020248 ● |
| 125     | 4.5      | 3.0       | 30       | 50                      | 12 | 6200 - 13700           | 020249 ● |
| 150     | 1.5      | 0.8       | 30       | 60                      | 12 | 5200 - 11400           | 020265 ● |
| 150     | 2.0      | 1.2       | 30       | 60                      | 12 | 5200 - 11400           | 020267 ● |
| 150     | 2.5      | 1.4       | 30       | 60                      | 12 | 5200 - 11400           | 020269 ● |
| 150     | 3.0      | 2.0       | 30       | 60                      | 12 | 5200 - 11400           | 020250 ● |
| 150     | 3.5      | 2.2       | 30       | 60                      | 12 | 5200 - 11400           | 020251 ● |
| 150     | 4.0      | 2.5       | 30       | 60                      | 12 | 5200 - 11400           | 020252 ● |
| 150     | 4.5      | 3.0       | 30       | 60                      | 12 | 5200 - 11400           | 020253 ● |
| 150     | 5.0      | 3.5       | 30       | 60                      | 12 | 5200 - 11400           | 020254 ● |
| 150     | 6.0      | 4.5       | 30       | 60                      | 12 | 5200 - 11400           | 020255 ● |
| 150     | 7.0      | 5.0       | 30       | 60                      | 12 | 5200 - 11400           | 020256 ● |
| 150     | 8.0      | 6.0       | 30       | 60                      | 12 | 5200 - 11400           | 020257 ● |
| 150     | 9.0      | 7.0       | 30       | 60                      | 12 | 5200 - 11400           | 160100 ● |
| 150     | 10.0     | 8.0       | 30       | 60                      | 12 | 5200 - 11400           | 160101 ● |
| 180     | 4.0      | 2.5       | 30       | 70                      | 12 | 4300 - 9500            | 020260 ● |
| 180     | 5.0      | 3.5       | 30       | 70                      | 12 | 4300 - 9500            | 020261 ● |
| 180     | 6.0      | 4.5       | 30       | 70                      | 12 | 4300 - 9500            | 020262 ● |
| 180     | 8.0      | 6.0       | 30       | 70                      | 12 | 4300 - 9500            | 020263 ● |
| 180     | 10.0     | 8.0       | 30       | 70                      | 12 | 4300 - 9500            | 160102 ● |

Groove cutter for MEC, see section Panel Processing.

For spacers TR 100 0 used as a set, see section Knives and Spare Parts.

## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



#### Grooving cutter - lamello joints

**Application:**

For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints (e.g. picture frames, furniture doors).

**Machine:**

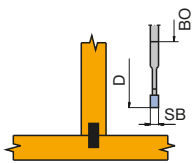
Portable power tools - grooving cutters (e.g. Lamello etc.).

**Workpiece material:**

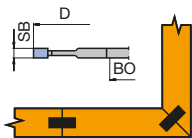
Solid wood; uncoated, coated and veneered wood derived materials.

**Technical information:**

Tool body design with round, closed shape.



Lamello - T-joint



Lamello - Longitudinal/corner joint

**HW tipped**

WF 102 1 01

| D   | SB  | BO | NLA      | Z | V | QAL | n                 | ID              |
|-----|-----|----|----------|---|---|-----|-------------------|-----------------|
| mm  | mm  | mm | mm       |   |   |     | min <sup>-1</sup> |                 |
| 100 | 4.0 | 22 | 4/4.5/36 | 2 | 4 | HW  | 7800 - 13300      | <b>020124 ●</b> |

**DP tipped**

WF 100 1 DP

| D   | SB | BO | NLA      | Z | QAL | n                 | ID              |
|-----|----|----|----------|---|-----|-------------------|-----------------|
| mm  | mm | mm | mm       |   |     | min <sup>-1</sup> |                 |
| 100 | 4  | 22 | 4/4.5/36 | 4 | DP  | 7800 - 13300      | <b>090017 ●</b> |

**Grooving cutterhead**

WW 102 1 01

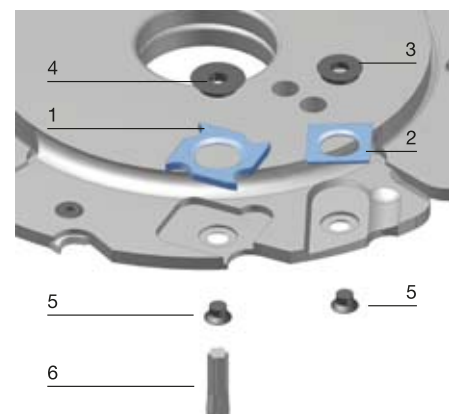
| D   | SB | BO | NLA      | Z   | V   | QAL | n                 | ID              |
|-----|----|----|----------|-----|-----|-----|-------------------|-----------------|
| mm  | mm | mm | mm       |     |     |     | min <sup>-1</sup> |                 |
| 100 | 4  | 22 | 4/4.5/36 | 2/2 | 2/2 | HW  | 7800 - 13300      | <b>020131 ●</b> |

**Spare knives:**

| Part-no. | BEZ                | QAL | VE  | ID              |
|----------|--------------------|-----|-----|-----------------|
|          |                    |     | PCS |                 |
| 1        | Turnblade knife    | HW  | 10  | <b>005114 ●</b> |
| 2        | Turnblade spur VS4 | HW  | 10  | <b>005130 ●</b> |

**Spare parts:**

| Part-no. | BEZ                        | ABM        | ID              |
|----------|----------------------------|------------|-----------------|
|          |                            | mm         |                 |
| 3        | Special nut for VS         | M9.9/1.60  | <b>005654 ●</b> |
| 4        | Special nut for WPL        | M11.9/2.20 | <b>005653 ●</b> |
| 5        | Countersink screw, Torx® 9 | M4x0.5x3.2 | <b>006057 ●</b> |
| 6        | Torx® key                  | Torx® 9    | <b>005463 ●</b> |



## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



### Grooving cutter Lamello® Clamex® P-System®

#### Application:

For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints.

#### Machine:

Portable power tools - grooving cutters (e.g. Lamello etc.) and for use on CNC machining centres.

#### Workpiece material:

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

#### Technical information:

Tool body design with round, closed shape.

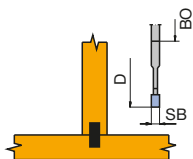


#### DP tipped for Clamex P - connector

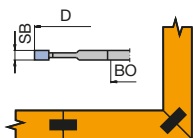
WK 100 3 DP, WK 103 2 DP

| D     | SB | BO | NLA      | Z | QAL | n                 | ZF | DRI | ID              |
|-------|----|----|----------|---|-----|-------------------|----|-----|-----------------|
| mm    | mm | mm | mm       |   |     | min <sup>-1</sup> |    |     |                 |
| 100.4 | 7  | 16 | 4/5.5/28 | 3 | DP  | 7800 - 13300      | TR | RH  | <b>192297</b> ● |
| 100.4 | 7  | 22 | 4/4.3/36 | 3 | DP  | 7800 - 13300      | TR | RH  | <b>192294</b> ● |
| 100.4 | 7  | 30 | 4/6.6/48 | 3 | DP  | 7800 - 13300      | TR | LH  | <b>192295</b> ● |
| 100.4 | 7  | 30 | 4/6.6/48 | 3 | DP  | 7800 - 13300      | TR | RH  | <b>090018</b> ● |
| 100.4 | 7  | 30 | 4/6.6/48 | 6 | DP  | 7800 - 13300      | TR | RH  | <b>192298</b> ● |
| 100.4 | 7  | 40 | 4/5.5/52 | 3 | DP  | 7800 - 13300      | TR | RH  | <b>192296</b> ● |

Suitable arbors see section Clamping Systems. Drills for access bore see section Drilling.



Lamello - T-joint



Lamello - Longitudinal/corner joint

#### Arbors with shank to mount the grooving cutter

S16x50,d30,l4,L85 ID **041429**

S25x60,d=30,l=4,L=102 ID **041367**

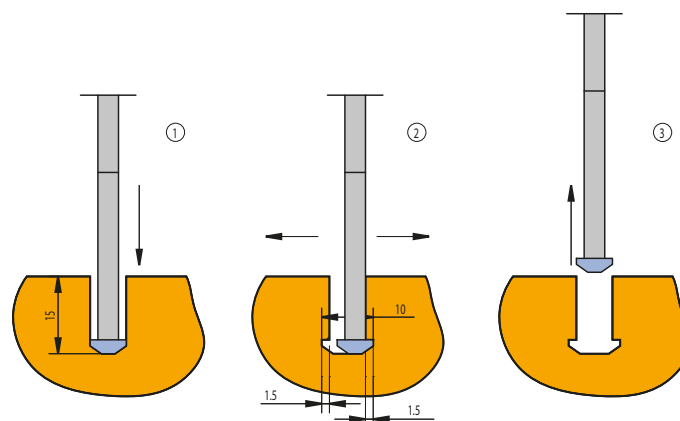
S20x50,d=30,l=4,L=102 ID **041368**

S25x60,d=30,l=4,L=127 ID **042980**

#### Drill for access bore hole

D = 6 mm ID **034116**

Shank cutter for CNC: ID **039161**



1. 15 mm plunge.
2. 1.5 mm left and right side recesses.
3. Leaving from the middle position.

## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



#### Grooving cutterset, adjustable with spacers

##### Application:

For cutting different groove widths.

##### Machine:

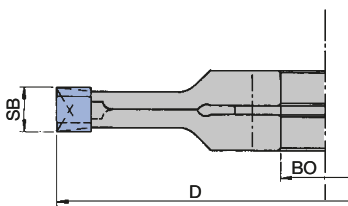
Spindle moulders, moulders, edgbanding machines and stationary routers with/without CNC control, double-end tenoners.

##### Workpiece material:

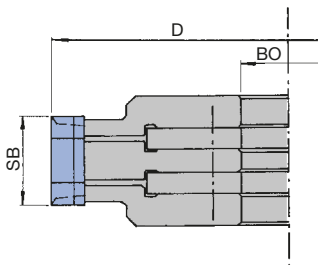
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

##### Technical information:

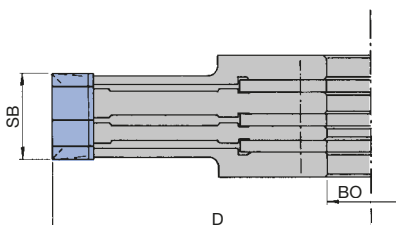
Adjustment of cutting widths with spacers (adjustment 0.10 mm).



Grooving cutterset, 2 part design



Grooving cutterset with 1 additional extension part



Grooving cutterset with 2 additional extension parts

#### 2 part with spurs; SB 1.8 - 23.5 mm

SF 501 1 01

| D   | SB          | BO | BO <sub>max</sub> | Z | V | NT   | n                 | ID       |
|-----|-------------|----|-------------------|---|---|------|-------------------|----------|
| mm  | mm          | mm | mm                |   |   | mm   | min <sup>-1</sup> |          |
| 140 | 1.8 - 3.4   | 30 | 35                | 4 | 4 | 20   | 5500 - 9500       | 020545 ● |
| 140 | 1.8 - 3.4   | 35 | 35                | 4 | 4 | 20   | 5500 - 9500       | 020546 □ |
| 140 | 1.8 - 3.4   | 40 | 45                | 4 | 4 | 20   | 5500 - 9500       | 020547 □ |
| 140 | 2.2 - 4.0   | 30 | 35                | 4 | 4 | 20   | 5500 - 9500       | 020549 ● |
| 140 | 2.2 - 4.0   | 35 | 35                | 4 | 4 | 20   | 5500 - 9500       | 020550 □ |
| 140 | 2.2 - 4.0   | 40 | 40                | 4 | 4 | 20   | 5500 - 9500       | 020551 □ |
| 140 | 2.2 - 4.0   | 50 | 50                | 4 | 4 | 20   | 5500 - 9500       | 020552 □ |
| 150 | 4.0 - 7.5   | 30 | 35                | 4 | 4 | 37.5 | 5200 - 8900       | 020573 ● |
| 150 | 4.0 - 7.5   | 40 | 45                | 4 | 4 | 30   | 5200 - 8900       | 020575 □ |
| 150 | 4.0 - 7.5   | 50 | 50                | 4 | 4 | 27.5 | 5200 - 8900       | 020576 □ |
| 150 | 7.5 - 14.5  | 30 | 35                | 4 | 4 | 37.5 | 5200 - 8900       | 020580 ● |
| 150 | 7.5 - 14.5  | 35 | 45                | 4 | 4 | 30   | 5200 - 8900       | 020581 □ |
| 150 | 7.5 - 14.5  | 40 | 45                | 4 | 4 | 30   | 5200 - 8900       | 020582 □ |
| 150 | 7.5 - 14.5  | 50 | 50                | 4 | 4 | 27.5 | 5200 - 8900       | 020583 □ |
| 180 | 6.0 - 11.5  | 30 | 35                | 4 | 4 | 45   | 4300 - 7400       | 020584 ● |
| 180 | 12.0 - 23.5 | 30 | 35                | 4 | 4 | 45   | 4300 - 7400       | 020585 ● |
| 180 | 12.0 - 23.5 | 40 | 45                | 4 | 4 | 45   | 4300 - 7400       | 020586 □ |

#### 2 part; SB 5.2 - 14 mm

SF 501 1 03

| D   | SB       | BO | BO <sub>max</sub> | NLA     | Z | V | NT | n                 | ID       |
|-----|----------|----|-------------------|---------|---|---|----|-------------------|----------|
| mm  | mm       | mm | mm                | mm      |   |   | mm | min <sup>-1</sup> |          |
| 250 | 5.2 - 10 | 30 | 35                | 2/10/60 | 8 | 8 | 40 | 3500 - 6000       | 020693 ● |
| 250 | 5.2 - 10 | 35 | 60                |         | 8 | 8 | 40 | 3100 - 5300       | 020694 □ |
| 250 | 7.2 - 14 | 35 | 60                |         | 8 | 8 | 40 | 3100 - 5300       | 020697   |

#### 3 / 4 part; SB 4.0 - 30 mm

SF 501 1, SF 501 1 02

| D   | SB       | BO | BO <sub>max</sub> | NLA     | Z   | V | NT | n                 | ID       |
|-----|----------|----|-------------------|---------|-----|---|----|-------------------|----------|
| mm  | mm       | mm | mm                | mm      |     |   | mm | min <sup>-1</sup> |          |
| 150 | 7.5 - 28 | 50 | 50                |         | 4+4 | 4 | 22 | 5200 - 8900       | 020661   |
| 160 | 4 - 13   | 30 |                   |         | 4   | 4 | 35 | 5000 - 10700      | 020667 ● |
| 220 | 5 - 30   | 30 | 35                | 2/10/60 | 4+4 | 4 | 55 | 3500 - 6000       | 020662 ● |



## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



#### Grooving cutterset, adjustable with spacers

**Application:**

For cutting different groove widths. 2 part design.

**Machine:**

Spindle moulders, moulders, edgbanding machines and double-end tenoners.

**Workpiece material:**

Uncoated, coated and veneered wood derived materials.

**Technical information:**

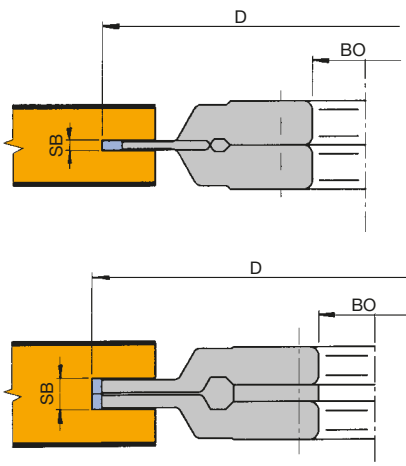
Adjustment of cutting width with spacers (adjustment 0.10 mm).

Diamaster PRO design. Tip height 3.0 mm.

**2 part; Diamaster PRO; SB 5.0 - 9.5 mm**

SF 501 1 DP

| D   | SB        | BO | BO <sub>max</sub> | NT | Z   | n                 | ID              |
|-----|-----------|----|-------------------|----|-----|-------------------|-----------------|
| mm  | mm        | mm | mm                | mm |     | min <sup>-1</sup> |                 |
| 180 | 5.0 - 9.5 | 30 | 50                | 25 | 4/4 | 4300 - 7400       | <b>090301 ●</b> |



Application examples of grooving in the middle layer



### Grooving cutterhead set adjustable with spacers

**Application:**

For cutting different groove widths.

**Machine:**

Spindle moulders, moulders, edgbanding machines and stationary routers with/without CNC control, double-end tenoners.

**Workpiece material:**

Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

**Technical information:**

Adjustment of cutting widths with spacers (adjustment 0.10 mm).



**2 part; SB 4.0 - 7.5 mm**

SW 501 1 01

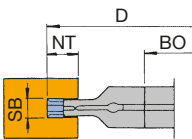
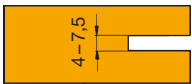
| D   | SB        | BO | BO <sub>max</sub> | NT | Z   | n                 | ID              |
|-----|-----------|----|-------------------|----|-----|-------------------|-----------------|
| mm  | mm        | mm | mm                | mm |     | min <sup>-1</sup> |                 |
| 150 | 4.0 - 7.5 | 30 | 50                | 20 | 2/2 | 5200 - 10100      | <b>128100 ●</b> |
| 180 | 4.0 - 7.5 | 30 | 50                | 35 | 2/2 | 4300 - 8400       | <b>128101 ●</b> |

**Extension parts SB 3.8 mm**

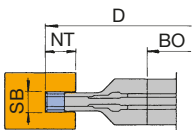
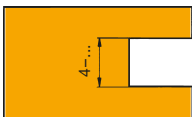
WW 200 1 NN

| D   | SB  | BO | BO <sub>max</sub> | Z | n                 | ID            |
|-----|-----|----|-------------------|---|-------------------|---------------|
| mm  | mm  | mm | mm                |   | min <sup>-1</sup> |               |
| 150 | 3.8 | 30 | 50                | 2 | 5200 - 10100      | <b>128130</b> |
| 180 | 3.8 | 30 | 50                | 2 | 4300 - 8400       | <b>128131</b> |

Each extension part increases the cutting widths by 3.6 mm.



Grooving cutterhead set, 2 part design



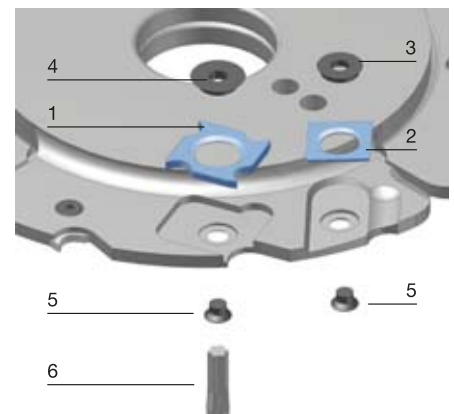
Grooving cutterhead set, multi part design

**Spare knives:**

| Part-no. | BEZ                | ABM        | QAL | VE  | ID              |
|----------|--------------------|------------|-----|-----|-----------------|
|          |                    | mm         |     | PCS |                 |
| 1        | Turnblade knife    | 18x18x1.95 | HW  | 10  | <b>005114 ●</b> |
| 2        | Turnblade spur VS4 | 14x14x1.2  | HW  | 10  | <b>005130 ●</b> |

**Spare parts:**

| Part-no. | BEZ                        | ABM        | ID              |
|----------|----------------------------|------------|-----------------|
|          |                            | mm         |                 |
| 3        | Special nut for VS         | M9.9/1.60  | <b>005654 ●</b> |
| 4        | Special nut for WPL        | M11.9/2.20 | <b>005653 ●</b> |
| 5        | Countersink screw, Torx® 9 | M4x0.5x3.2 | <b>006057 ●</b> |
| 6        | Torx® key                  | Torx® 9    | <b>005463 ●</b> |
|          | Setting gauge for knives   | 0.3/0.8    | <b>005374 ●</b> |



## 4. Manual feed

### 4.1 Grooving

#### 4.1.2 Grooving cutterheads



#### Grooving cutterhead set adjustable with spacers

##### Application:

For cutting different groove widths.

##### Machine:

Spindle moulders, moulders, edgbanding machines and stationary routers with/without CNC control, double-end tenoners.

##### Workpiece material:

Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials.

##### Technical information:

Adjustment of cutting widths with spacers (adj. range 0.1 mm). Multi part design.



##### Multi part; SB 8.0 - 30.0 mm

SW 501 1, SW 501 1 01

| D   | SB         | BO | NT | Z   | n                 | ID              |
|-----|------------|----|----|-----|-------------------|-----------------|
| mm  | mm         | mm | mm |     | min <sup>-1</sup> |                 |
| 150 | 8.0 - 15.4 | 30 | 20 | 2/2 | 5200 - 10100      | <b>128104</b> ● |
| 180 | 8.0 - 15.4 | 30 | 35 | 2/2 | 4300 - 8400       | <b>128105</b> ● |
| 200 | 8.0 - 15.4 | 30 | 45 | 2/2 | 3900 - 7600       | <b>128106</b> ● |
| 220 | 8.0 - 30.0 | 30 | 58 | 2/2 | 3500 - 6000       | <b>024663</b> ● |

##### Extension part

SW 501 1, WW 200 1 NN

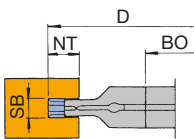
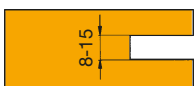
| D   | SB  | BO | BO <sub>max</sub> | Z | n                 | ID              |
|-----|-----|----|-------------------|---|-------------------|-----------------|
| mm  | mm  | mm | mm                |   | min <sup>-1</sup> |                 |
| 150 | 7.7 | 30 | 50                | 2 | 5200 - 10100      | <b>128134</b>   |
| 180 | 7.7 | 30 | 50                | 2 | 4300 - 8400       | <b>128135</b> ● |
| 200 | 7.7 | 30 | 50                | 2 | 3900 - 7600       | <b>128136</b> ● |
| 220 | 15  | 30 | 45                | 2 | 3500 - 6000       | <b>024666</b> ● |

##### Spare knives:

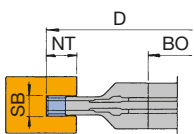
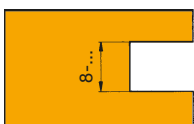
| Part-no. | BEZ                | ABM        | QAL   | VE  | ID              |
|----------|--------------------|------------|-------|-----|-----------------|
|          |                    | mm         |       | PCS |                 |
| 1        | Turnblade knife    | 7.7x8x1.5  | HW-05 | 10  | <b>005053</b> ● |
| 1        | Turnblade knife    | 14.7x8x1.5 | HW-05 | 10  | <b>005056</b> ● |
| 2        | Turnblade spur VS1 | 14x14x2    | HW-F  | 10  | <b>005099</b> ● |
| 2        | Turnblade spur VS2 | 19x19x2    | HW-F  | 10  | <b>005115</b> ● |

##### Spare parts:

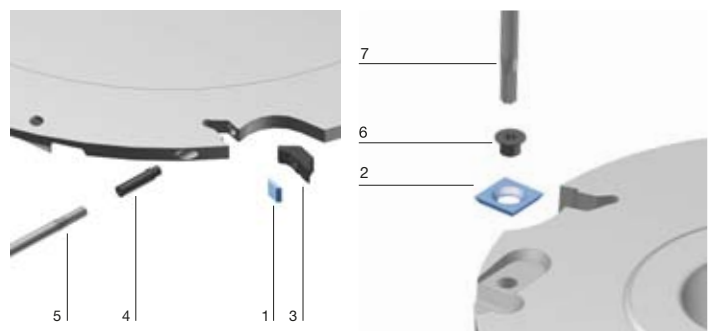
| Part-no. | BEZ                              | ABM           | ID              |
|----------|----------------------------------|---------------|-----------------|
|          |                                  | mm            |                 |
| 3        | Clamping wedge                   | 7x18.75x8.27  | <b>009763</b> ● |
| 3        | Clamping wedge                   | 13x18.75x8.27 | <b>009670</b> ● |
| 4        | Allen screw with shank, Torx® 15 | M5x20         | <b>007380</b> ● |
| 4        | Clamping screw w. disc, Torx® 25 | M6x18.5       | <b>007442</b> ● |
| 5        | Torx® key                        | Torx® 15      | <b>117507</b> ● |
| 5        | Torx® key                        | Torx® 25      | <b>117504</b> ● |
| 6        | Countersink screw, Torx® 20      | M6x0.5x4.9    | <b>006243</b> ● |
| 7        | Torx® key                        | Torx® 20      | <b>117503</b> ● |
|          | Setting gauge for knives         | 0.3/0.8       | <b>005374</b> ● |



Grooving cutterhead set, 2 part design



Grooving cutterhead set, multi part design





### Grooving cutterhead - steplessly adjustable

**Application:**

For cutting different groove widths.

**Machine:**

Spindle moulders, moulders, edgbanding machines and double-end tenoners.

**Workpiece material:**

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

**Technical information:**

Stepless adjustment of cutting width possible when installed on machine.  
2 part design.



**Mounted on sleeve; SB 4.0 - 15.0 mm**

SW 502 1 01

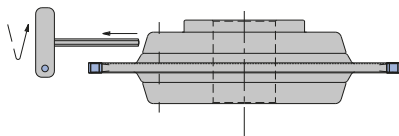
| D   | SB         | BO | BO <sub>max</sub> | NT | Z   | n                 | ID              |
|-----|------------|----|-------------------|----|-----|-------------------|-----------------|
| mm  | mm         | mm | mm                | mm |     | min <sup>-1</sup> |                 |
| 180 | 4.0 - 7.5  | 30 | 35                | 40 | 2/2 | 4300 - 8400       | <b>128154</b> ● |
| 180 | 8.0 - 15.0 | 30 | 35                | 40 | 2/2 | 4300 - 8400       | <b>128155</b> ● |
| 180 | 4.0 - 7.8  | 40 | 50                | 35 | 2/2 | 4300 - 8400       | <b>128156</b> ● |
| 180 | 8.0 - 15.0 | 40 | 50                | 35 | 2/2 | 4300 - 8400       | <b>128157</b> ● |

**Spare knives:**

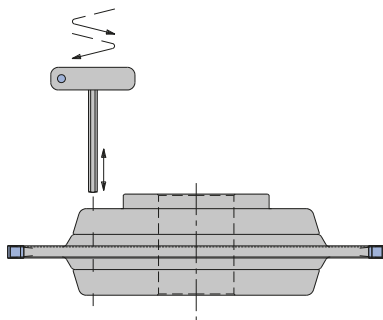
| Part-no. | BEZ                | ABM        | QAL   | VE  | ID              |
|----------|--------------------|------------|-------|-----|-----------------|
|          |                    | mm         |       | PCS |                 |
| 1        | Turnblade knife    | 18x18x1.95 | HW    | 10  | <b>005114</b> ● |
| 2        | Turnblade knife    | 7.7x8x1.5  | HW-05 | 10  | <b>005053</b> ● |
| 3        | Turnblade spur VS4 | 14x14x1.2  | HW    | 10  | <b>005130</b> ● |
| 4        | Turnblade spur VS2 | 19x19x2    | HW-F  | 10  | <b>005115</b> ● |

**Spare parts:**

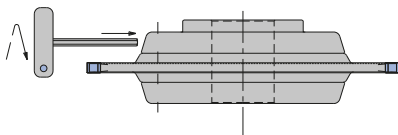
| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 5        | Special nut for WPL              | M11.9/2.20   | <b>005653</b> ● |
| 6        | Special nut for VS               | M9.9/1.60    | <b>005654</b> ● |
| 7        | Countersink screw, Torx® 9       | M4x0.5x3.2   | <b>006057</b> ● |
| 8        | Countersink screw, Torx® 20      | M6x0.5x4.9   | <b>006243</b> ● |
| 9        | Allen screw with shank, Torx® 15 | M5x20        | <b>007380</b> ● |
| 10       | Clamping wedge                   | 7x18.75x8.27 | <b>009763</b> ● |
| 11       | Torx® key                        | Torx® 20     | <b>117503</b> ● |
| 12       | Torx® key                        | Torx® 9      | <b>005463</b> ● |
| 13       | Torx® key                        | Torx® 15     | <b>117507</b> ● |
|          | Setting gauge for knives         | 0.3/0.8      | <b>005374</b> ● |



Opening the clamping system

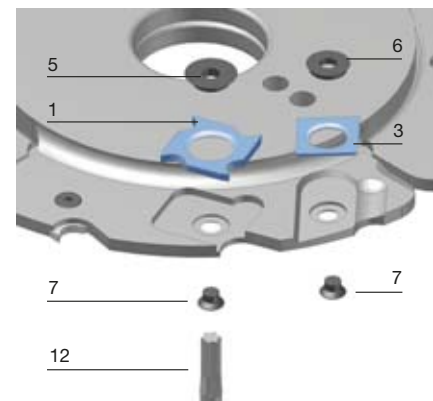
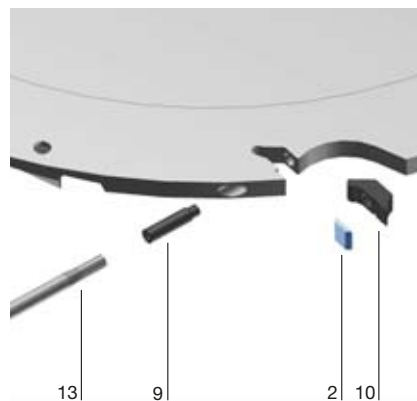


Adjustment: SB larger „+“,  
SB smaller „-“



Closing the clamping system

After the tool is mounted on the spindle it can be adjusted and clamped using a hexagon key



## 4. Manual feed

### 4.1 Grooving 4.1.3 Profile cutter



#### Profile cutter - pitch pockets

**Application:**

Optimized for milling pitch pockets.

**Machine:**

Portable machine Lamello Standard and Lamello Top.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

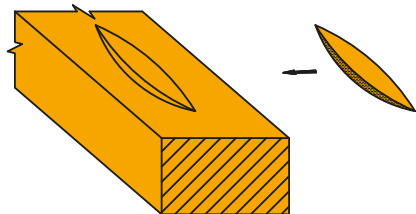
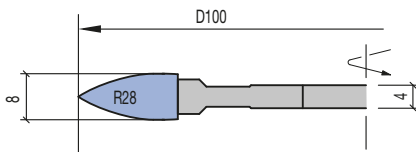
Two reciprocal cutting knives.

**Radii profile**

WF 502 1

| D   | SB | BO | BEM      | Z   | ID              |
|-----|----|----|----------|-----|-----------------|
| mm  | mm | mm |          |     |                 |
| 100 | 8  | 22 | Size 1-3 | 1+1 | <b>020126 ●</b> |

**RPM:** n = 7700 - 13000 min<sup>-1</sup>



|                           |  |
|---------------------------|--|
| <b>Type of operation</b>  | Rebate tools cut on the periphery and the side. The rebated edge is produced by spurs.   |
| <b>Workpiece material</b> | Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.  |
| <b>Machines</b>           | Spindle moulders.<br>Edgebanding machines; double-end tenoners.<br>Four-sided moulders.  |
| <b>Application</b>        | Jointing and rebating against feed: all panel materials with or without coating.<br>Jointing and rebating with feed: machining solid wood with heavily twisted fibres and risk of tear outs. Only for machines with mechanical feed.<br>Note: Difficult chip removal.<br>Jump cutting: jointing with or against feed across grain to avoid tear outs at the front and rear workpiece edges after edgebanding or lipping. |

#### Tool design



Turnblade rebating cutterhead with alternate shear angle:  
Reduced feed and cutting forces achieve clean and tear out free rebating edges. Suitable for all coated and uncoated panel materials as well as solid wood.

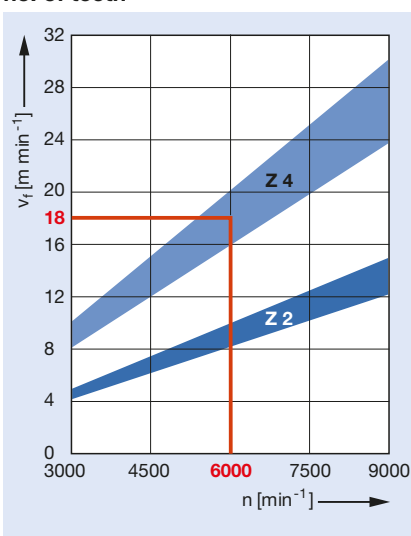


2 part tools with alternate shear angle:  
Can also be used as adjustable grooving tools.

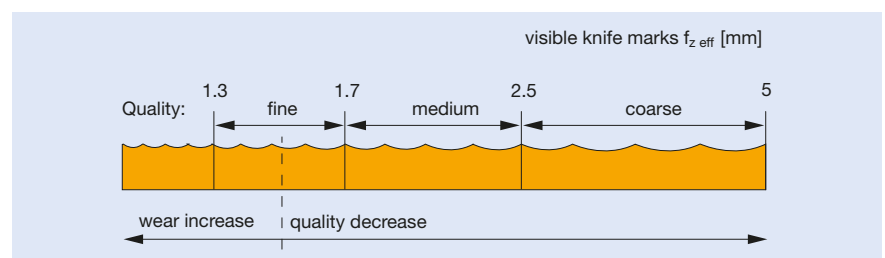


Turnblade rebating cutterhead with additional knives (edge knives):  
Multi-purpose tool for jointing, rebating and rounding/bevelling.

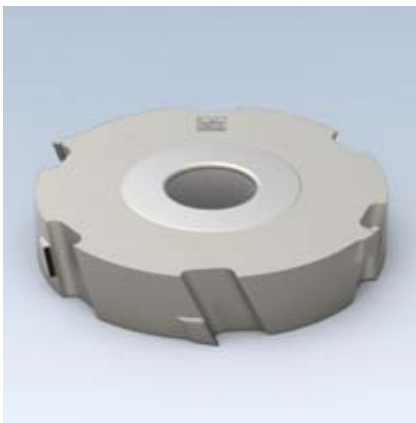
#### Feed speed depending on RPM and no. of teeth



#### Relation between surface quality and length of knife marks $f_{z \text{ eff}}$



With multi blade tools, only the marks of one knife show on the surface (one knife finish).  
Z 2 and Z 4 tools produce the same surface quality with the same machine setting.  
High numbers of teeth are required for a high hogging performance.



### Jointing and Rebating cutter Diamaster PRO

**Application:**

Optimized for rebating and jointing with and against feed (e.g. jump cutting). Manual feed only against feed.

**Machine:**

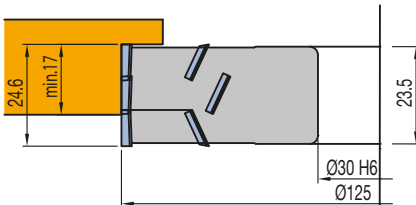
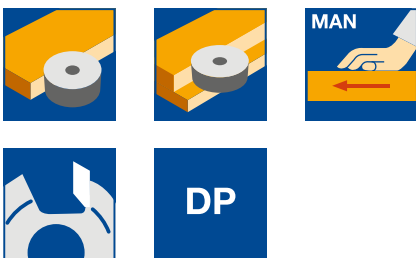
Spindle moulders and edgebanding machines, double-end tenoners.

**Workpiece material:**

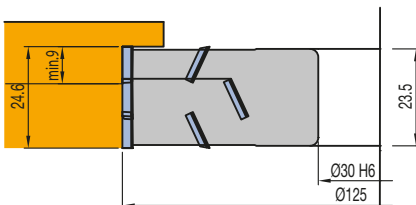
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood etc.), plastomers, solid surface material (Corian, Varicor etc.) fibre reinforced plastics (GFRP, CFRP etc.).

**Technical information:**

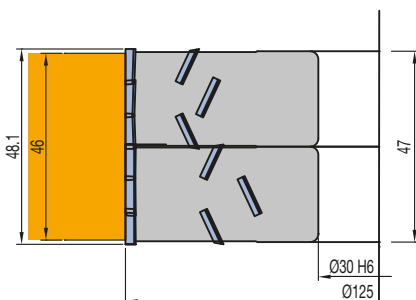
Composite tool with alternate shear angle and main blades with pre-cutting function. Long performance times through polished cutting area. Diamaster PRO design for two resharpening cycles with standard wear. Double sided rebating possible. For larger cutting widths a stacking of various tools is possible. 3.5 mm tipping height. 1.5 mm resharpening area.



Jointing cutter ID **090853**  
Rebate height min. 17 mm



Jointing cutter ID **090872**  
Rebating height min. 9 mm



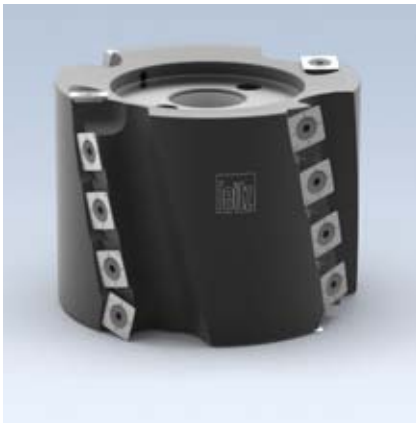
Set existing of ID **090853** and ID **090872**

**Diamaster PRO**

WF 400 1 DP

| D   | SB   | BO | Z     | ID              |
|-----|------|----|-------|-----------------|
| mm  | mm   | mm |       |                 |
| 125 | 24.6 | 30 | 2/2/2 | <b>090853</b> ● |
| 125 | 24.6 | 30 | 2/2/2 | <b>090872</b> ● |

RPM: n = 6200 - 13600 min<sup>-1</sup>



### Copy shaping cutterhead - HeliCut 15

#### Application:

For pre-cutting, jointing and copy shaping of large cutting depths. For copy shaping of curved workpieces with template, ball bearing and guide ring.

#### Machine:

Spindle moulders and profile milling machines, double-end tenoner, stationary routers with and without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam, chipboard and fibre materials (MDF etc.) uncoated, plastic coated, veneered etc.

#### Technical information:

Noise reduced design with staggered edges and very deep gullets for improved chip removal. Tungsten carbide cutting edges with Microfinish for perfect surface quality. Rebate tools cut on the periphery and the side.



#### Cutterhead for copy shaping, grooving and rebating

WW 230 2 07

| D   | SB    | BO | Z | V   | QAL   | AM  | ID       |
|-----|-------|----|---|-----|-------|-----|----------|
| mm  | mm    | mm |   |     |       | PCS |          |
| 60  | 81.5  | 20 | 2 | 2   | HW-MF | 16  | 132600 ● |
| 80  | 81.5  | 30 | 2 | 2   | HW-MF | 16  | 132608 ● |
| 125 | 93.7  | 30 | 2 | 2+2 | HW-MF | 20  | 132604 ● |
| 125 | 116.6 | 30 | 2 | 2+2 | HW-MF | 24  | 132605 ● |

**RPM:** D 60 mm:  $n_{\max} = 20000 \text{ min}^{-1}$

D 80 mm:  $n_{\max} = 18000 \text{ min}^{-1}$

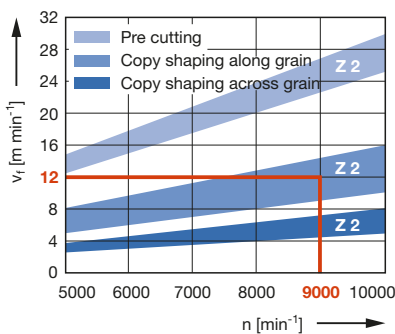
D 125 mm:  $n_{\max} = 12000 \text{ min}^{-1}$

#### Spare knives:

| BEZ             | ABM       | QAL   | BEM        | VE  | ID       |
|-----------------|-----------|-------|------------|-----|----------|
|                 | mm        |       |            | PCS |          |
| Turnblade knife | 15x15x2.5 | HW-MF | HeliCut 15 | 10  | 009543 ● |
| Turnblade knife | 15x15x2.5 | HW    | HeliCut 15 | 10  | 009549 ● |

#### Spare parts:

| BEZ                         | ABM      | for D | ID       |
|-----------------------------|----------|-------|----------|
|                             | mm       | mm    |          |
| Countersink screw, Torx® 20 | M5x18    | 125   | 114030 ● |
| Countersink screw, Torx® 20 | M5x12    | 60/80 | 007898 ● |
| Torx® key                   | Torx® 20 |       | 006091 ● |



**Feed speed  $v_f$  depending on the number of teeth  $Z$  and speed  $n$  for solid wood (pre trimming and copy shaping)**

#### Example:

$n = 9000 \text{ min}^{-1}$ ,  $Z 2$ /copy shaping along the grain:  $v_f = 12 \text{ m min}^{-1}$





## 4. Manual feed

## 4.2 Jointing, rebating and bevelling

### 4.2.3 Rebating cutterheads



#### Rebating cutterhead

##### Application:

For jointing, rebating and grooving.

##### Machine:

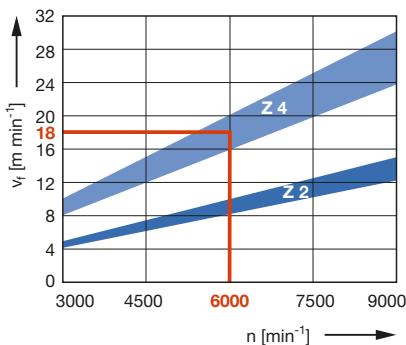
Spindle moulders (running against feed), double-end tenoners, edgebanding machines etc. (running with feed or against feed e.g. jump cutting). Stationary routers with/without CNC control.

##### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

##### Technical information:

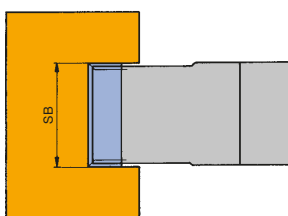
Cutterhead with alternate shear angle and triangular spurs.



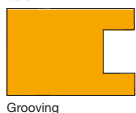
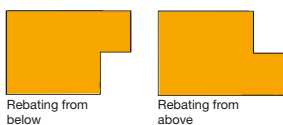
**Feed speed  $v_f$  depending on the number of teeth  $Z$  and speed  $n$  for solid wood along grain**

##### Example:

$n = 6000 \text{ min}^{-1}$ ,  $Z 4$ :  $v_f = 18 \text{ m min}^{-1}$



Tool set



#### Turnblade rebating cutterhead

WW 420 1, WW 420 1 02

| D   | SB | BO | BO <sub>max</sub> | Z | V | n <sub>max</sub>  | ID       |
|-----|----|----|-------------------|---|---|-------------------|----------|
| mm  | mm | mm | mm                |   |   | min <sup>-1</sup> |          |
| 85  | 51 | 30 | 40                | 2 | 4 | 20200             | 024555   |
| 100 | 51 | 30 | 40                | 2 | 4 | 17100             | 024568   |
| 125 | 41 | 30 | 40                | 2 | 4 | 13700             | 024546 ● |
| 125 | 51 | 30 | 50                | 2 | 4 | 13800             | 024569 ● |
| 125 | 51 | 40 | 50                | 2 | 4 | 13800             | 024570 □ |
| 125 | 51 | 50 | 50                | 2 | 4 | 13800             | 024571 □ |
| 125 | 81 | 30 | 50                | 2 | 4 | 13700             | 024723 ● |
| 150 | 51 | 30 | 40                | 2 | 4 | 11400             | 024548 ● |
| 150 | 61 | 30 | 50                | 4 | 4 | 11400             | 024543 ● |

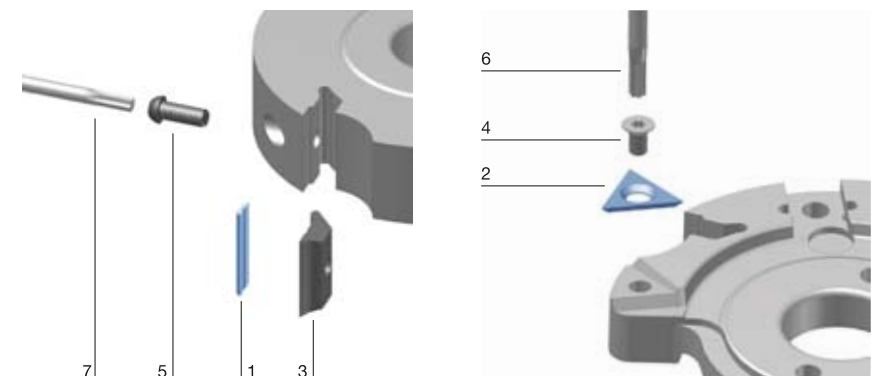
#### Spare knives:

| Part-no. | BEZ                | ABM      | QAL    | VE  | ID       |
|----------|--------------------|----------|--------|-----|----------|
|          |                    | mm       |        | PCS |          |
| 1        | Turnblade knife    | 40x8x1.5 | HW-30F | 10  | 005074 ● |
| 1        | Turnblade knife    | 50x8x1.5 | HW-30F | 10  | 005075 ● |
| 1        | Turnblade knife    | 60x8x1.5 | HW-30F | 10  | 005076 ● |
| 1        | Turnblade knife    | 80x8x1.5 | HW-30F | 10  | 601613 ● |
| 2        | Turnblade spur VS2 | 19x19x2  | HW-F   | 10  | 005115 ● |

Alternative turnblade knife qualities see section Knives and Spare Parts

#### Spare parts:

| Part-no. | BEZ                              | ABM           | ID       |
|----------|----------------------------------|---------------|----------|
|          |                                  | mm            |          |
| 3        | Clamping wedge                   | 38x18.75x8.27 | 009675 ● |
| 3        | Clamping wedge                   | 48x18.75x8.27 | 009677 ● |
| 3        | Clamping wedge                   | 58x18.75x8.27 | 009678 ● |
| 3        | Clamping wedge                   | 78x18.75x8.27 | 009680 ● |
| 4        | Countersink screw, Torx® 20      | M5x8.5        | 007808 ● |
| 5        | Clamping screw w. disc, Torx® 25 | M6x18.5       | 007442 ● |
| 6        | Torx® key                        | Torx® 20      | 117503 ● |
| 7        | Torx® key                        | Torx® 25      | 117504 ● |
|          | Setting gauge for knives         | 0.3/0.8       | 005374 ● |



● available ex stock  
 □ available at short notice  
 Instruction manual visit [www.leitz.org](http://www.leitz.org)



### Rebating cutterset, 2 part design

**Application:**

For jointing, rebating and grooving.

**Machine:**

Spindle moulders (running against feed), double-end tenoners and edgbanding machines etc. (running with feed or against feed).

**Workpiece material:**

Softwood and hardwood, glulam, plastics etc.

**Technical information:**

2 part with spacers adjustable tool set with alternate shear angle and triangular spurs.



**SB 26.4 - 98 mm**

SW 531 1 01

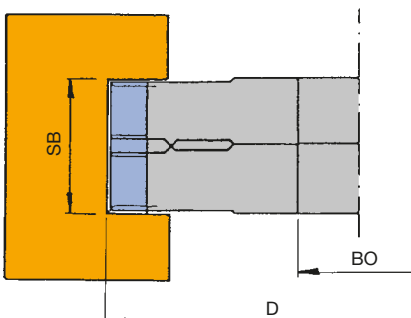
| D   | SB | VSB       | BO | BO <sub>max</sub> | Z | V | n                 | ID       |
|-----|----|-----------|----|-------------------|---|---|-------------------|----------|
| mm  | mm |           | mm | mm                |   |   | min <sup>-1</sup> |          |
| 160 | 20 | 26.4 - 38 | 30 | 45                | 4 | 4 | 4900 - 9500       | 024456 ● |
| 160 | 20 | 26.4 - 38 | 50 | 50                | 4 | 4 | 4900 - 9500       | 024458 □ |
| 160 | 50 | 56.4 - 98 | 40 | 45                | 4 | 4 | 4900 - 9500       | 024455   |

**Spare knives:**

| Part-no. | BEZ                | ABM        | QAL    | VE  | ID       |
|----------|--------------------|------------|--------|-----|----------|
|          |                    | mm         |        | PCS |          |
| 1        | Turnblade knife    | 19.7x8x1.5 | HW-30F | 10  | 005071 ● |
| 1        | Turnblade knife    | 50x8x1.5   | HW-30F | 10  | 005075 ● |
| 1        | Turnblade knife    | 30x8x1.5   | HW-30F | 10  | 005072 ● |
| 2        | Turnblade spur VS2 | 19x19x2    | HW-F   | 10  | 005115 ● |

**Spare parts:**

| Part-no. | BEZ                              | ABM           | ID       |
|----------|----------------------------------|---------------|----------|
|          |                                  | mm            |          |
| 3        | Clamping wedge                   | 18x18.75x8.27 | 009671 ● |
| 3        | Clamping wedge                   | 48x18.75x8.27 | 009677 ● |
| 3        | Clamping wedge                   | 28x18.75x8.27 | 009673 ● |
| 4        | Countersink screw, Torx® 20      | M6x0.5x4.9    | 006243 ● |
| 5        | Clamping screw w. disc, Torx® 25 | M6x18.5       | 007442 ● |
| 6        | Torx® key                        | Torx® 20      | 117503 ● |
| 7        | Torx® key                        | Torx® 25      | 117504 ● |
|          | Setting gauge for knives         | 0.3/0.8       | 005374 ● |



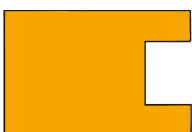
Tool set



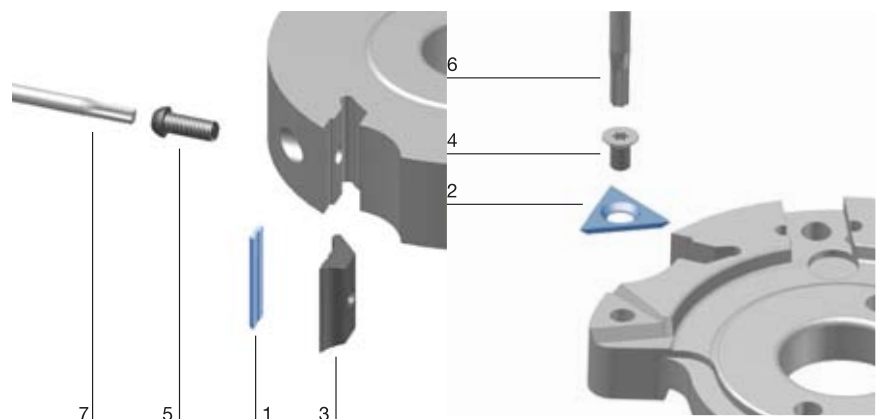
Rebating from below

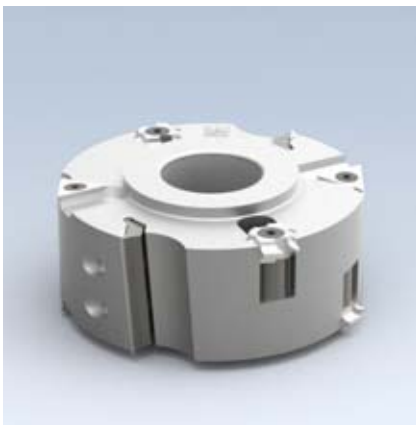


Rebating from above



Grooving





### Jointing and rebating cutterhead

#### Application:

For rebating and jointing, rounding and profiling at the same time.

#### Machine:

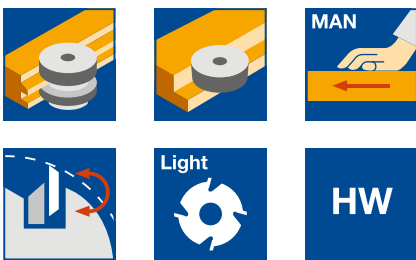
Spindle moulders and moulders, double-end tenoners. Stationary routers with/without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

#### Technical information:

Cutterhead with turnblade knives. With alternate shear angle, triangle spurs and seating to adapt edging knives.



#### Cutterhead with seatings for edging knives

WW 420 1 01

| D   | SB  | BO | Z | KM  | n                 | QAL | ID       |
|-----|-----|----|---|-----|-------------------|-----|----------|
| mm  | mm  | mm |   | PCS | min <sup>-1</sup> |     |          |
| 125 | 51  | 30 | 2 | 4   | 6200 - 10600      | HW  | 029073 ● |
| 125 | 101 | 30 | 2 | 4   | 6200 - 10600      | HW  | 029074 ● |
| 170 | 51  | 30 | 2 | 4   | 4500 - 7800       | HW  | 029075 ● |

#### Spare knives:

| Part-no. | BEZ                | ABM      | R   | FAW | QAL    | VE  | ID       |
|----------|--------------------|----------|-----|-----|--------|-----|----------|
|          |                    | mm       | mm  | °   |        | PCS |          |
| 1        | Turnblade knife    | 50x8x1.5 |     |     | HW-30F | 10  | 005075 ● |
| 2        | Turnblade spur VS2 | 19x19x2  |     |     | HW-F   | 10  | 005115 ● |
| 3        | Edging knife 45°   | KM 21/0  |     | 45° | HW-F   |     | 008292 ● |
| 3        | Edging knife R1.5  | KM 22/4  | 1.5 |     | HW-F   |     | 008295 ● |
| 3        | Edging knife R2    | KM 22/3  | 2   |     | HW-F   |     | 008309 ● |
| 3        | Edging knife R3    | KM 22/0  | 3   |     | HW-F   |     | 008293 ● |
| 3        | Edging knife R5    | KM 24/0  | 5   |     | HW-F   |     | 008305 ● |
| 3        | Edging knife R5    | KM 24/1  | 5   |     | HW-F   |     | 008306 ● |

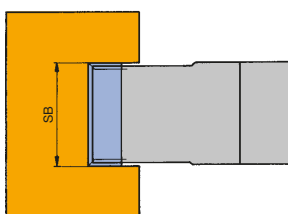
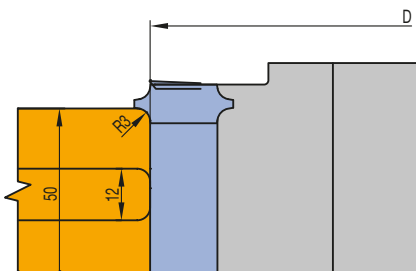
#### Spare parts:

| Part-no. | BEZ                              | ABM           | ID       |
|----------|----------------------------------|---------------|----------|
|          |                                  | mm            |          |
| 5        | Clamping wedge                   | 48x18.75x8.27 | 009677 ● |
| 6        | Clamping screw w. disc, Torx® 25 | M6x18.5       | 007442 ● |
| 9        | Countersink screw, Torx® 20      | M6x30         | 006089 ● |
|          | Torx® key                        | Torx® 20      | 117503 ● |
|          | Torx® key                        | Torx® 25      | 117504 ● |
|          | Setting gauge for knives         | 1.0           | 005350 ● |
|          | Spacer                           | 13/6.1x0.1    | 028034 ● |
|          | Spacer                           | 13/6.1x0.3    | 028035 ● |
|          | Spacer                           | 13/6.1x0.5    | 028036 ● |
|          | Spacer                           | 13/6.1x1      | 028037 ● |
|          | Spacer                           | 13/6.1x3      | 028040 ● |
|          | Spacer                           | 13/6.1x5      | 028042 ● |

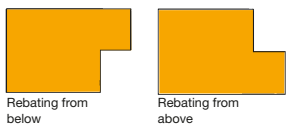
#### Edging knife set: 2 edging knives each + countersunk screw + set of spacers

TE 540 0

| BEZ            | FAW | R   | QAL | ID       |
|----------------|-----|-----|-----|----------|
|                | °   | mm  |     |          |
| Edge cutterset | 45° |     | HW  | 009091 ● |
| Edge cutterset |     | 1.5 | HW  | 009092 ● |
| Edge cutterset |     | 3   | HW  | 009093 ● |
| Edge cutterset |     | 5   | HW  | 009097 ● |
| Edge cutterset |     | 5   | HW  | 009098 ● |



Tool set

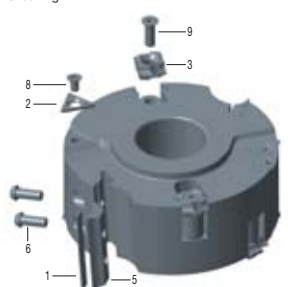


Rebating from below

Rebating from above



Grooving





### Rebate cutterset UniCut

**Application:**

For rebating, jointing, grooving, bevelling and rounding.

**Machine:**

Spindle moulders, moulders etc.

**Workpiece material:**

Softwood and hardwood, glulam, plastics etc.

**Technical information:**

2 part with spacers adjustable tool set for multi-purpose application.

**With seatings for edging knives and turnblade grooving knives; SB 30 - 60 mm  
AW 330 1 01**

| Tool no. | D<br>mm | SB<br>mm | BO<br>mm | BO <sub>max</sub><br>mm | Z   | V   | n<br>min <sup>-1</sup> | ID       |
|----------|---------|----------|----------|-------------------------|-----|-----|------------------------|----------|
| 1 + 2    | 160     | 30 - 60  | 30       | 50                      | 2/2 | 2/2 | 4900 - 8300            | 024056 ● |
| 1 + 2    | 160     | 30 - 60  | 40       |                         | 2/2 | 2/2 | 4900 - 8300            | 024062 □ |



Tool complete with edge rounding knife R 2.

Additionally:

2 grooving knives SB 4 mm with countersunk screws

1 set of spacers D 70 mm for adjusting the tool parts

1 set of spacers D 13.70 mm to adjust the edging/grooving knives

1 setting gauge 0.3/0.8 mm

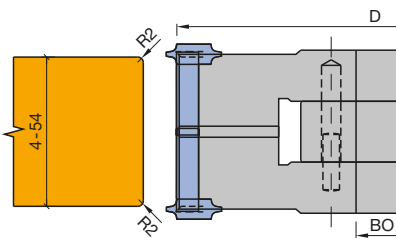
Tool set in wooden box, BO 30.

**Spare knives:**

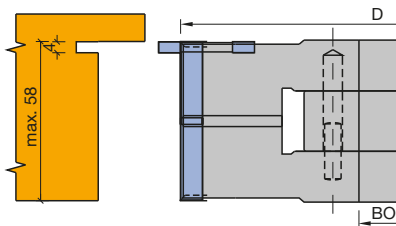
| Part-no. | BEZ                          | ABM<br>mm | QAL    | VE<br>PCS | ID       |
|----------|------------------------------|-----------|--------|-----------|----------|
| 1        | Turnblade knife              | 30x8x1.5  | HW-30F | 10        | 005072 ● |
| 2        | Turnblade spur VS2           | 19x19x2   | HW-F   | 10        | 005115 ● |
| 3        | Edging knife 45°             | KM 21/0   | HW-F   |           | 008292 ● |
| 3        | Edging knife R2              | KM 22/3   | HW-F   |           | 008309 ● |
| 4        | Turnblade grooving knife NB4 | 36x20x4   | HW-F   |           | 008323 ● |

**Spare parts:**

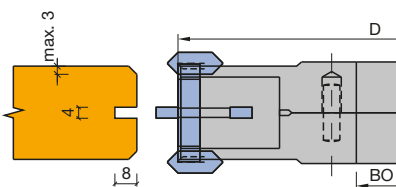
| Part-no. | BEZ                              | ABM<br>mm     | ID       |
|----------|----------------------------------|---------------|----------|
| 5        | Clamping screw w. disc, Torx® 25 | M6x18.5       | 007442 ● |
| 6        | Countersink screw, Torx® 20      | M6x30         | 006089 ● |
| 7        | Countersink screw, Torx® 20      | M6x0.5x4.9    | 006243 ● |
| 8        | Clamping wedge                   | 28x18.75x8.27 | 009673 ● |
| 9        | Torx® key                        | Torx® 20      | 117503 ● |
| 10       | Torx® key                        | Torx® 25      | 117504 ● |
|          | Setting gauge for knives         | 0.3/0.8       | 005374 ● |



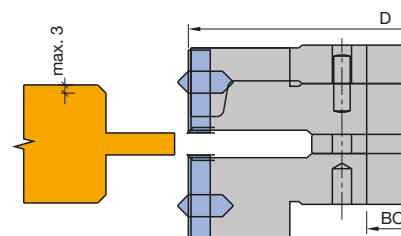
Jointing, rounding



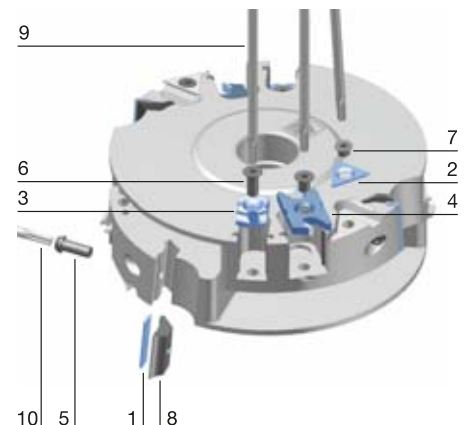
Rebating and seal groove



Groove and chamfers



Tongue profile





### Bevel cutterhead turnblade, swivelling

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

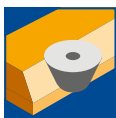
Spindle moulders, moulders, edgbanding machines, double-end tenoners and special machines.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber, plastomers, limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder swivelling adjustable from 0 - 90°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Free of marks cutting result due to 1-part, continuous cutting edge. Economical due to changeable tungsten carbide turnblades with two cutting edges. Optimized gullet design for improved chip removal.



**Turnblade, adjustable bevel angle**

WW 430 1 05

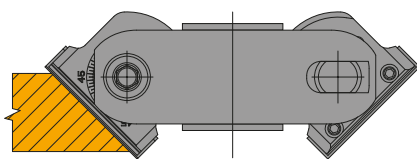
| D   | SB | BO    | BO <sub>max</sub> | Swivel range | n                 | Z   | ID              |
|-----|----|-------|-------------------|--------------|-------------------|-----|-----------------|
| mm  | mm | mm    | mm                | °            | min <sup>-1</sup> |     |                 |
| 150 | 50 | 30    | 40                | 0 - 90       | 5000 - 9000       | 1/1 | <b>024169</b> ● |
| 150 | 50 | 31.75 | 40                | 0 - 90       | 5000 - 9000       | 1/1 | <b>024170</b> □ |
| 150 | 50 | 40    | 40                | 0 - 90       | 5000 - 9000       | 1/1 | <b>024171</b> □ |

**Spare knives:**

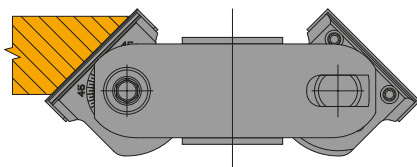
| Part-no. | BEZ             | ABM       | QAL    | VE  | ID              |
|----------|-----------------|-----------|--------|-----|-----------------|
|          |                 | mm        |        | PCS |                 |
| 1        | Turnblade knife | 50x12x1.5 | HW-05F | 10  | <b>005086</b> ● |

**Spare parts:**

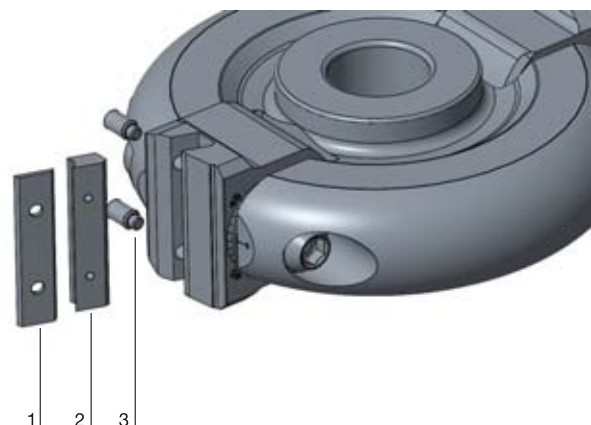
| Part-no. | BEZ                      | ABM         | ID              |
|----------|--------------------------|-------------|-----------------|
|          |                          | mm          |                 |
| 2        | Clamping wedge with pin  | 48x10.88x6  | <b>009766</b> ● |
| 3        | Allen screw              | M6x12       | <b>006035</b> ● |
|          | Allen key                | SW 3        | <b>005433</b> ● |
|          | Allen key                | SW 8, L 100 | <b>005437</b> ● |
|          | Setting gauge for knives | 80x12x9.5   | <b>005352</b> ● |



Bevelling from above



Bevelling from below





### Bevel cutterhead HeliCut, swivelling

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

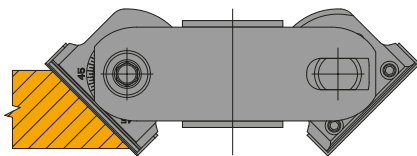
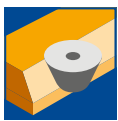
Spindle moulders, moulders, edgbanding machines and double-end tenoners.

**Workpiece material:**

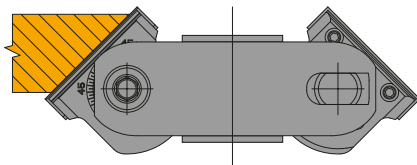
Softwood and hardwood, laminated veneer lumber, plastomers, technical foams (XPS, PU), limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternatinv shear angles. Economical due to partial change of tungsten carbide turnblades with four cutting edges. Cutting edges with particularly sleek geometry and polishing for perfect surface quality and long performance time. Noice reduced design with split cutting edges and optimized gullet design for improved chip removal.



Bevelling from above



Bevelling from below

**HeliCut, adjustable bevel angle**

WW 430 1 05

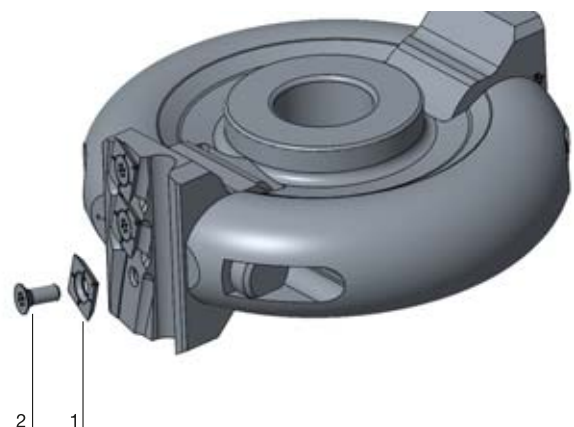
| D   | SB | BO    | BO <sub>max</sub> | Swivel range | n                 | Z   | ID       |
|-----|----|-------|-------------------|--------------|-------------------|-----|----------|
| mm  | mm | mm    | mm                | °            | min <sup>-1</sup> |     |          |
| 150 | 55 | 30    | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024290 ● |
| 150 | 55 | 31.75 | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024262 □ |
| 150 | 55 | 40    | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024264 □ |

**Spare knives:**

| Part-no. | BEZ             | ABM       | ID       |
|----------|-----------------|-----------|----------|
|          |                 | mm        |          |
| 1        | Turnblade knife | 15x15x2.5 | 009543 ● |

**Spare parts:**

| Part-no. | BEZ                         | ABM         | ID       |
|----------|-----------------------------|-------------|----------|
|          |                             | mm          |          |
| 2        | Countersink screw, Torx® 20 | M5x12       | 007898 ● |
|          | Torx® key                   | Torx® 20    | 006091 ● |
|          | Allen key                   | SW 8, L 100 | 005437 ● |





**Bevel cutterhead WhisperCut, swivelling**

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

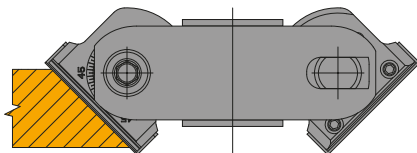
Spindle moulders, moulders, edgbanding machines and double-end tenoners.

**Workpiece material:**

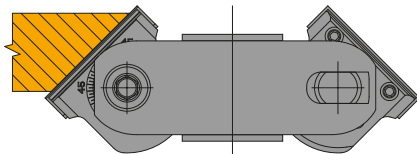
Hardwood, chip and fibre board (chipboard, MDF, HDF etc.), plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), solid surface material (e.g. Corian®, Varicor® etc.), fibre reinforced plastics (e.g. GRP, CFRP).

**Technical information:**

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternatinv shear angles. Economical due to partial change of diamond cutting edges. Noise reduced design with optimized gullet design for improved chip removal.



Bevelling from above



Bevelling from below

**WhisperCut, adjustable bevel angle**

WW 430 1 05

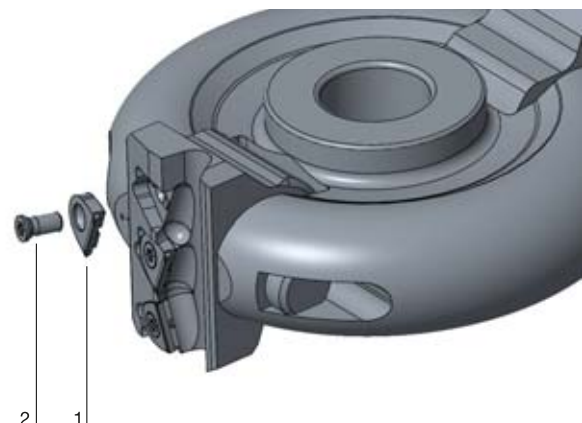
| D   | SB | BO    | BO <sub>max</sub> | Swivel range | n                 | Z   | ID       |
|-----|----|-------|-------------------|--------------|-------------------|-----|----------|
| mm  | mm | mm    | mm                | °            | min <sup>-1</sup> |     |          |
| 150 | 55 | 30    | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024291 ● |
| 150 | 55 | 31.75 | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024263 □ |
| 150 | 55 | 40    | 40                | 0 - 65       | 5000 - 9000       | 1/1 | 024265 □ |

**Spare knives:**

| Part-no. | BEZ                   | ABM         | ID       |
|----------|-----------------------|-------------|----------|
|          |                       | mm          |          |
| 1        | WhisperCut-knife SB14 | 14x14.2x4.3 | 091074 ● |

**Spare parts:**

| Part-no. | BEZ                      | ABM         | ID       |
|----------|--------------------------|-------------|----------|
|          |                          | mm          |          |
| 2        | Countersink screw, Torx® | M5x11.5     | 007899 ● |
|          | 20/59° Torx® key         | Torx® 20    | 006091 ● |
|          | Allen key                | SW 8, L 100 | 005437 ● |



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**Types of operation** The tools in the following section are suitable for producing glue joints, divided into glue joints (along the grain) and mitre joints.

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#### Glue joints along grain

Glue joint profiles for length grain glue joints have a low profile depth to minimise the material loss at each glue joint. Glue joint profiles do not increase the stability of the glue joint. The profile is used to position the wood precisely, so it does not slip during pressing. Length grain glue joint profiles are not self-locking. The workpieces must remain pressed together until the glue has hardened completely. Profile tools for glue joints along the grain are not suitable for mitre joints.

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**Workpiece material** Softwood and hardwood.

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**Machine** Spindle moulders with or without power feed.  
Four-sided moulders.  
Double-end tenoners.

---

**Application** Against the feed, always along the grain.

---

#### Mitre joint

Solid wood and wood-derived materials cannot be glued on the end faces side without glue joint profiles. Compared to glue joints along the grain, mitre glue joint profiles increase the stability of the joint. These profiles have a greater profile depth, generally 10 mm. Mitre joint profiles must have a straight edge area to create a defined straight joint in the visible area. The profiles are slightly self-locking. This means the workpieces need to be pressed together briefly and can only be machined after the glue has hardened. Mitre joints are typically used to produce segments for arched windows or profiled mouldings.

---

**Workpiece material** Softwood and hardwood.

---

**Machine** Spindle moulders with clamping device and sliding table.  
Double-end tenoners.  
Window machines.  
Stationary routers with or without CNC control.

---

**Application** Against feed, across or along the grain.

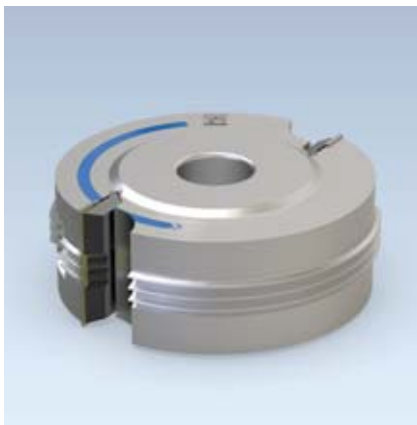
---



## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.1 Glue joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joint profiles

##### Application:

To cut glue joint profiles with high fit accuracy. Profile P2-4 for processing with the grain for precise positioning of the wood to be glued. Profile 1 is especially suitable for mitre joint profile/longitudinal glue joint profile and for frames.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Finger profile in rounded design (softline). Effective wood use through small profile depth.



##### MAN feed

WE 600 1 53

| P | D   | SB | BO | BO <sub>max</sub> | Z | n                 | ID              |
|---|-----|----|----|-------------------|---|-------------------|-----------------|
|   | mm  | mm | mm | mm                |   | min <sup>-1</sup> |                 |
| 1 | 135 | 30 | 30 | 50                | 2 | 5700 - 9900       | <b>125125</b> ● |
| 2 | 135 | 50 | 30 | 50                | 2 | 5700 - 9900       | <b>125126</b> ● |
| 3 | 135 | 60 | 30 | 50                | 2 | 5700 - 9900       | <b>125127</b> ● |
| 3 | 135 | 60 | 50 |                   | 2 | 5700 - 9900       | <b>125390</b> □ |
| 4 | 135 | 80 | 30 | 50                | 2 | 5700 - 9900       | <b>125128</b> ● |

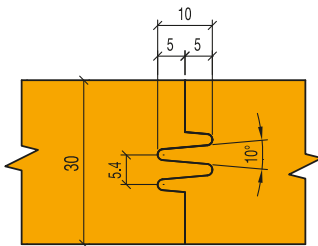
##### Spare knives:

| Part-no. | BEZ               | ABM     | QAL | ID              |
|----------|-------------------|---------|-----|-----------------|
|          |                   | mm      |     |                 |
| 1        | ProfilCut Q knife | 30x16x2 | MC  | <b>619237</b> ● |
| 1        | ProfilCut Q knife | 50x16x2 | MC  | <b>619234</b> ● |
| 1        | ProfilCut Q knife | 60x16x2 | MC  | <b>619235</b> ● |
| 1        | ProfilCut Q knife | 80x16x2 | MC  | <b>619236</b> ● |

##### Spare parts:

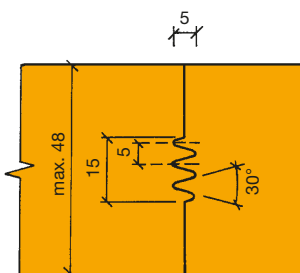
| Part-no. | BEZ                              | ABM           | ID              |
|----------|----------------------------------|---------------|-----------------|
|          |                                  | mm            |                 |
| 2        | Clamping wedge profiled          | 48x23.73x8.27 | <b>629219</b>   |
| 2        | Clamping wedge profiled          | 58x23.73x8.27 | <b>629220</b>   |
| 2        | Clamping wedge profiled          | 78x23.73x8.27 | <b>629221</b>   |
| 2        | Clamping wedge profiled          | 28x23.73x8.27 | <b>629222</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5       | <b>007442</b> ● |
| 4        | Torx® key                        | Torx® 25      | <b>117504</b> ● |

Mitre joint/longitudinal glue joint profile

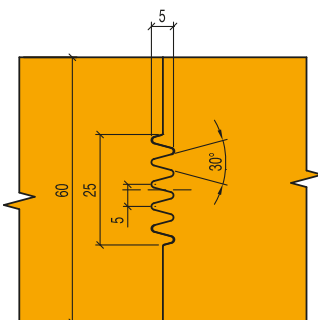


P1

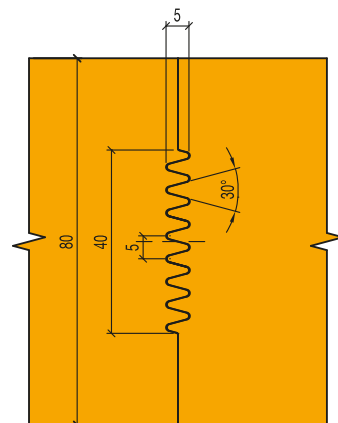
Width glue joint profile



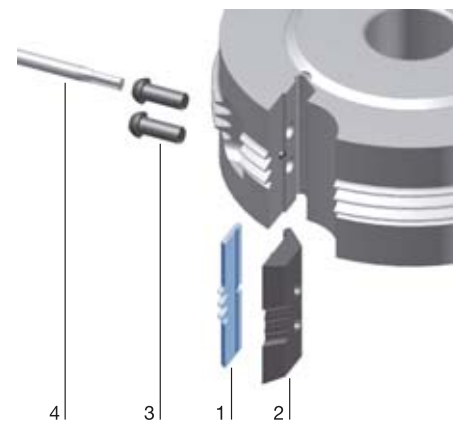
P2



P3



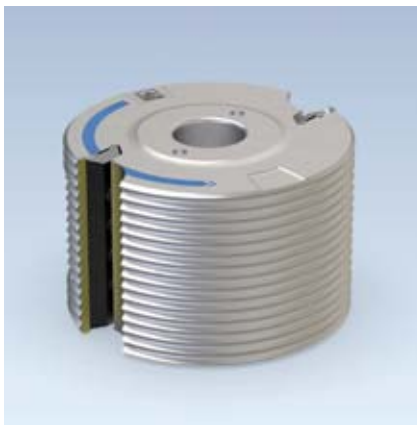
P4



## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.1 Glue joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joint profiles

**Application:**

To cut glue joint profiles in fibre direction with high fit accuracy.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Finger profile in rounded design (softline). Effective wood use through small profile depth.



**Profile cutterhead set**

SE 600 1 53

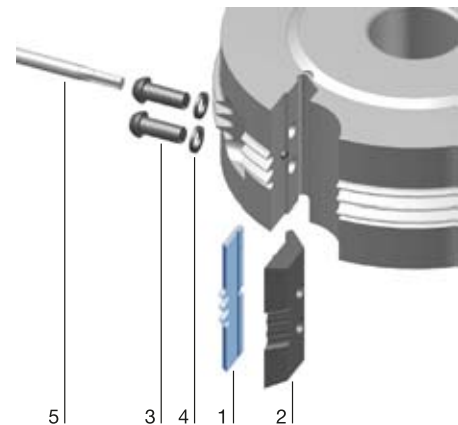
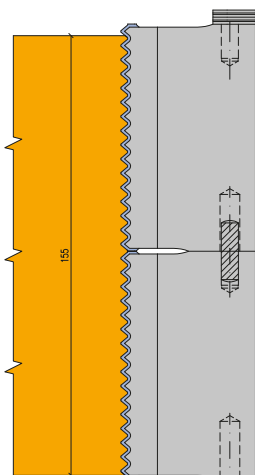
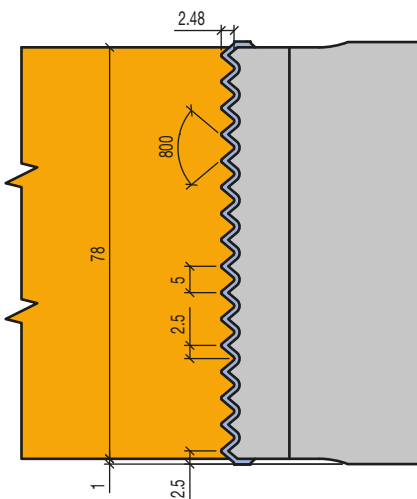
| D   | SB | BO | Z | ID       |
|-----|----|----|---|----------|
| mm  | mm | mm |   |          |
| 125 | 78 | 30 | 2 | 126097 ● |
| 125 | 78 | 50 | 2 | 126098 ● |

**Spare knives:**

| Part-no. | BEZ               | ABM         | QAL | ID     |
|----------|-------------------|-------------|-----|--------|
|          |                   | mm          |     |        |
| 1        | ProfilCut Q knife | 80.2x14x2.4 | MC  | 619523 |

**Spare parts:**

| Part-no. | BEZ                              | ABM        | ID       |
|----------|----------------------------------|------------|----------|
|          |                                  | mm         |          |
| 2        | Clamping wedge profiled          | 78x20x8.27 | 629214   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5    | 007442 ● |
| 4        | Torx® key                        | Torx® 25   | 117504 ● |

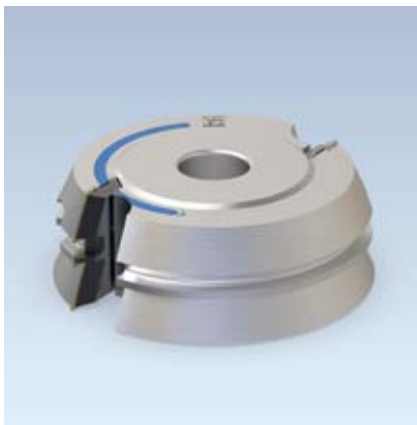


Tool stackable

## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.2 Mitre joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

**Application:**

For glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood, veneered panel materials.

**Technical information:**

Wood thickness 15 to 48 mm; basic clearance 0.3 mm, side clearance 0.1 mm. Economic wood use due to small profile depth.



**Profile depth 6.4 mm**

WE 600 1 53

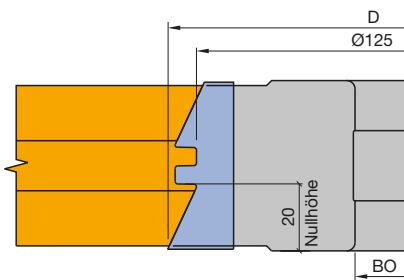
| D   | SB | BO | BO <sub>max</sub> | Z | n                 | ID            |
|-----|----|----|-------------------|---|-------------------|---------------|
| mm  | mm | mm | mm                |   | min <sup>-1</sup> |               |
| 142 | 50 | 30 | 50                | 2 | 5500 - 9400       | <b>125129</b> |

**Spare knives:**

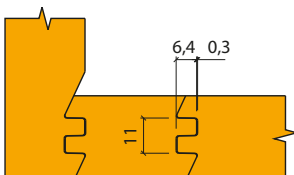
| Part-no. | BEZ               | ABM     | QAL | ID            |
|----------|-------------------|---------|-----|---------------|
|          |                   | mm      |     |               |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | <b>619238</b> |

**Spare parts:**

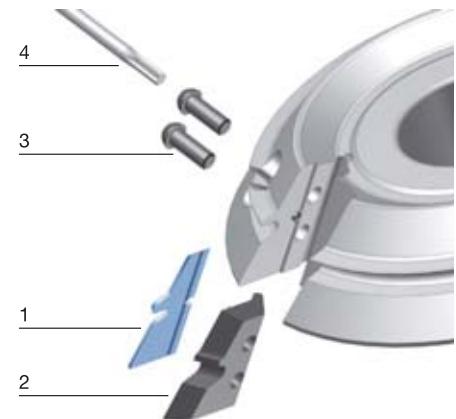
| Part-no. | BEZ                              | ABM           | ID              |
|----------|----------------------------------|---------------|-----------------|
|          |                                  | mm            |                 |
| 2        | Clamping wedge profiled          | 48x31.93x8.27 | <b>629223</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5       | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25      | <b>117504 ●</b> |



Adjustment scheme



Profile example



## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.2 Mitre joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

##### Application:

For 45° glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood, veneered panel materials.

##### Technical information:

Not suitable for melamine or paper coated panel materials.



##### Profile cutterhead ProfilCut Q 45°

WE 610 1 53

| D   | SB | HD | BO | Z | BO <sub>max</sub> | n                 | ID              |
|-----|----|----|----|---|-------------------|-------------------|-----------------|
| mm  | mm | mm | mm |   | mm                | min <sup>-1</sup> |                 |
| 175 | 40 | 28 | 30 | 2 | 50                | 4400 - 7600       | <b>125130</b> ● |
| 175 | 40 | 28 | 50 | 2 | 50                | 4400 - 7600       | <b>125131</b> □ |

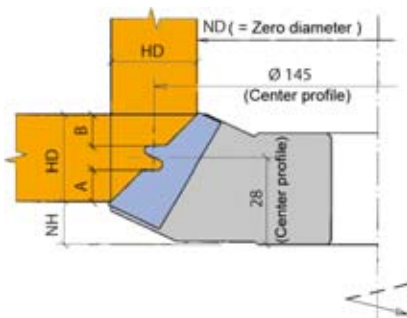
##### Profile adjustment

Height adjustment by profiling the workpiece flat on the table and vertical against the fence:

Profile height: PH 8.00 mm

Correct adjustment, if dimension A is the same as dimension B.

Formula:  $A(B) = (HD - PH) / 2$



$$0\text{-height (NH)} = 28 - \frac{\text{wood thickness (HD)}}{2}$$

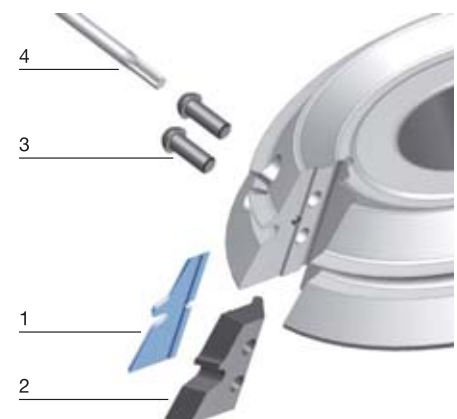
$$0\text{-diameter (ND)} = \text{Ø } 145 - \text{wood thickness (HD)}$$

##### Spare knives:

| Part-no. | BEZ               | ABM     | QAL | ID              |
|----------|-------------------|---------|-----|-----------------|
|          |                   | mm      |     |                 |
| 1        | ProfilCut Q knife | 40x22x2 | MC  | <b>619239</b> ● |

##### Spare parts:

| Part-no. | BEZ                              | ABM           | ID              |
|----------|----------------------------------|---------------|-----------------|
|          |                                  | mm            |                 |
| 2        | Clamping wedge profiled          | 38x32.11x8.27 | <b>629224</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5       | <b>007442</b> ● |
| 4        | Torx® key                        | Torx® 25      | <b>117504</b> ● |



## 4. Manual feed

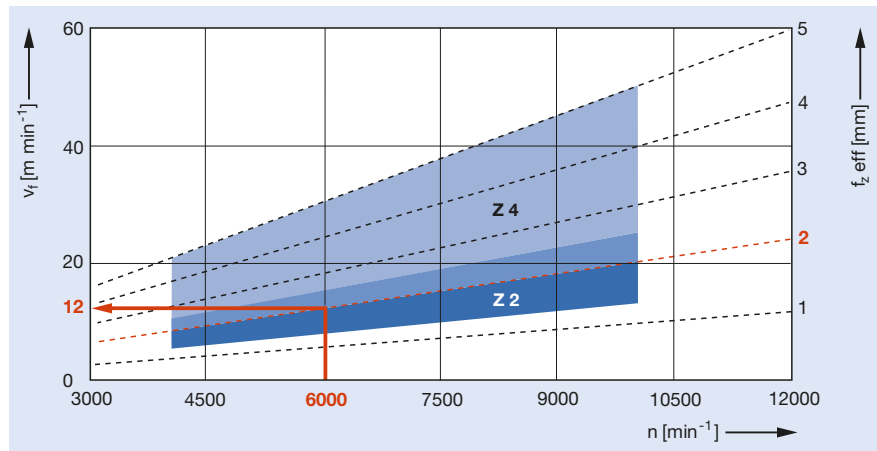
### 4.4 Profiling

#### 4.4.1 – 4.4.6 Different profile cutterheads

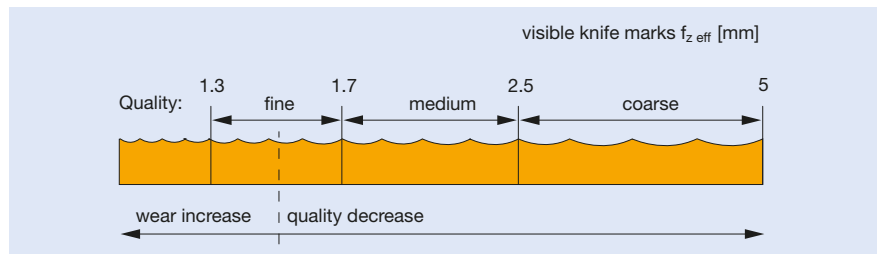
##### Type of operation

Profiling in craft and industry. As there are many different applications, the features of the tool and the wood types to be processed are described in the respective product pages.

##### Feed speeds depending on RPM, length of knife marks and number of teeth



##### Relation between surface quality and length of knife marks $f_{z \text{ eff}}$



With multi blade tools, only the marks of one knife show on the surface (one knife finish).

Z 2 and Z 4 tools produce the same surface quality with the same machine setting. High numbers of teeth are required for a high hogging performance.

##### Workpiece material Machines Application

Please refer to the relevant product pages, depending on the operation and profile.



### Turnblade ProfilCut Q profile cutterhead set for internal door production

#### Application:

For external door profiles with single rebate, rebating depth 13/15/18 mm. Extendable for double rebate 12/15 and 15/15.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Combinable for front door, single and double rebate. Double rebate profiles by using additional tools. Tool body of aluminium. ProfilCut jointing cutterhead with chamfers to edges, rebate cutterhead with turnblade knives, spurs and seatings for edge knives and seal groove knives.

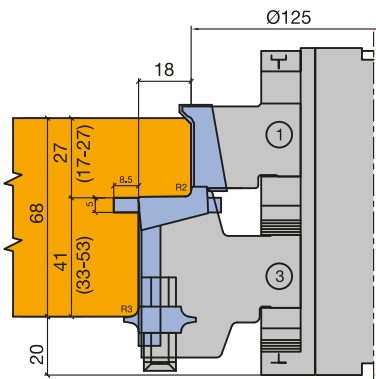
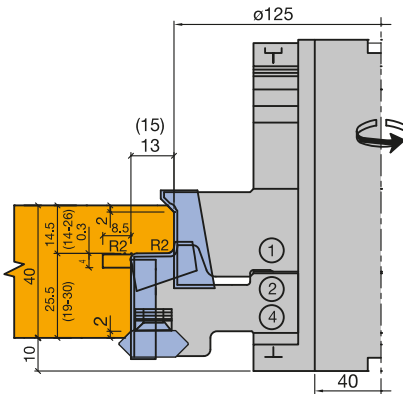


#### Turnblade / profile cutterhead set

SE 540 1 53

| BEM           | Tool no. | D <sub>0</sub><br>mm | BO<br>mm | Z | FAT<br>mm | n <sub>max</sub><br>min <sup>-1</sup> | ID            |
|---------------|----------|----------------------|----------|---|-----------|---------------------------------------|---------------|
| Single rebate | 1/2      | 125                  | 40       | 2 | 13        | 7200                                  | <b>126051</b> |
| Single rebate | 1/4      | 125                  | 40       | 2 | 15        | 7200                                  | <b>126052</b> |
| Single rebate | 1/3      | 125                  | 40       | 2 | 18        | 7200                                  | <b>126053</b> |
| Double rebate | 1/4/5    | 125                  | 40       | 2 | 15/12     | 7200                                  | <b>126054</b> |
| Double rebate | 1/4/6    | 125                  | 40       | 2 | 15/15     | 7200                                  | <b>126055</b> |

Set completely mounted on VDS-sleeve.



#### Single tools

TB 100 0 01, WE 500 1 53

| BEZ                            | ABM<br>mm          | Tool no. | Z | ID              |
|--------------------------------|--------------------|----------|---|-----------------|
| ProfilCut Q tool               | 133x30x50          | 1        | 2 | <b>125132</b>   |
| ProfilCut Q tool               | 151.2x35x50        | 2        | 2 | <b>125133</b>   |
| ProfilCut Q tool               | 161.2x54.5/58.5x50 | 3        | 2 | <b>125134</b>   |
| ProfilCut Q tool               | 155.2x35x50        | 4        | 2 | <b>125135</b>   |
| ProfilCut Q tool               | 179.2x35x50        | 5        | 2 | <b>125136</b>   |
| ProfilCut Q tool               | 185.2x35x50        | 6        | 2 | <b>125137</b>   |
| Reducing sleeve without collar | 40x96x30           |          |   | <b>028302 ●</b> |

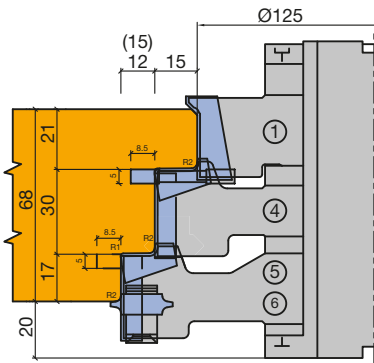
#### Spare knives:

| BEZ                          | ABM<br>mm    | Tool no. | QAL   | ID              |
|------------------------------|--------------|----------|-------|-----------------|
| ProfilCut Q knife            | 30.2x14.1x2  | 1        | MC    | <b>619240</b>   |
| ProfilCut Q knife            | 20.1x12.62x2 | 2        | MC    | <b>413043</b>   |
| ProfilCut Q knife            | 25x12.76x2   | 3        | MC    | <b>413017</b>   |
| ProfilCut Q knife            | 20.1x12.61x2 | 4        | MC    | <b>413045</b>   |
| ProfilCut Q knife            | 20.1x11.89x2 | 5        | MC    | <b>413011</b>   |
| ProfilCut Q knife            | 20.1x12.9x2  | 6        | MC    | <b>413015</b>   |
| Turnblade knife              | 30x8x1.5     | 2/4/5/6  | HW-05 | <b>005059 ●</b> |
| Edging knife 45°             | KM 21/0      | 2/4      | HW-F  | <b>008292 ●</b> |
| Edging knife R2              | KM 22/3      | 5/6      | HW-F  | <b>008309 ●</b> |
| Edging knife R3              | KM 22/0      | 3        | HW-F  | <b>008293 ●</b> |
| Turnblade grooving knife NB4 | 36x20x4      | 2/4      | HW-F  | <b>008323 ●</b> |
| Turnblade grooving knife NB5 | 36x20x5      | 2 - 6    | HW-F  | <b>008324 ●</b> |

## 4. Manual feed

### 4.4 Profiling

#### 4.4.1 Door rebate - cutterhead sets



#### Spare parts:

| BEZ                              | ABM           | Tool no. | ID       |
|----------------------------------|---------------|----------|----------|
|                                  | mm            |          |          |
| Clamping wedge ProfilCut Q       | 28x20x8.27    | 1        | 629208   |
| Clamping wedge ProfilCut Q       | 17x21.22x7.25 | 2/4/6    | 629267   |
| Clamping wedge                   | 28x18.75x8.27 | 2/4/5/6  | 009673 ● |
| Clamping wedge ProfilCut Q       | 22x21.11x7.25 | 3        | 629227   |
| Clamping wedge                   | 48x18.75x8.27 | 3        | 009677 ● |
| Clamping wedge ProfilCut Q       | 17x20x7.25    | 5        | 629226   |
| Clamping screw w. disc, Torx® 25 | M6x18.5       | 1 - 6    | 007442 ● |
| Countersink screw, Torx® 20      | M6x20         | 2/4      | 006087 ● |
| Countersink screw, Torx® 20      | M6x40         | 3        | 006090 ● |
| Countersink screw, Torx® 20      | M6x25         | 5/6      | 006088 ● |
| Countersink screw, Torx® 20      | M6x12         | 2 - 6    | 006084 ● |
| Cylindrical screw with ISK       | M6x93         |          | 007834 ● |
| Torx® key                        | Torx® 25      | 1 - 6    | 117504 ● |
| Torx® key                        | Torx® 20      | 1 - 6    | 117503 ● |
| Allen key                        | SW 5          |          | 005452 ● |



R 1,5 = ID **619185**  
 R 2,0 = ID **619186**  
 R 3,0 = ID **619187**  
 R 4,0 = ID **619188**  
 R 5,0 = ID **619189**



ID **619190**



ID **619191**



ID **184008678**

Cut-out for DP edging knives on request



### Profile cutterhead ProfilCut Q

#### Application:

For door casing and door linings with 5 mm rebate.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood, uncoated, plastic coated and veneered chipboard and fibre materials.

#### Technical information:

Material thickness: 24 to 27 mm (option up to 32 mm with jointing). Seal 14 and 12 mm possible by fitting spacers. Adjustable rebate of 5 mm or 4 mm by changeable profile knives. Rebate 7 mm, 8 mm and 11 mm on request.



#### Rebate 5 mm

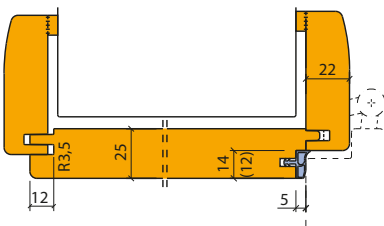
SE 640 1 53

| Tool Type                     | D<br>mm | BO<br>mm | BO <sub>max</sub><br>mm | Z | FAT<br>mm | n<br>min <sup>-1</sup> | ID              |
|-------------------------------|---------|----------|-------------------------|---|-----------|------------------------|-----------------|
| With jointing and rounding    | 125     | 30       | 50                      | 2 | 5         | 5100 - 8800            | <b>126056</b> ● |
| Without jointing and rounding | 125     | 30       | 50                      | 2 | 5         | 5100 - 8800            | <b>126057</b>   |

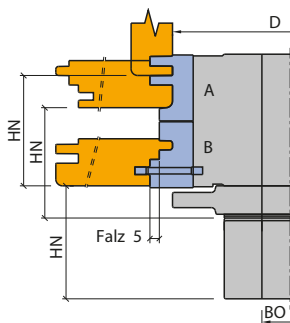
#### Rebate 4 mm

SE 640 1 53

| Tool Type                     | D<br>mm | BO<br>mm | BO <sub>max</sub><br>mm | Z | FAT<br>mm | n<br>min <sup>-1</sup> | ID            |
|-------------------------------|---------|----------|-------------------------|---|-----------|------------------------|---------------|
| With jointing and rounding    | 125     | 30       | 50                      | 2 | 4         | 5100 - 8800            | <b>126058</b> |
| Without jointing and rounding | 125     | 30       | 50                      | 2 | 4         | 5100 - 8800            | <b>126059</b> |



Door lining profile



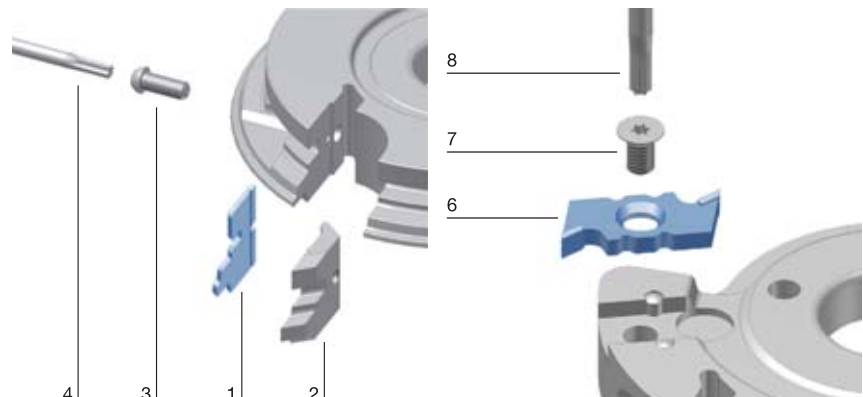
Lining/decorative panel and rebate lining

#### Spare knives:

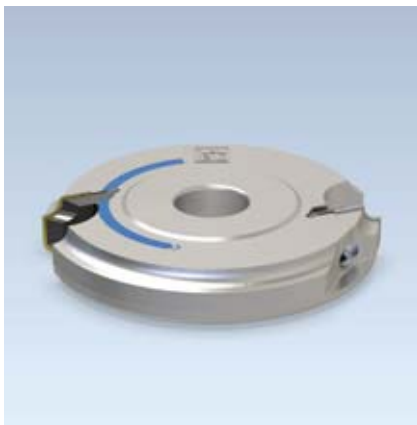
| Part-no. | BEZ                                  | ABM<br>mm  | QAL  | ID              |
|----------|--------------------------------------|------------|------|-----------------|
| 1        | ProfilCut Q knife A for jointing     | 35x22.75x2 | MC   | <b>619241</b>   |
| 1        | ProfilCut Q knife B 5 mm rebate      | 35x23.82x2 | MC   | <b>619242</b>   |
| 1        | ProfilCut Q knife A without jointing | 35x22.75x2 | MC   | <b>619243</b>   |
| 1        | ProfilCut Q knife B 4 mm rebate      | 35x23.29x2 | MC   | <b>619244</b>   |
| 6        | Turnblade grooving knife NB4         | 36x20x4    | HW-F | <b>008323</b> ● |

#### Spare parts:

| Part-no. | BEZ                              | ABM<br>mm     | ID              |
|----------|----------------------------------|---------------|-----------------|
| 2        | Clamping wedge A                 | 33x27.89x8.27 | <b>629229</b>   |
| 2        | Clamping wedge B                 | 33x32.72x2    | <b>629230</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5       | <b>007442</b> ● |
| 4        | Torx® key                        | Torx® 25      | <b>117504</b> ● |
| 7        | Countersink screw, Torx® 20      | M6x12         | <b>006084</b> ● |
| 8        | Torx® key                        | Torx® 20      | <b>117503</b> ● |







### Profile cutterhead ProfilCut Q

#### Application:

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Production of counter profile possible by combining with the fluting profile. Tool can be used on both sides as panel raising cutter (straight panel raising).



#### Radii profile R 2; 3; 5; 7 mm

WE 500 1 53

| D   | SB | BO | BO <sub>max</sub> | Z | R  | n                 | ID              |
|-----|----|----|-------------------|---|----|-------------------|-----------------|
| mm  | mm | mm | mm                |   | mm | min <sup>-1</sup> |                 |
| 139 | 25 | 30 | 50                | 2 | 5  | 5500 - 9600       | <b>125387 ●</b> |

#### Radii profile R 12; 15; 16; 18; 20 mm

WE 500 1 53

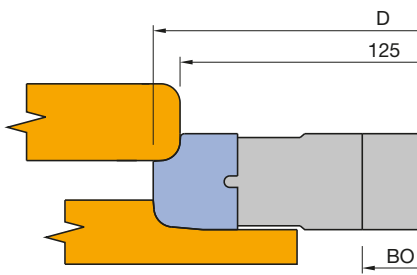
| D   | SB | BO | BO <sub>max</sub> | Z | R  | n                 | ID              |
|-----|----|----|-------------------|---|----|-------------------|-----------------|
| mm  | mm | mm | mm                |   | mm | min <sup>-1</sup> |                 |
| 167 | 40 | 30 | 50                | 2 | 12 | 4600 - 10200      | <b>125391 ●</b> |

#### Spare knives:

| Part-no. | BEZ               | ABM         | QAL | R  | ID            |
|----------|-------------------|-------------|-----|----|---------------|
|          |                   | mm          |     | mm |               |
| 1        | ProfilCut Q knife | 25x25x2.4   | MC  | 2  | <b>619504</b> |
| 1        | ProfilCut Q knife | 25x25x2.4   | MC  | 3  | <b>619505</b> |
| 1        | ProfilCut Q knife | 25x25x2.4   | MC  | 5  | <b>619501</b> |
| 1        | ProfilCut Q knife | 25x25x2.4   | MC  | 7  | <b>619502</b> |
| 1        | ProfilCut Q knife | 40x32.6x2.4 | MC  | 12 | <b>619516</b> |
| 1        | ProfilCut Q knife | 40x32.6x2.4 | MC  | 15 | <b>619517</b> |
| 1        | ProfilCut Q knife | 40x32.6x2.4 | MC  | 16 | <b>619518</b> |
| 1        | ProfilCut Q knife | 40x32.6x2.4 | MC  | 18 | <b>619519</b> |
| 1        | ProfilCut Q knife | 40x32.6x2.4 | MC  | 20 | <b>619520</b> |

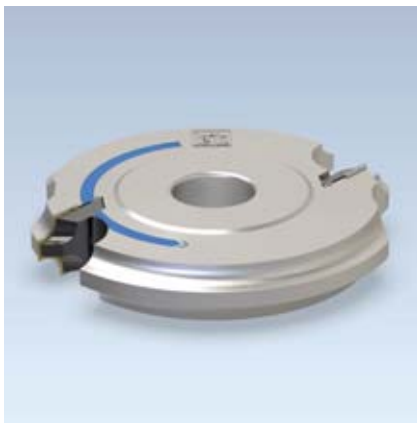
#### Spare parts:

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge profiled          | 23x35.5x8.27 | <b>629458</b>   |
| 2        | Clamping wedge profiled          | 38x43x8.27   | <b>629460</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25     | <b>117504 ●</b> |



Radii profile cutterhead





### Profile cutterhead set ProfilCut Q - radii profile

#### Application:

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutterhead with changing knives R 5/8, R 6/9, R 7/10, R 3/12, bevelling knives 30/45/60° and axially parallel knives. For cutting radii and dowel profiles as well as bevelling and copy-shaping of curved workpieces using templates.



#### Radii profile R 5 - 12 mm or 30/45/60° bevel

AE 540 1 53

| exist. of          | D   | SB | BO | BO <sub>max</sub> | R         | Z | ID              |
|--------------------|-----|----|----|-------------------|-----------|---|-----------------|
|                    | mm  | mm | mm | mm                | mm        |   |                 |
| Profile cutterhead | 140 | 25 | 30 | 50                |           | 2 | <b>126546</b> ● |
| Radius knife       |     |    |    |                   | 5/8       |   |                 |
| Radius knife       |     |    |    |                   | 6/9       |   |                 |
| Radius knife       |     |    |    |                   | 7/10      |   |                 |
| Radius knife       |     |    |    |                   | 3/12      |   |                 |
| Bevel knife        |     |    |    |                   | 30/45/60° |   |                 |

Set completely in wooden box including radii/bevel knives.

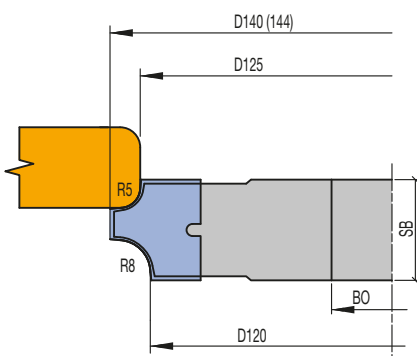
Standard values for feed speed  $v_f$  at speed  $n = 6000 \text{ min}^{-1}$ :

Machining along grain: 8 to 10  $\text{m min}^{-1}$ .

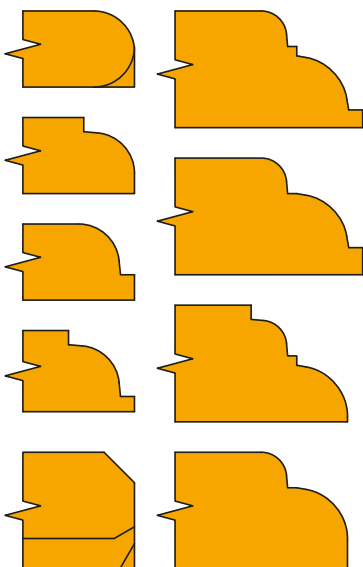
Machining across grain: 3 to 5  $\text{m min}^{-1}$ .

RPM:  $n = 5400 - 9200 \text{ min}^{-1}$

Zero diameter: 120/125 mm



Profile cutterhead D-140(144) mm



Left = 1 working step  
Right = 2 working steps

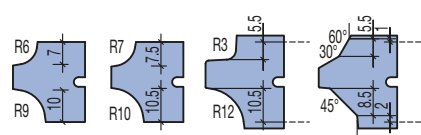
#### Spare knives:

| Part-no. | BEZ               | ABM        | QAL | R    | FAW       | ID            |
|----------|-------------------|------------|-----|------|-----------|---------------|
|          |                   | mm         |     | mm   | °         |               |
| 1        | ProfilCut Q knife | 25x22x2    | MC  | 5/8  |           | <b>619445</b> |
| 1        | ProfilCut Q knife | 25x22x2    | MC  | 6/9  |           | <b>619446</b> |
| 1        | ProfilCut Q knife | 25x22x2    | MC  | 7/10 |           | <b>619447</b> |
| 1        | ProfilCut Q knife | 29x24.17x2 | MC  | 3/12 |           | <b>619448</b> |
| 1        | ProfilCut Q knife | 29x24.17x2 | MC  |      | 30/45/60° | <b>619449</b> |

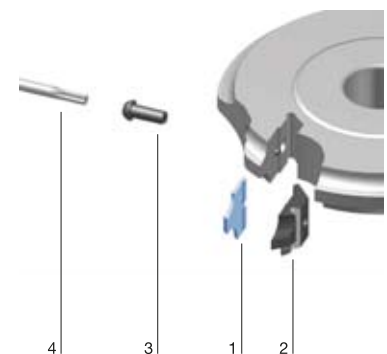
#### Spare parts:

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge                   | 23x32.5x8.27 | <b>629286</b> ● |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442</b> ● |
| 4        | Torx® key                        | Torx® 25     | <b>117504</b> ● |

Ball bearing and guide rings - see Lexicon section Knives and Spare Parts.

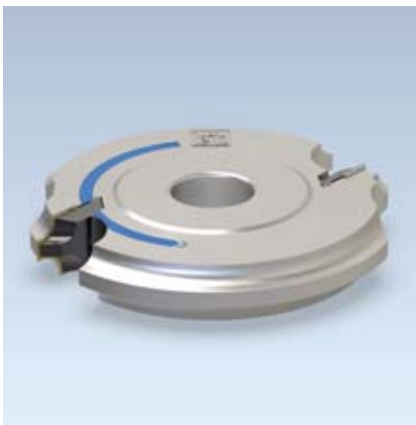


Profile knives radius / bevel



## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads



#### Profile cutterhead ProfilCut Q

**Application:**

For radii and bevel profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutterhead with change knives and straight cut. Multi-purpose application for different profiles.



**Radii profile R 12 - 20 mm or 45° bevel**

WE 500 1 53

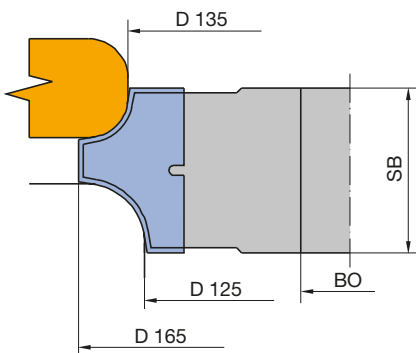
| D   | SB | BO | BO <sub>max</sub> | Z | R     | n                 | ID              |
|-----|----|----|-------------------|---|-------|-------------------|-----------------|
| mm  | mm | mm | mm                |   | mm    | min <sup>-1</sup> |                 |
| 165 | 50 | 30 | 50                | 2 | 12/18 | 5500 - 5900       | <b>125388 ●</b> |

**Spare knives:**

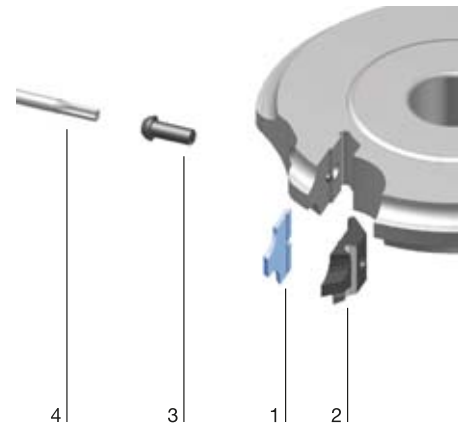
| Part-no. | BEZ               | ABM         | QAL | R     | FAW | ID            |
|----------|-------------------|-------------|-----|-------|-----|---------------|
|          |                   | mm          |     | mm    | °   |               |
| 1        | ProfilCut Q knife | 50x33.8x2.4 | MC  | 12/18 |     | <b>619512</b> |
| 1        | ProfilCut Q knife | 50x33.8x2.4 | MC  | 14/20 |     | <b>619513</b> |
| 1        | ProfilCut Q knife | 50x33.8x2.4 | MC  |       | 45  | <b>619514</b> |

**Spare parts:**

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge profiled          | 48x43.5x8.27 | <b>629099</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25     | <b>117504 ●</b> |

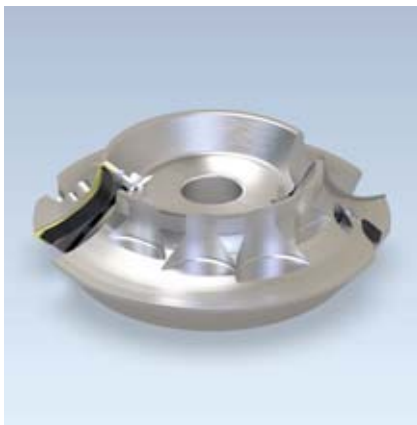


Profile cutterhead D-165 mm



## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads



#### Profile cutterhead ProfilCut Q

##### Application:

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Height and diameter adjustment through recess in the tool basic body per radius. Cutterhead extendable for radii R 12.5 - 30 mm. Replacement knives for dowel cuts on request.



##### Radii profile R 12.5 - 30 mm

WE 500 1 53

| D   | SB | BO | BO <sub>max</sub> | D <sub>0</sub> | Z | R  | n                 | ID       |
|-----|----|----|-------------------|----------------|---|----|-------------------|----------|
| mm  | mm | mm | mm                | mm             |   | mm | min <sup>-1</sup> |          |
| 180 | 32 | 30 | 50                | 112            | 2 | 30 | 4300 - 7400       | 125359 ● |

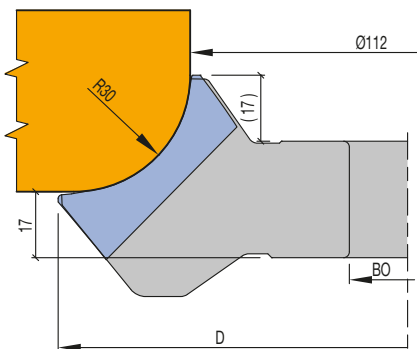
For ball bearings and guide rings see section Knives and Spare Parts.

Standard values for feed speed  $v_f$ :

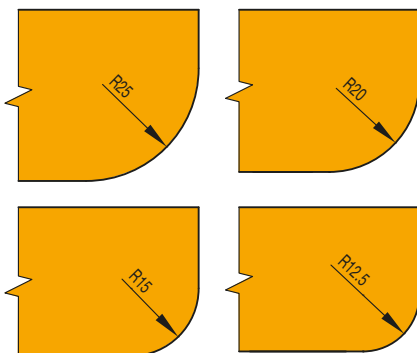
Machining along grain: 8 to 10 m min<sup>-1</sup>

Machining across grain: 3 to 5 m min<sup>-1</sup>

at speed  $n = 6000$  min<sup>-1</sup>.



Profile cutterhead D-180 mm



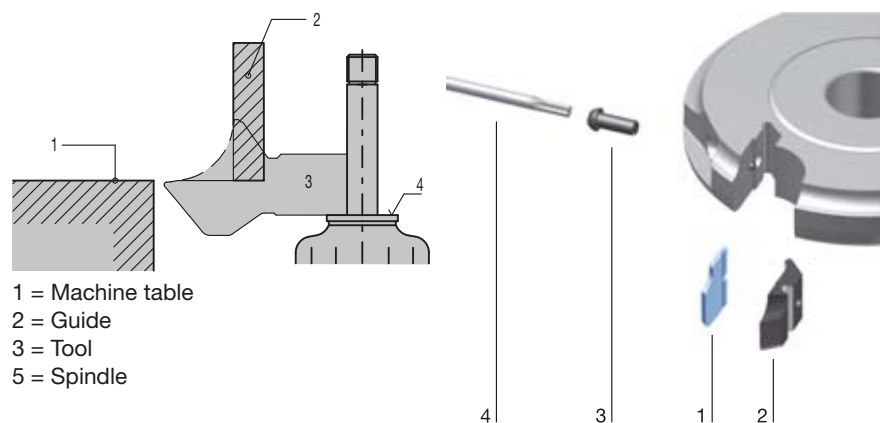
##### Spare knives:

| Part-no. | BEZ               | ABM     | QAL | R    | ID     |
|----------|-------------------|---------|-----|------|--------|
|          |                   | mm      |     | mm   |        |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | 12.5 | 619431 |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | 15   | 619432 |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | 20   | 619433 |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | 25   | 619434 |
| 1        | ProfilCut Q knife | 50x22x2 | MC  | 30   | 619430 |

##### Spare parts:

| Part-no. | BEZ                              | ABM        | ID       |
|----------|----------------------------------|------------|----------|
|          |                                  | mm         |          |
| 2        | Clamping wedge profiled          | 48x29x8.27 | 629284 □ |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5    | 007442 ● |
| 4        | Torx® key                        | Torx® 25   | 117504 ● |

Machine adjustment by recessing the tool.



- 1 = Machine table
- 2 = Guide
- 3 = Tool
- 5 = Spindle

## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads



#### Profile cutterhead ProfilCut Q

##### Application:

For different radii profiles with 10 different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Height and diameter adjustment through recess in the tool basic body per radius. Cutterhead extendable for radii R 30 - 50 mm. Replacement knives for dowel cuts on request.



##### Radii profile R 30 - 50 mm

AE 540 1 53

| D   | SB | BO | BO <sub>max</sub> | D <sub>0</sub> | Z | R  | n                 | ID              |
|-----|----|----|-------------------|----------------|---|----|-------------------|-----------------|
| mm  | mm | mm | mm                | mm             |   | mm | min <sup>-1</sup> |                 |
| 227 | 57 | 30 | 50                | 125            | 2 | 40 | 3400 - 7500       | <b>125360</b> ● |

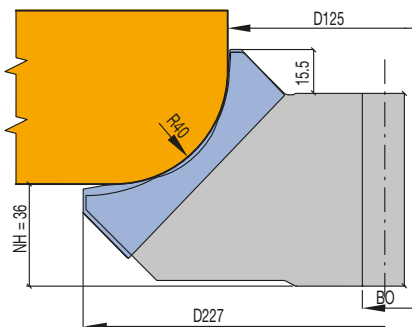
For ball bearings and guide rings see section Knives and Spare Parts.

##### Spare knives:

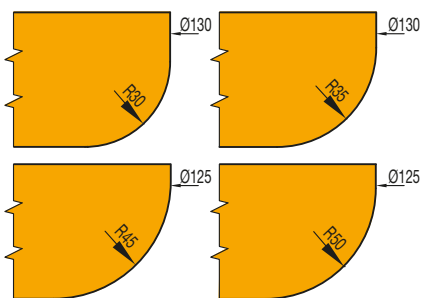
| Part-no. | BEZ               | ABM<br>mm    | QAL | R<br>mm | ID<br>with relief<br>angle | ID<br>without<br>relief<br>angle |
|----------|-------------------|--------------|-----|---------|----------------------------|----------------------------------|
| 1        | ProfilCut Q knife | 80.1x30.78x2 | MC  | 30      | <b>619436</b>              | <b>619440</b>                    |
| 1        | ProfilCut Q knife | 80.1x30.56x2 | MC  | 35      | <b>619437</b>              | <b>619441</b>                    |
| 1        | ProfilCut Q knife | 80.1x31.08x2 | MC  | 40      | <b>619435</b>              | <b>619442</b>                    |
| 1        | ProfilCut Q knife | 80.1x29.98x2 | MC  | 45      | <b>619438</b>              | <b>619443</b>                    |
| 1        | ProfilCut Q knife | 80.1x29.56x2 | MC  | 50      | <b>619439</b>              |                                  |
| 1        | ProfilCut Q knife | 80.1x29.66x2 | MC  | 50      |                            | <b>619444</b>                    |

##### Spare parts:

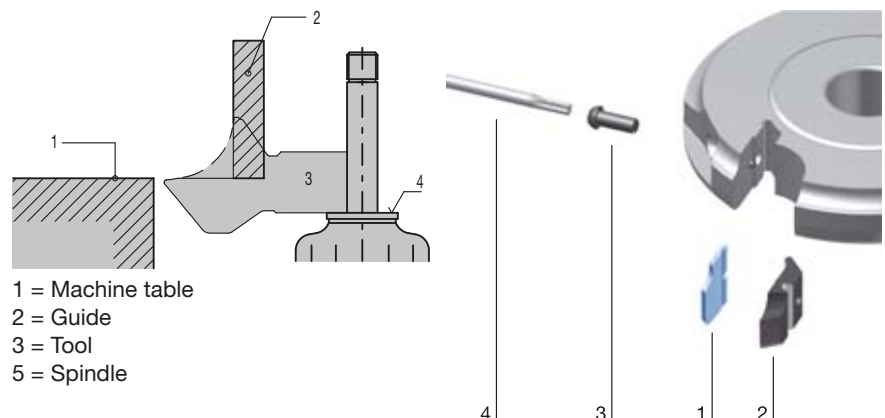
| Part-no. | BEZ                              | ABM<br>mm  | ID              |
|----------|----------------------------------|------------|-----------------|
| 2        | Clamping wedge ProfilCut         | 78x39x8.27 | <b>629285</b> □ |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5    | <b>007442</b> ● |
| 4        | Torx® key                        | Torx® 25   | <b>117504</b> ● |



Profile cutterhead D-227 mm



Machine adjustment by recessing the tool.



- 1 = Machine table
- 2 = Guide
- 3 = Tool
- 5 = Spindle



### Profile cutterhead ProfilCut Q

**Application:**

For radii and counter profiles. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders etc.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutterhead with change knives, straight cut. Multi-purpose use for different profiles in one or several working steps.



**Radii profile R 3 - 10 mm**

WE 500 1 53

| D   | SB | BO | BO <sub>max</sub> | Z | n                 | ID              |
|-----|----|----|-------------------|---|-------------------|-----------------|
| mm  | mm | mm | mm                |   | min <sup>-1</sup> |                 |
| 132 | 40 | 30 | 40                | 2 | 5900 - 10100      | <b>125389 •</b> |

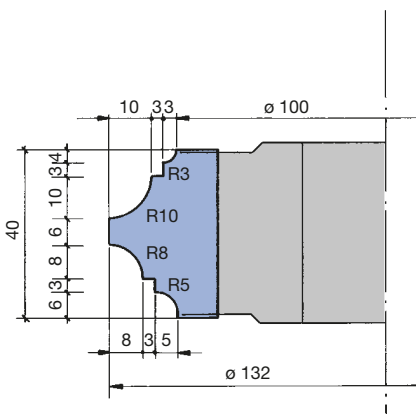
Standard values for feed speed  $v_f$ :

Machining along grain: 8 to 10 m min<sup>-1</sup>

Machining across grain: 3 to 5 m min<sup>-1</sup>

at speed  $n = 6000$  min<sup>-1</sup>

For ball bearings and guide rings see section Knives and Spare Parts.

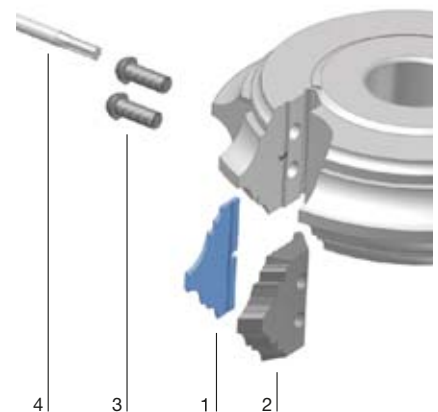


**Spare knives:**

| Part-no. | BEZ               | ABM           | QAL | ID            |
|----------|-------------------|---------------|-----|---------------|
|          |                   | mm            |     |               |
| 1        | ProfilCut Q knife | 40.2x28.5x2.4 | MC  | <b>619515</b> |

**Spare parts:**

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge profiled          | 38x34.5x8.27 | <b>629459</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442 •</b> |
| 4        | Torx® key                        | Torx® 25     | <b>117504 •</b> |





### Profile cutterhead set ProfilCut Q - bevelling / rounding

#### Application:

Multi-purpose tool set for bevelling, rounding and jointing the workpiece edges at the same time.

#### Machine:

Spindle moulders, copy shaping and profile moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

With a combination of jointing and bevelling/rounding cutterheads, different profiles and wood thicknesses can be machined. Profile knives with different radii/bevels can be mounted in one cutterhead.



#### Manual feed

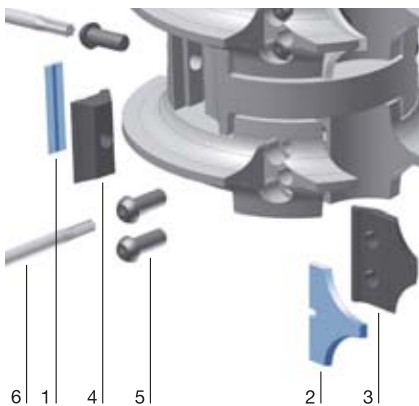
SE 541 1 53

| Tool Type                  | D <sub>0</sub><br>mm | AW<br>PCS | n<br>min <sup>-1</sup> | Z | ID            |
|----------------------------|----------------------|-----------|------------------------|---|---------------|
| Jointing-rounding          | 125                  | 2         | 4200 - 7100            | 2 | <b>126060</b> |
| Rounding-jointing-rounding | 125                  | 3         | 4200 - 7100            | 2 | <b>126061</b> |
| Rounding-rounding          | 125                  | 2         | 4200 - 7100            | 2 | <b>126062</b> |

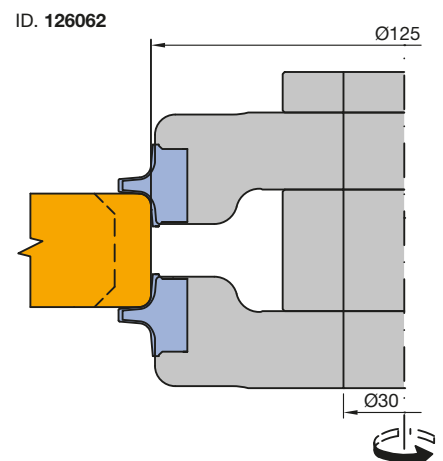
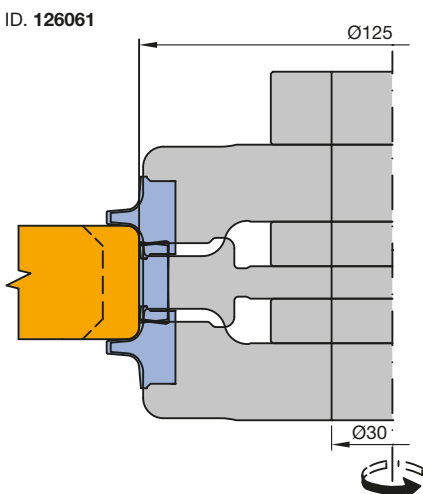
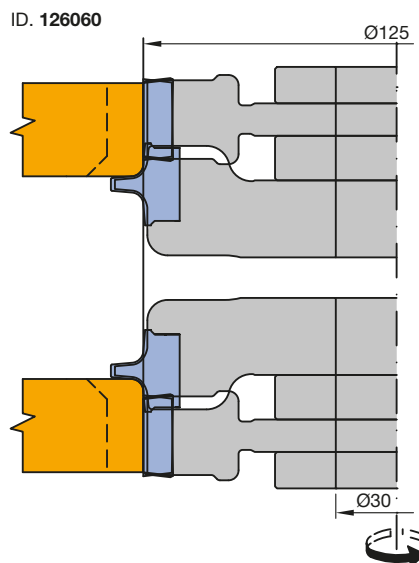
Further radii are available at short notice.

#### Spare parts:

| Part-no. | BEZ                                 | ABM<br>mm     | Tool no.  | ID              |
|----------|-------------------------------------|---------------|-----------|-----------------|
| 3        | Clamping wedge                      | 18x22x8.27    | 1/2/11/12 | <b>629231</b>   |
| 3        | Clamping wedge                      | 33x28x8.27    | 3/4/13/14 | <b>629232</b>   |
| 3        | Clamping wedge                      | 38x29.71x8.27 | 5/15      | <b>629233</b>   |
| 3        | Clamping wedge                      | 38x29.71x8.27 | 6/16      | <b>629234</b>   |
| 3        | Clamping wedge                      | 48x31.73x8.27 | 7/17      | <b>629235</b>   |
| 3        | Clamping wedge                      | 48x31.73x8.27 | 8/18      | <b>629236</b>   |
| 4        | Clamping wedge                      | 18x18.75x8.27 | 20        | <b>009671</b> ● |
| 4        | Clamping wedge                      | 33x18.75x8.27 | 35        | <b>009674</b> ● |
| 4        | Clamping wedge                      | 48x18.75x8.27 | 50        | <b>009677</b> ● |
| 5        | Clamping screw w.<br>disc, Torx® 25 | M6x18.5       |           | <b>007442</b> ● |
| 6        | Torx® key                           | Torx® 25      |           | <b>117504</b> ● |



Part nos. 1 and 2 - ProfilCut Q and turnblade knives - see detailed information on the following pages.

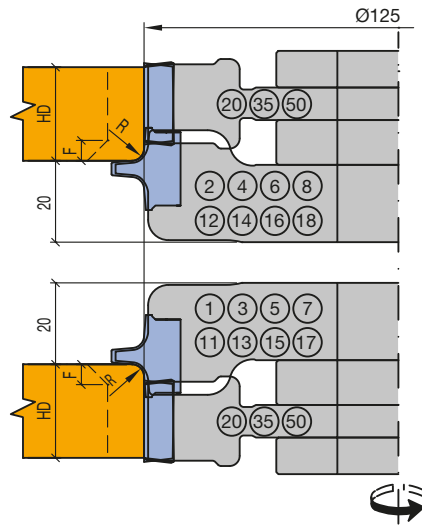


## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads

#### ID. 126060

Order example:  
 -Combination ID 126060  
 -Profile description top down RL  
 jointingSB35/R5 or R5/jointingSB35  
 -Bore diameter 30



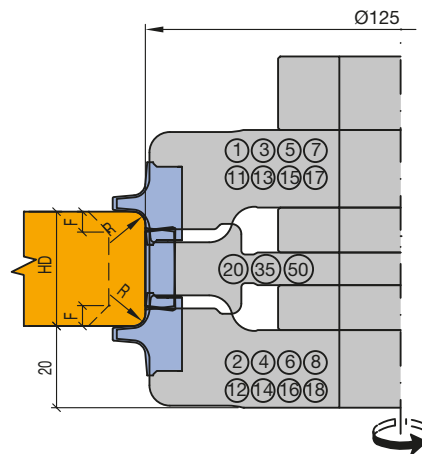
Wood thickness (HD):

| Jointing tool | 20       | 35       | 50       |
|---------------|----------|----------|----------|
| max. HD       | 18+R (F) | 33+R (F) | 48+R (F) |

F (bevel) max. = 3, 5, 7x45° or 8x40°

#### ID. 126061

Order example:  
 -Combination ID 126061  
 -Profile description top down RL  
 R5/jointingSB35/R5  
 -Bore diameter 30



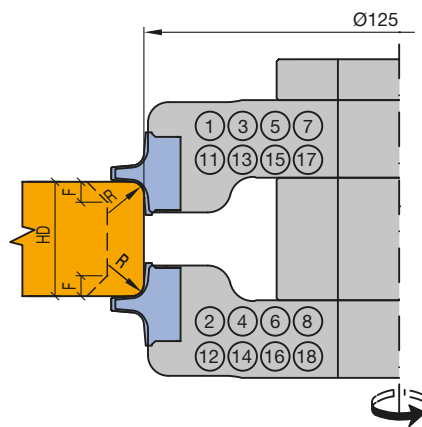
| Radii tools    | Jointing tool   |                 |                 |
|----------------|-----------------|-----------------|-----------------|
|                | 20              | 35              | 50              |
| No.1(11)+2(12) | 6               | 12              | 24              |
| No.1(11)+4(14) | 13              | 19              | 31              |
| No.1(11)+6(16) | 18              | 24              | 36              |
| No.1(11)+8(18) | 28              | 34              | 46              |
| No.3(13)+2(12) | 13              | 19              | 31              |
| No.3(13)+4(14) | 20              | 26              | 38              |
| No.3(13)+6(16) | 25              | 31              | 43              |
| No.3(13)+8(18) | 35              | 41              | 53              |
| No.5(15)+2(12) | 18              | 24              | 36              |
| No.5(15)+4(14) | 25              | 31              | 43              |
| No.5(15)+6(16) | 30              | 36              | 48              |
| No.5(15)+8(18) | 40              | 46              | 58              |
| No.7(17)+2(12) | 28              | 34              | 46              |
| No.7(17)+4(14) | 35              | 41              | 53              |
| No.7(17)+6(16) | 40              | 46              | 58              |
| No.7(17)+8(18) | 50              | 56              | 68              |
| max. HD        | 18+R+R<br>(F+F) | 33+R+R<br>(F+F) | 48+R+R<br>(F+F) |

Minimum wood thickness

F (bevel) max. = 3, 5, 7x45° or 8x40°  
 Wood thicknesses are calculated with max. bevel

#### ID. 126062

Order example:  
 -Combination ID 126062  
 -Profile description top down RL  
 R5/R5  
 -Bore diameter 30



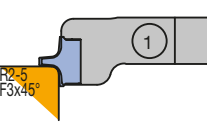
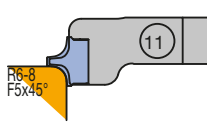
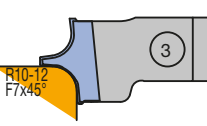
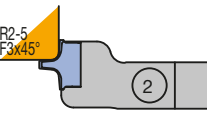
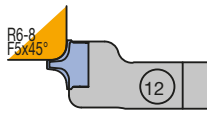
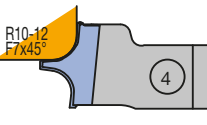
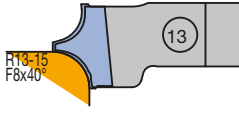
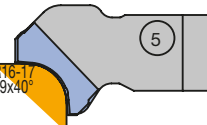
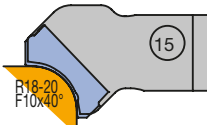
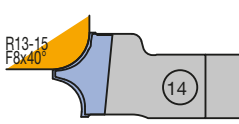
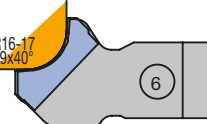
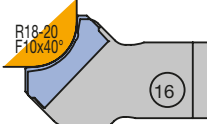
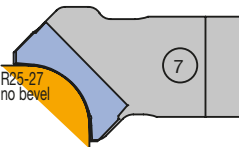
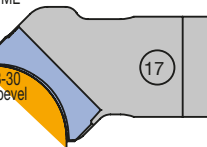
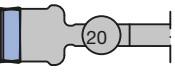
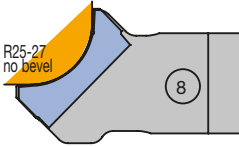
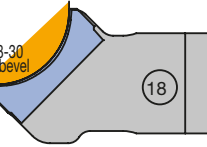
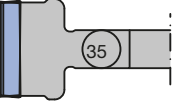
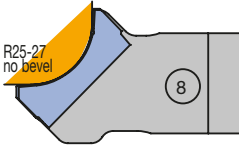
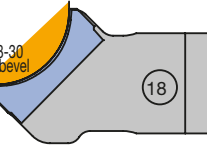
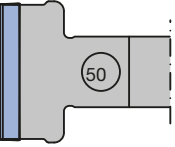

| Radii tools    |    |
|----------------|----|
| No.1(11)+2(12) | -2 |
| No.1(11)+4(14) | 5  |
| No.1(11)+6(16) | 10 |
| No.1(11)+8(18) | 20 |
| No.3(13)+2(12) | 5  |
| No.3(13)+4(14) | 12 |
| No.3(13)+6(16) | 17 |
| No.3(13)+8(18) | 27 |
| No.5(15)+2(12) | 10 |
| No.5(15)+4(14) | 17 |
| No.5(15)+6(16) | 22 |
| No.5(15)+8(18) | 32 |
| No.7(17)+2(12) | 20 |
| No.7(17)+4(14) | 27 |
| No.7(17)+6(16) | 32 |
| No.7(17)+8(18) | 42 |

Minimum wood thickness



## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads

|  |  |  |
|--|--|--|
| <p>Spare part:<br/>clamping wedge 629231</p>  <p>WZ 125138<br/>ME 619246 R3</p> <p>WZ 125139<br/>ME 619247 R4</p> <p>WZ 125140<br/>ME 619248 R5</p> <p>WZ 125375<br/>ME 619245 R2</p> <p>WZ 125141<br/>ME 619252 F3x45°</p> | <p>Spare part:<br/>clamping wedge 629231</p>  <p>WZ 125146<br/>ME 619249 R6</p> <p>WZ 125147<br/>ME 619250 R7</p> <p>WZ 125148<br/>ME 619251 R8</p> <p>WZ 125149<br/>ME 619253 F5x45°</p> | <p>Spare part:<br/>clamping wedge 629232</p>  <p>WZ 125154<br/>ME 619254 R10</p> <p>WZ 125155<br/>ME 619255 R11</p> <p>WZ 125156<br/>ME 619256 R12</p> <p>WZ 125157<br/>ME 619261 F7x45°</p>    |
| <p>Spare part:<br/>clamping wedge 629231</p>  <p>WZ 125142<br/>ME 619246 R3</p> <p>WZ 125143<br/>ME 619247 R4</p> <p>WZ 125144<br/>ME 619248 R5</p> <p>WZ 125376<br/>ME 619245 R2</p> <p>WZ 125145<br/>ME 619252 F3x45°</p> | <p>Spare part:<br/>clamping wedge 629231</p>  <p>WZ 125150<br/>ME 619249 R6</p> <p>WZ 125151<br/>ME 619250 R7</p> <p>WZ 125152<br/>ME 619251 R8</p> <p>WZ 125153<br/>ME 619253 F5x45°</p> | <p>Spare part:<br/>clamping wedge 629232</p>  <p>WZ 125158<br/>ME 619254 R10</p> <p>WZ 125159<br/>ME 619255 R11</p> <p>WZ 125160<br/>ME 619256 R12</p> <p>WZ 125161<br/>ME 619261 F7x45°</p>    |
| <p>Spare part:<br/>clamping wedge 629232</p>  <p>WZ 125162<br/>ME 619257 R13</p> <p>WZ 125163<br/>ME 619258 R14</p> <p>WZ 125164<br/>ME 619259 R15</p> <p>WZ 125165<br/>ME 619262 F8x40°</p>                               | <p>Spare part:<br/>clamping wedge 629233</p>  <p>WZ 125170<br/>ME 619263 R16</p> <p>WZ 125171<br/>ME 619264 R17</p> <p>WZ 125172<br/>ME 619269 F9x40°</p>                                | <p>Spare part:<br/>clamping wedge 629233</p>  <p>WZ 125176<br/>ME 619265 R18</p> <p>WZ 125177<br/>ME 619266 R19</p> <p>WZ 125178<br/>ME 619267 R20</p> <p>WZ 125179<br/>ME 619270 F10x40°</p>  |
| <p>Spare part:<br/>clamping wedge 629232</p>  <p>WZ 125166<br/>ME 619257 R13</p> <p>WZ 125167<br/>ME 619258 R14</p> <p>WZ 125168<br/>ME 619259 R15</p> <p>WZ 125169<br/>ME 619262 F8x40°</p>                              | <p>Spare part:<br/>clamping wedge 629234</p>  <p>WZ 125173<br/>ME 619271 R16</p> <p>WZ 125174<br/>ME 619272 R17</p> <p>WZ 125175<br/>ME 619277 F9x40°</p>                               | <p>Spare part:<br/>clamping wedge 629234</p>  <p>WZ 125180<br/>ME 619273 R18</p> <p>WZ 125181<br/>ME 619274 R19</p> <p>WZ 125182<br/>ME 619275 R20</p> <p>WZ 125183<br/>ME 619278 F10x40°</p> |
| <p>Spare part:<br/>clamping wedge 629235</p>  <p>WZ 125184<br/>ME 619279 R25</p> <p>WZ 125185<br/>ME 619280 R26</p> <p>WZ 125186<br/>ME 619281 R27</p>  | <p>Spare part:<br/>clamping wedge 629235</p>  <p>WZ 125190<br/>ME 619282 R28</p> <p>WZ 125191<br/>ME 619283 R29</p> <p>WZ 125192<br/>ME 619284 R30</p>                                  | <p>SB 20</p>  <p>WZ 23015<br/>ME 5071<br/>VE 10 pcs.)<br/>Wedge 9671</p>  |
| <p>Spare part:<br/>clamping wedge 629236</p>  <p>WZ 125187<br/>ME 619285 R25</p> <p>WZ 125188<br/>ME 619286 R26</p> <p>WZ 125189<br/>ME 619287 R27</p>  | <p>Spare part:<br/>clamping wedge 629236</p>  <p>WZ 125193<br/>ME 619288 R28</p> <p>WZ 125194<br/>ME 619289 R29</p> <p>WZ 125195<br/>ME 619290 R30</p>                                  | <p>SB 35</p>  <p>WZ 23016<br/>ME 5073<br/>VE 10 pcs.)<br/>Wedge 9674</p>  |
| <p>Spare part:<br/>clamping wedge 629236</p>  <p>WZ 125187<br/>ME 619285 R25</p> <p>WZ 125188<br/>ME 619286 R26</p> <p>WZ 125189<br/>ME 619287 R27</p>  | <p>Spare part:<br/>clamping wedge 629236</p>  <p>WZ 125193<br/>ME 619288 R28</p> <p>WZ 125194<br/>ME 619289 R29</p> <p>WZ 125195<br/>ME 619290 R30</p>                                  | <p>SB 50</p>  <p>WZ 23017<br/>ME 5075<br/>VE 10 pcs.)<br/>Wedge 9677</p>  |
| <p>Spacer set<br/>(one set per cutterhead necessary)</p>  <p>60x20x30</p>   |  |  |



### Profile cutterhead ProfilCut Q for internal doors

**Application:**

For internal door profiles and counter profiles.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutterhead with change knives, straight cut.

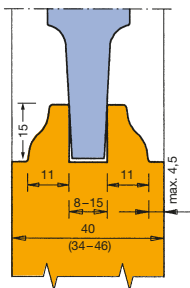
**Tool combination DOUBLE profile with jointing**

AE 341 1 53, AW 341 1

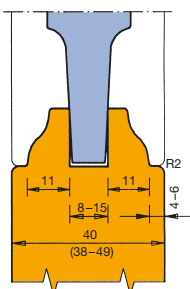


| Tool Type                            | Tool no.      | BO<br>mm | BO <sub>max</sub><br>mm | ID              |
|--------------------------------------|---------------|----------|-------------------------|-----------------|
| Profile 1 (P2-P5 on request)         | 1/2/3         | 30       | 50                      | <b>126532</b> ● |
| Profile 1.1 (P2.1-P5.1 on request)   | 1/2/3/4/5     | 30       | 50                      | <b>126533</b>   |
| Profile 6/7                          | 2/4/5/6/7     | 30       | 50                      | <b>126534</b>   |
| Profile 6.1/7                        | 2/4.1/5.1/6/7 | 30       | 50                      | <b>126535</b>   |
| Profile 8                            | 2/8/9/10      | 30       | 50                      | <b>126536</b>   |
| Profile 8.1                          | 2/8.1/9.1/10  | 30       | 50                      | <b>126537</b>   |
| Addition for rebates and/or one side | 15/16         | 30       | 50                      | <b>126538</b>   |

Combinations complete in wooden boxes.



Profile P 1 closed joint



Profile P 1.1 with open joint

**Single tools**

SW 501 1, WE 500 1 53, WW 200 1 NN, WW 210 1 NN, WW 410 1 NN

| Tool Type                | Tool no. | D<br>mm | SB<br>mm | BO<br>mm | ID              |
|--------------------------|----------|---------|----------|----------|-----------------|
| Profile cutterhead *     | 1        | 155     | 25       | 30       | <b>125250</b> ● |
| Grooving cutterhead      | 2        | 155.2   | 8 - 15   | 30       | <b>125089</b> ● |
| Profile cutterhead       | 3        | 155     | 25       | 30       | <b>125251</b> ● |
| Profile cutterhead       | 4        | 161     | 30       | 30       | <b>125252</b>   |
| Profile cutterhead       | 5        | 161     | 30       | 30       | <b>125253</b>   |
| Profile cutterhead       | 6        | 155.1   | 25       | 30       | <b>125254</b>   |
| Profile cutterhead       | 7        | 155.1   | 25       | 30       | <b>125255</b>   |
| Profile cutterhead       | 8        | 165     | 25       | 30       | <b>125256</b>   |
| Profile cutterhead bevel | 8.1      | 165     | 25       | 30       | <b>125257</b>   |
| Profile cutterhead       | 9        | 165     | 25       | 30       | <b>125258</b>   |
| Profile cutterhead bevel | 9.1      | 165     | 25       | 30       | <b>125259</b>   |
| Jointing cutterhead      | 10       | 125     | 15       | 30       | <b>125013</b>   |
| Rebating cutterhead      | 15       | 155     | 35       | 30       | <b>125018</b>   |
| Jointing cutterhead      | 16       | 125     | 30       | 30       | <b>125019</b>   |

\* = Profile cutterheads supplied with profile P1.

**Spare knives:**

| Part-no. | BEZ               | ABM<br>mm | P       | Tool no. | QAL | VE<br>PCS | ID            |
|----------|-------------------|-----------|---------|----------|-----|-----------|---------------|
| 1        | ProfilCut Q knife | 25x27x2   | 1       | 1        | MC  |           | <b>619291</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 2       | 1        | MC  |           | <b>619292</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 3       | 1        | MC  |           | <b>619293</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 4       | 1        | MC  |           | <b>619294</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 5       | 1        | MC  |           | <b>619295</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 1       | 1        | MC  |           | <b>619296</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 2       | 3        | MC  |           | <b>619297</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 3       | 3        | MC  |           | <b>619298</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 4       | 3        | MC  |           | <b>619299</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 5       | 3        | MC  |           | <b>619300</b> |
| 1        | ProfilCut Q knife | 30x31x2   | 6/7     | 3        | MC  |           | <b>619301</b> |
| 1        | ProfilCut Q knife | 30x31x2   | 6/7     | 5        | MC  |           | <b>619302</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 6/6.1/7 | 6        | MC  |           | <b>619303</b> |
| 1        | ProfilCut Q knife | 25x27x2   | 6/6.1/7 | 7        | MC  |           | <b>619304</b> |
| 1        | ProfilCut Q knife | 25x32x2   | 8       | 8        | MC  |           | <b>619305</b> |
| 1        | ProfilCut Q knife | 25x32x2   | 8.1     | 8.1      | MC  |           | <b>619306</b> |

## 4. Manual feed

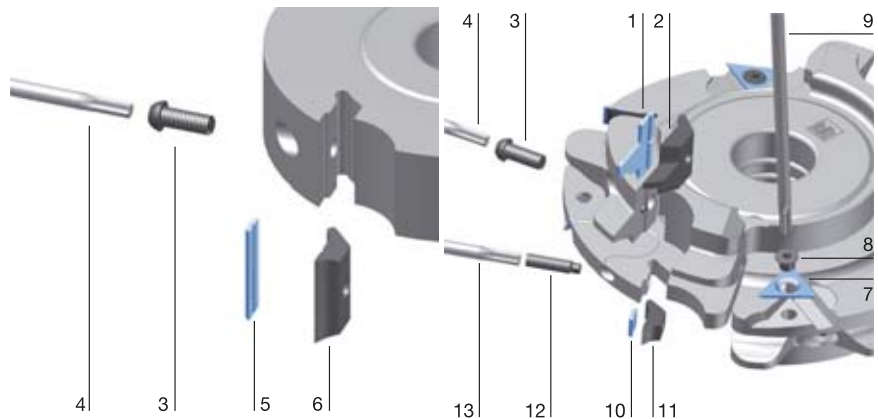
### 4.4 Profiling

#### 4.4.4 Profile and counter profile cutterheads

| Part-no. | BEZ                | ABM<br>mm  | P   | Tool<br>no. | QAL    | VE<br>PCS | ID              |
|----------|--------------------|------------|-----|-------------|--------|-----------|-----------------|
| 1        | ProfilCut Q knife  | 25x32x2    | 8   | 9           | MC     |           | <b>619307</b>   |
| 1        | ProfilCut Q knife  | 25x32x2    | 8.1 | 9.1         | MC     |           | <b>619308</b>   |
| 5        | Turnblade knife    | 14.7x8x1.5 |     | 10          | HW-30F | 10        | <b>005070 ●</b> |
| 5        | Turnblade knife    | 30x8x1.5   |     | 16          | HW-30F | 10        | <b>005072 ●</b> |
| 5        | Turnblade knife    | 35x8x1.5   |     | 15          | HW-30F | 10        | <b>005073 ●</b> |
| 7        | Turnblade spur VS2 | 19x19x2    |     | 2/5         | HW-F   | 10        | <b>005115 ●</b> |
| 10       | Turnblade knife    | 7.7x8x1.5  |     | 2           | HW-30F | 10        | <b>005068 ●</b> |

#### Spare parts:

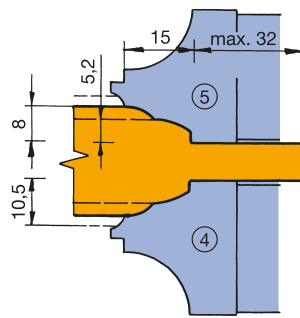
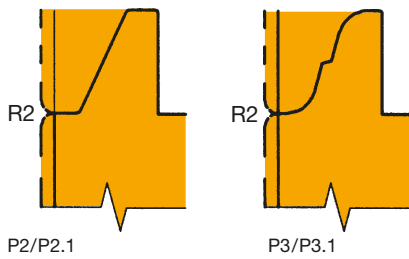
| Part-no. | BEZ                                 | ABM<br>mm     | P       | Tool<br>no. | ID              |
|----------|-------------------------------------|---------------|---------|-------------|-----------------|
| 2        | Clamping wedge profiled             | 23x30x8.27    |         | 3           | <b>629237</b>   |
| 2        | Clamping wedge profiled             | 23x30x8.27    |         | 1           | <b>629238</b>   |
| 2        | Clamping wedge profiled             | 28x38x8.27    | 6/6.1/7 | 4/4.1       | <b>629239</b>   |
| 2        | Clamping wedge profiled             | 28x38x8.27    | 6/6.1/7 | 5/5.1       | <b>629240</b>   |
| 2        | Clamping wedge profiled             | 23x37.32x8.27 | 6/6.1/7 | 6           | <b>629241</b>   |
| 2        | Clamping wedge profiled             | 23x37.32x8.27 | 6/6.1/7 | 7           | <b>629242</b>   |
| 2        | Clamping wedge profiled             | 23x37.2x8.27  | 8/8.1   | 8/8.1       | <b>629243</b>   |
| 2        | Clamping wedge profiled             | 23x37.2x8.27  | 8/8.1   | 9/9.1       | <b>629244</b>   |
| 3        | Clamping screw w. disc,<br>Torx® 25 | M6x18.5       |         |             | <b>007442 ●</b> |
| 4        | Torx® key                           | Torx® 25      |         |             | <b>117504 ●</b> |
| 6        | Clamping wedge                      | 13x18.75x8.27 |         | 6           | <b>009670 ●</b> |
| 6        | Clamping wedge                      | 28x18.75x8.27 | 1/2/16  | 4           | <b>009673 ●</b> |
| 6        | Clamping wedge                      | 33x18.75x8.27 | 15      | 5           | <b>009674 ●</b> |
| 8        | Countersink screw, Torx® 20         | M6x0.5x4.9    |         |             | <b>006243 ●</b> |
| 9        | Torx® key                           | Torx® 20      |         |             | <b>117503 ●</b> |
| 11       | Clamping wedge                      | 7x18.75x8.27  | 2       | 2           | <b>009763 ●</b> |
| 12       | Allen screw with shank,<br>Torx® 15 | M5x20         |         |             | <b>007380 ●</b> |
| 13       | Torx® key                           | Torx® 15      |         |             | <b>117507 ●</b> |
|          | Magnetic setting gauge              | 0.3/0.8       |         |             | <b>005376 ●</b> |



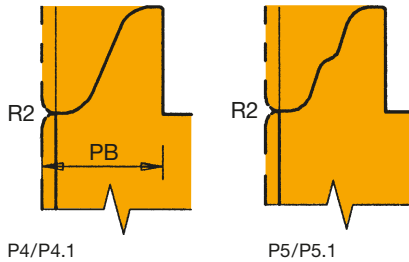
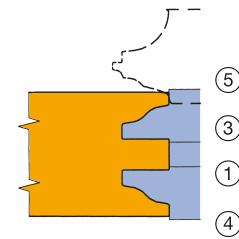
## 4. Manual feed

### 4.4 Profiling

#### 4.4.4 Profile and counter profile cutterheads



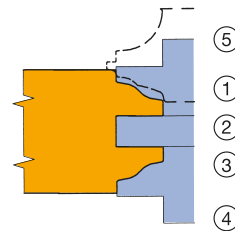
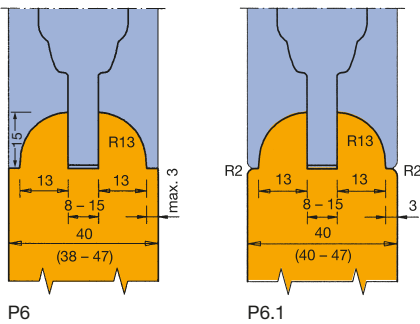
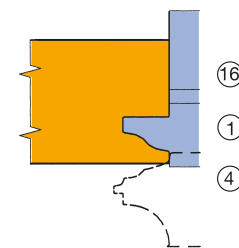
Double profile



These profile cutterheads can be used for panel raising.

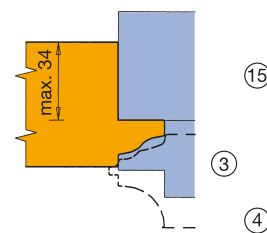
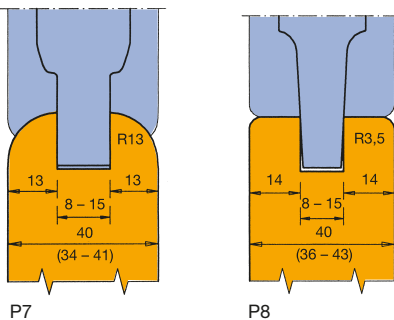
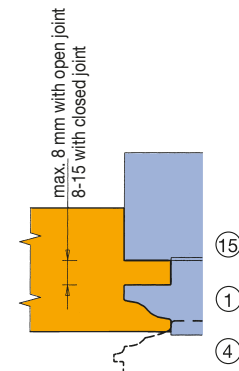
Fig.: Combination options of single tools  
Double profile

Profiles P1 - P5.1 counter profile



For profiles P1 - P5.1 along grain

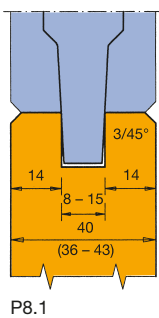
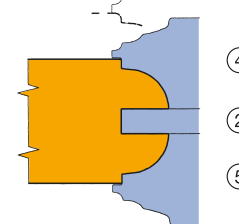
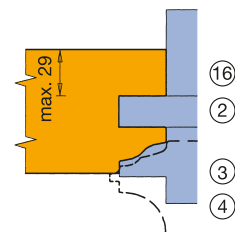
Rebate\*



Rebate\*

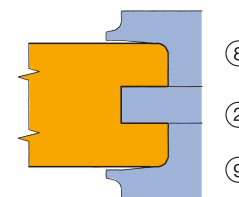
On one side\*

\* Profiles P1 - P8 (rebate possible and on one side)



On one side\*

Profiles P6 - P7 along grain

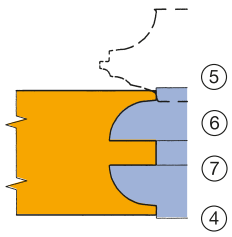


Profile P8 along grain

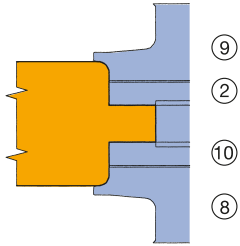
## 4. Manual feed

### 4.4 Profiling

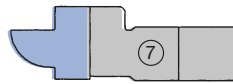
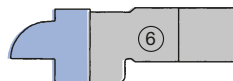
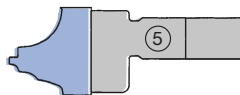
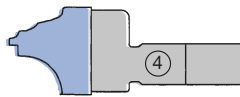
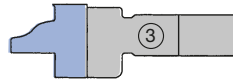
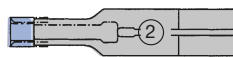
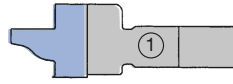
#### 4.4.4 Profile and counter profile cutterheads



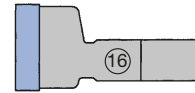
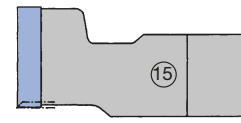
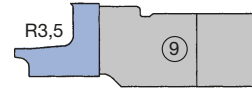
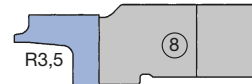
Profiles P6 - P7 counter profile



Profile P8 counter profile



Single tools



## 4. Manual feed

### 4.4 Profiling

#### 4.4.4 Profile and counter profile cutterheads



#### Profile cutterhead ProfilCut Q for furniture doors

**Application:**

For profiles and counter profiles for furniture doors.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

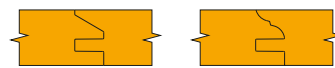
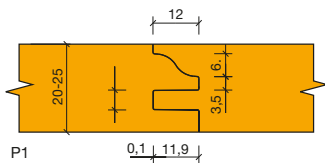
**Technical information:**

Cutterhead with change knives, straight cut.

**SB 20 - 25 mm; with closed joint**

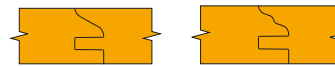
WE 640 1 53

| D   | SB | BO | BO <sub>max</sub> | Z | P | n                 | ID       |
|-----|----|----|-------------------|---|---|-------------------|----------|
| mm  | mm | mm | mm                |   |   | min <sup>-1</sup> |          |
| 150 | 40 | 30 | 50                | 2 | 1 | 5200 - 8900       | 125262 ● |
| 150 | 40 | 50 |                   | 2 | 1 | 5200 - 8900       | 125392 □ |



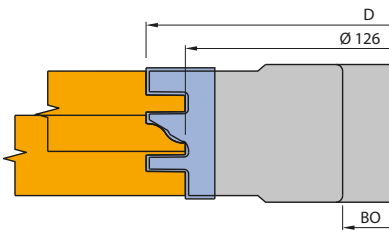
P2

P3



P4

P5



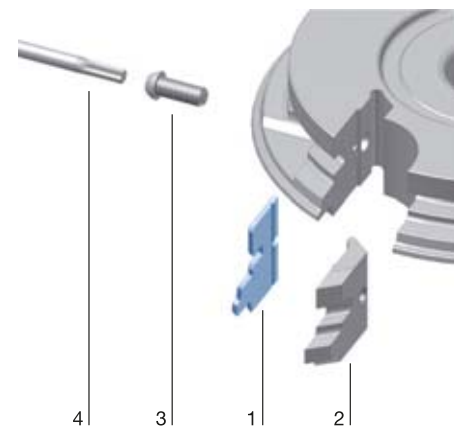
Profile cutterhead

**Spare knives:**

| Part-no. | BEZ               | ABM     | P | QAL | ID     |
|----------|-------------------|---------|---|-----|--------|
|          |                   | mm      |   |     |        |
| 1        | ProfilCut Q knife | 40x26x2 | 1 | MC  | 619311 |
| 1        | ProfilCut Q knife | 40x26x2 | 2 | MC  | 619312 |
| 1        | ProfilCut Q knife | 40x26x2 | 3 | MC  | 619313 |
| 1        | ProfilCut Q knife | 40x26x2 | 4 | MC  | 619314 |
| 1        | ProfilCut Q knife | 40x26x2 | 5 | MC  | 619315 |

**Spare parts:**

| Part-no. | BEZ                              | ABM          | ID       |
|----------|----------------------------------|--------------|----------|
|          |                                  | mm           |          |
| 2        | Clamping wedge profiled          | 38x36.5x8.27 | 629245   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | 007442 ● |
| 4        | Torx® key                        | Torx® 25     | 117504 ● |



## 4. Manual feed

### 4.4 Profiling

#### 4.4.5 Panel raising profile cutterheads



#### Profile cutterhead ProfilCut Q - panel raising

**Application:**

For profiling and panel raising 5 different profiles by knife change.

**Machine:**

Spindle moulders and moulders, double-end tenoners.

**Workpiece material:**

Softwood and hardwood (along and across grain).

**Technical information:**

Cutterhead with change knives, shear angle.

**Profiling and panel raising, panel raising profile curved**

AE 342 1 53

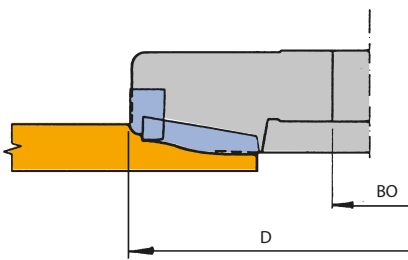
| P | D   | SB | BO | BO <sub>max</sub> | Z   | n                 | DRI | ID              |
|---|-----|----|----|-------------------|-----|-------------------|-----|-----------------|
|   | mm  | mm | mm | mm                |     | min <sup>-1</sup> |     |                 |
| 1 | 190 | 40 | 30 | 50                | 2/2 | 4100 - 7000       | RH  | <b>125265 ●</b> |

**Spare knives:**

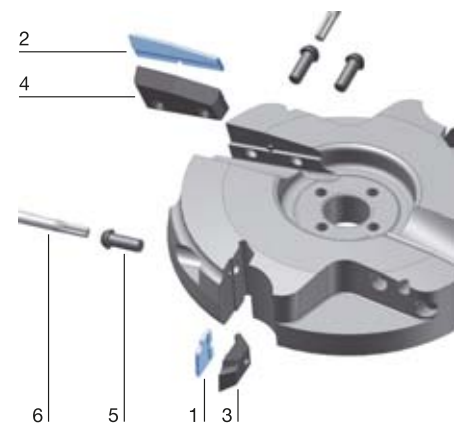
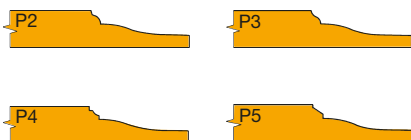
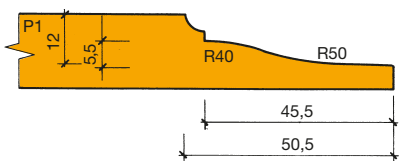
| Part-no. | BEZ                           | ABM        | P | ID              |
|----------|-------------------------------|------------|---|-----------------|
|          |                               | mm         |   |                 |
| 1        | ProfilCut Q knife             | 20x16x2    | 1 | <b>619321 ●</b> |
| 1        | ProfilCut Q knife             | 20x16x2    | 2 | <b>619322 ●</b> |
| 1        | ProfilCut Q knife             | 20x16x2    | 3 | <b>619323 ●</b> |
| 1        | ProfilCut Q knife             | 20x16x2    | 4 | <b>619324</b>   |
| 1        | ProfilCut Q knife             | 20x16x2    | 5 | <b>619325</b>   |
| 2        | ProfilCut Q knife (pan.rais.) | 50x11.68x2 |   | <b>619326 ●</b> |

**Spare parts:**

| Part-no. | BEZ                              | ABM                          | ID              |
|----------|----------------------------------|------------------------------|-----------------|
|          |                                  | mm                           |                 |
| 3        | Clamping wedge profiled          | 18x26.46x8.27 (P1-5)         | <b>629248</b>   |
| 4        | Clamping wedge profiled          | 47x20.18x7.25 (raised panel) | <b>629249</b>   |
| 5        | Clamping screw w. disc, Torx® 25 | M6x18.5                      | <b>007442 ●</b> |
| 6        | Torx® key                        | Torx® 25                     | <b>117504 ●</b> |



Single side panel raising



## 4. Manual feed

### 4.4 Profiling

#### 4.4.5 Panel raising profile cutterheads



#### Profile cutterhead ProfilCut Q - panel raising

##### Application:

For profiling and panel raising 5 different profiles by knife change.

##### Machine:

Spindle moulders and moulders, double-end tenoners.

##### Workpiece material:

Softwood and hardwood (along and across grain).

##### Technical information:

Cutterhead with change knives, shear angle.

##### Profiling and panel raising, panel raising profile straight

AE 342 1 53

| P | D   | SB | BO | BO <sub>max</sub> | Z   | n                 | DRI | ID            |
|---|-----|----|----|-------------------|-----|-------------------|-----|---------------|
|   | mm  | mm | mm | mm                |     | min <sup>-1</sup> |     |               |
| 1 | 204 | 33 | 30 | 50                | 2/2 | 3800 - 6500       | RH  | <b>125266</b> |
| 1 | 220 | 33 | 30 | 50                | 2/2 | 3500 - 6000       | RH  | <b>125267</b> |
| 1 | 220 | 33 | 50 | 50                | 2/2 | 3500 - 6000       | RH  | <b>125268</b> |

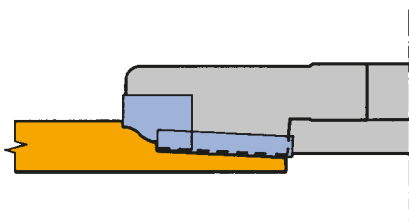
P1 = Profile cutterhead P1.

##### Spare knives:

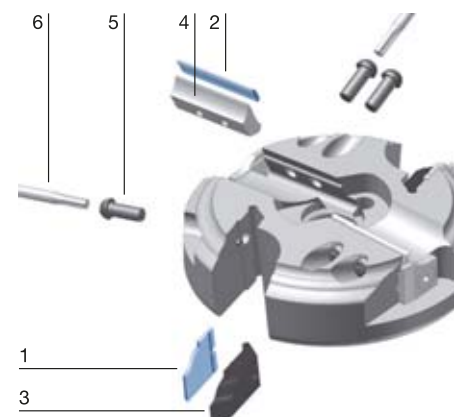
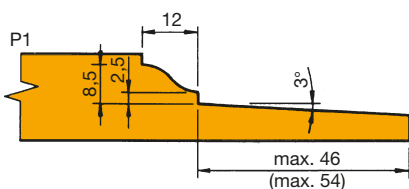
| Part-no. | BEZ               | ABM      | P | VE  | ID              |
|----------|-------------------|----------|---|-----|-----------------|
|          |                   | mm       |   | PCS |                 |
| 1        | ProfilCut Q knife | 20x27x2  | 1 |     | <b>619327</b>   |
| 1        | ProfilCut Q knife | 20x27x2  | 2 |     | <b>619328</b>   |
| 1        | ProfilCut Q knife | 20x27x2  | 3 |     | <b>619329</b>   |
| 1        | ProfilCut Q knife | 20x27x2  | 4 |     | <b>619330</b>   |
| 1        | ProfilCut Q knife | 20x27x2  | 5 |     | <b>619331</b>   |
| 2        | Turnblade knife   | 50x8x1.5 |   | 10  | <b>005075 ●</b> |
| 2        | Turnblade knife   | 60x8x1.5 |   | 10  | <b>005076 ●</b> |

##### Spare parts:

| Part-no. | BEZ                                 | ABM           | P   | ID              |
|----------|-------------------------------------|---------------|-----|-----------------|
|          |                                     | mm            |     |                 |
| 3        | Clamping wedge profiled             | 18x37.46x8.27 | 1-5 | <b>629250</b>   |
| 4        | Clamping wedge panel raising cutter | 47x16.8x7.25  |     | <b>009578 ●</b> |
| 4        | Clamping wedge panel raising cutter | 57x16.8x7.25  |     | <b>009579 ●</b> |
| 5        | Clamping screw w. disc, Torx® 25    | M6x18.5       |     | <b>007442 ●</b> |
| 6        | Torx® key                           | Torx® 25      |     | <b>117504 ●</b> |



##### Single side panel raising





## 4. Manual feed

### 4.4 Profiling

#### 4.4.5 Panel raising profile cutterheads



#### Profile cutterhead ProfilCut Q - panel raising

##### Application:

For profiling and panel raising 4 different profiles by knife change.

##### Machine:

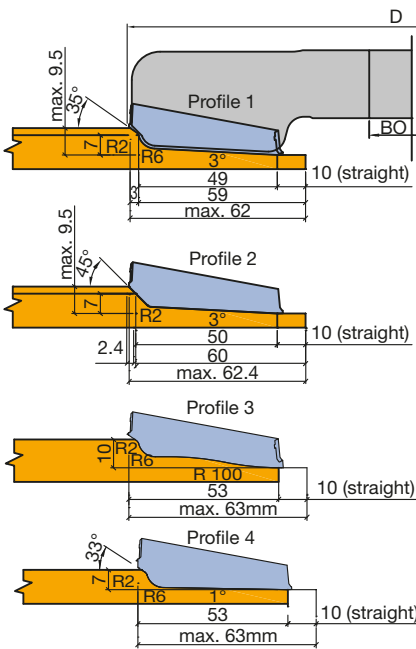
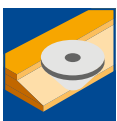
Spindle moulders and moulders, double-end tenoners.

##### Workpiece material:

Softwood and hardwood, three layer laminate.

##### Technical information:

Cutterhead with change knives and shear angle. Tool with 4 profile variants (bevel and quarter round).



#### Profiling and panel raising using one knife, panel raising profile straight

WE 550 1 53

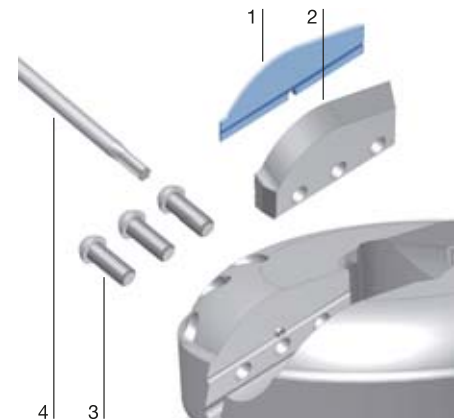
| P | D   | SB      | BO | BO <sub>max</sub> | Z | n                 | ID              |
|---|-----|---------|----|-------------------|---|-------------------|-----------------|
|   | mm  | mm      | mm | mm                |   | min <sup>-1</sup> |                 |
| 1 | 200 | 10 - 37 | 30 | 50                | 2 | 3900 - 6600       | <b>125269 ●</b> |

#### Spare knives:

| Part-no. | BEZ               | ABM        | P | QAL | ID              |
|----------|-------------------|------------|---|-----|-----------------|
|          |                   | mm         |   |     |                 |
| 1        | ProfilCut Q knife | 60x14.5x2  | 1 | MC  | <b>619332 ●</b> |
| 1        | ProfilCut Q knife | 60x14.56x2 | 2 | MC  | <b>619333 ●</b> |
| 1        | ProfilCut Q knife | 60x14.5x2  | 3 | MC  | <b>619489</b>   |
| 1        | ProfilCut Q knife | 60x14.5x2  | 4 | MC  | <b>619490</b>   |

#### Spare parts:

| Part-no. | BEZ                              | ABM        | ID              |
|----------|----------------------------------|------------|-----------------|
|          |                                  | mm         |                 |
| 2        | Clamping wedge profiled          | 57x23x7.25 | <b>629251</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5    | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25   | <b>117504 ●</b> |



## 4. Manual feed

### 4.4 Profiling

#### 4.4.5 Panel raising profile cutterheads



### Profile cutterhead set ProfilCut Q

#### Application:

For panel raising of cabinet doors, table tops and worktops.

#### Machine:

Spindle moulders and moulders, double-end tenoners.

#### Workpiece material:

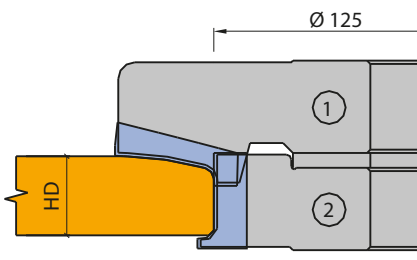
Softwood and hardwood, wood derived materials.

#### Technical information:

Cutterhead with throwaway knives and shear angle. Can be used either as single tool without jointing or as set with jointing cutterhead.



Profile 1.1



P1.1



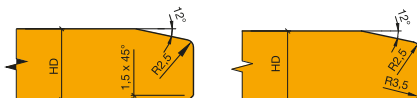
P1.2



P1.3



P2.2



P2.1



P2.3

#### Profile cutterhead set with jointing

SE 500 1 53

| Tool no. | D mm | SB mm     | BO mm | BO <sub>max</sub> mm | Z  | P   | n min <sup>-1</sup> | ID              |
|----------|------|-----------|-------|----------------------|----|-----|---------------------|-----------------|
| 1 / 2    | 185  | 29 - 29.5 | 30    | 50                   | 22 | 1.1 | 4200 - 7200         | <b>126066 ●</b> |

#### Single tools

WE 500 1 53, WE 550 1 53

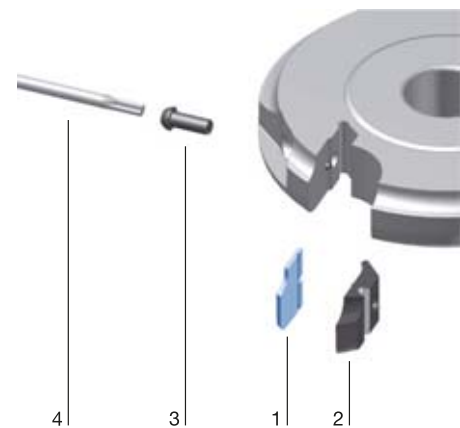
| Tool no. | D mm | SB mm     | BO mm | BO <sub>max</sub> mm | Z | n min <sup>-1</sup> | ID            |
|----------|------|-----------|-------|----------------------|---|---------------------|---------------|
| 1        | 185  | 10 - 38   | 30    | 50                   | 2 | 4200 - 7200         | <b>125263</b> |
| 2        | 135  | 29 - 29.5 | 30    | 50                   | 2 | 5700 - 9800         | <b>125264</b> |

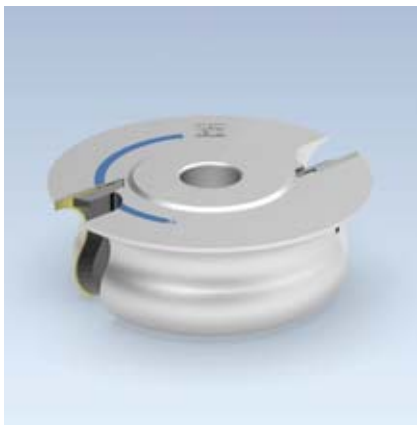
#### Spare knives:

| Part-no. | BEZ               | ABM mm     | P | Tool no. | QAL | ID            |
|----------|-------------------|------------|---|----------|-----|---------------|
| 1        | ProfilCut Q knife | 40x13.21x2 | 1 | 1        | MC  | <b>619316</b> |
| 1        | ProfilCut Q knife | 40x13.21x2 | 2 | 1        | MC  | <b>619317</b> |
| 1        | ProfilCut Q knife | 30x15.9x2  | 1 | 2        | MC  | <b>619318</b> |
| 1        | ProfilCut Q knife | 30x15.9x2  | 2 | 2        | MC  | <b>619319</b> |
| 1        | ProfilCut Q knife | 30x15.9x2  | 3 | 2        | MC  | <b>619320</b> |

#### Spare parts:

| Part-no. | BEZ                              | ABM mm        | Tool no. | ID              |
|----------|----------------------------------|---------------|----------|-----------------|
| 2        | Clamping wedge profiled          | 37x21.38x8.27 | 1        | <b>629246 ●</b> |
| 2        | Clamping wedge profiled          | 28x24x8.27    | 2        | <b>629247 ●</b> |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5       |          | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25      |          | <b>117504 ●</b> |





### Profile cutterhead ProfilCut Q for handrail profile

**Application:**

For handrails. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders, machines with/without CNC control.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutterhead with change knives and straight cut.



**Handrail profile**

WE 500 1 53

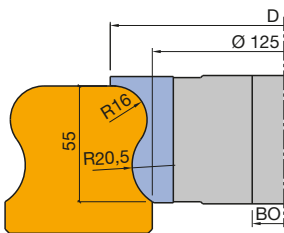
| D   | SB      | BO | BO <sub>max</sub> | Z | n                 | ID              |
|-----|---------|----|-------------------|---|-------------------|-----------------|
| mm  | mm      | mm | mm                |   | min <sup>-1</sup> |                 |
| 165 | 60 - 61 | 30 | 50                | 2 | 4700 - 8100       | <b>125386 ●</b> |

**Spare knives:**

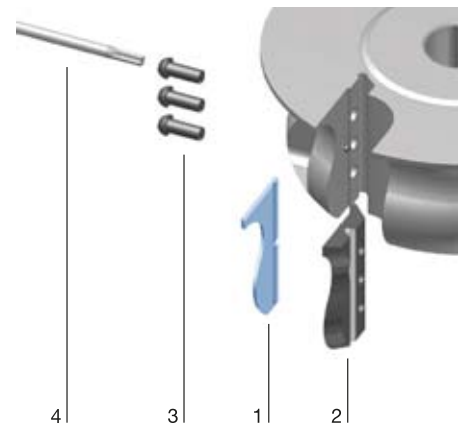
| Part-no. | BEZ               | ABM         | QAL | ID            |
|----------|-------------------|-------------|-----|---------------|
|          |                   | mm          |     |               |
| 1        | ProfilCut Q knife | 60x32.7x2.4 | MC  | <b>619500</b> |

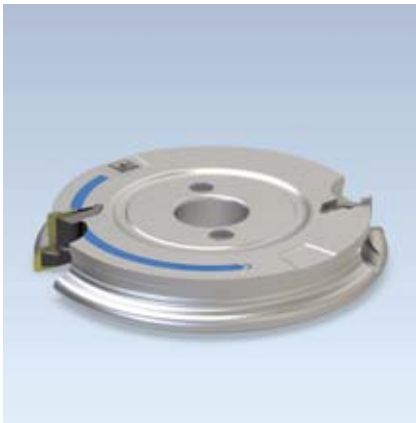
**Spare parts:**

| Part-no. | BEZ                              | ABM        | ID              |
|----------|----------------------------------|------------|-----------------|
|          |                                  | mm         |                 |
| 2        | Clamping wedge profiled          | 58x35x8.27 | <b>629463</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5    | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25   | <b>117504 ●</b> |



Handrail profile





### Profile Cutterhead ProfilCut Q for grip rails

**Application:**  
For cutting recessed grips.

**Machine:**  
Spindle moulders and moulders.

**Workpiece material:**  
Softwood and hardwood, chip and fibre board, raw or plastic coated, glulam etc.

**Technical information:**  
Maximum operating comfort due to lightweight construction of the tool body. Longer lasting consistent finish cutting quality due to Marathon high performance coating.



**MAN feed**  
WE 500 1 53

| D   | SB | BO | BO <sub>max</sub> | Z | ID              |
|-----|----|----|-------------------|---|-----------------|
| mm  | mm | mm | mm                |   |                 |
| 150 | 25 | 30 | 50                | 2 | <b>125380 ●</b> |

**RPM:**  $n_{max} = 12500 \text{ min}^{-1}$

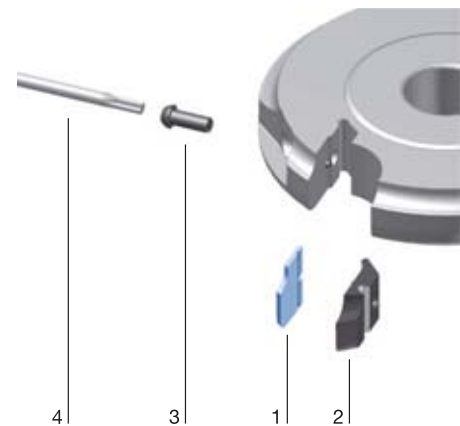
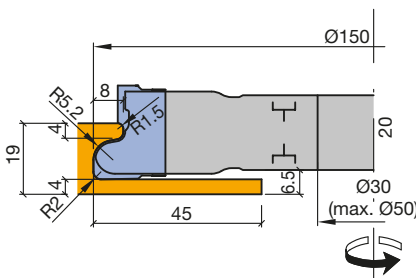
Throwaway knives for other profile variants available on request.

**Spare knives:**

| Part-no. | BEZ               | ABM         | QAL | ID            |
|----------|-------------------|-------------|-----|---------------|
|          |                   | mm          |     |               |
| 1        | ProfilCut Q knife | 25.1x21x2.4 | MC  | <b>619475</b> |

**Spare parts:**

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge profiled          | 21x29.5x8.27 | <b>629464</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25     | <b>117504 ●</b> |



## 4. Manual feed

### 4.4 Profiling 4.4.6 Common profiles



#### Profile cutterhead ProfilCut Q for gear grooves

**Application:**  
For gear grooves.

**Machine:**  
Spindle moulders and moulders.

**Workpiece material:**  
Softwood and hardwood.

**Technical information:**  
Cutterhead with change knives. User friendliness by lightweight construction of the tool body. Longer performance and cut quality due to Marathon high performance coating.



**Gear groove**  
WE 500 1 53

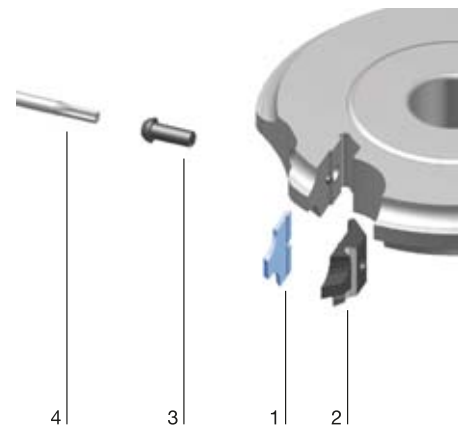
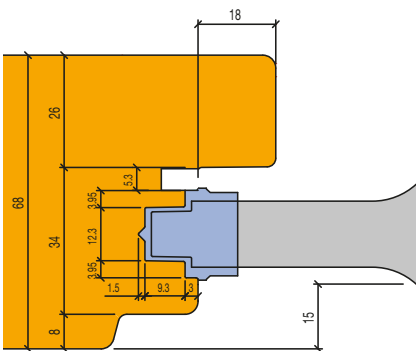
| D     | SB        | BO | BO <sub>max</sub> | Z | n                 | ID              |
|-------|-----------|----|-------------------|---|-------------------|-----------------|
| mm    | mm        | mm | mm                |   | min <sup>-1</sup> |                 |
| 188.6 | 21.3/23.1 | 30 | 50                | 2 | 4100 - 9100       | <b>125393 ●</b> |

**Spare knives:**

| Part-no. | BEZ               | ABM         | QAL | ID            |
|----------|-------------------|-------------|-----|---------------|
|          |                   | mm          |     |               |
| 1        | ProfilCut Q knife | 21.3x25x2.4 | MC  | <b>619521</b> |

**Spare parts:**

| Part-no. | BEZ                              | ABM          | ID              |
|----------|----------------------------------|--------------|-----------------|
|          |                                  | mm           |                 |
| 2        | Clamping wedge                   | 15.7x33x8.27 | <b>629461</b>   |
| 3        | Clamping screw w. disc, Torx® 25 | M6x18.5      | <b>007442 ●</b> |
| 4        | Torx® key                        | Torx® 25     | <b>117504 ●</b> |



## 4. Manual feed

### 4.4 Profiling

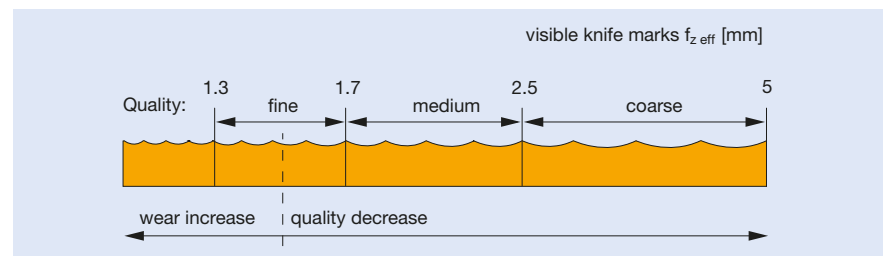
#### 4.4.7 Multi-purpose profile cutterheads

##### Type of operation

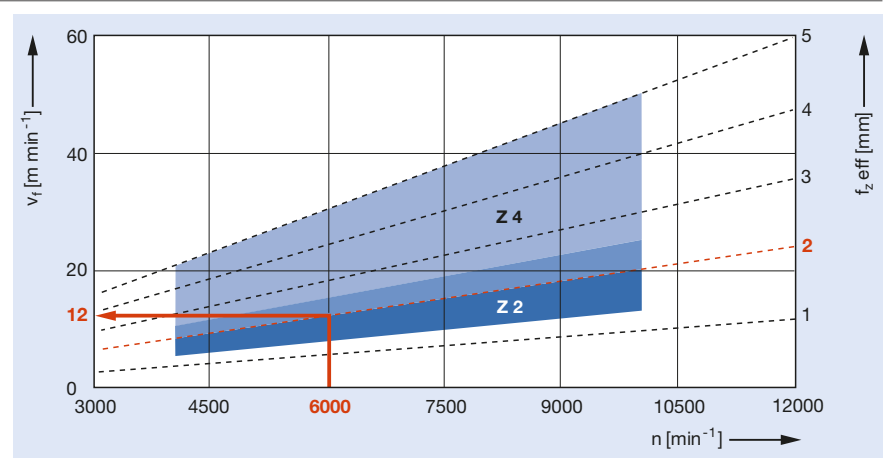
The tools described in the following section are suitable for making many different profiles. This includes profiling in craft or industry, the relevant product descriptions provide a reference when using a specific tool, and the type of woods processed.

The introduction to each section gives general notes and application regulations.

##### Relation between surface quality and length of knife marks $f_{z\text{ eff}}$



##### Feed speeds depending on RPM, length of knife marks and number of teeth

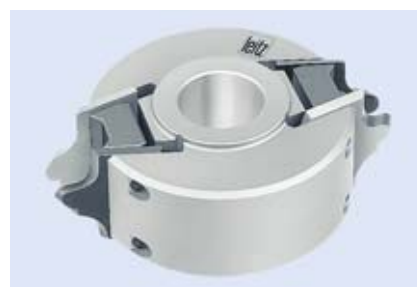


With multi blade tools, only the marks of one knife show on the surface (one knife finish). Z 2 and Z 4 tools produce the same surface quality with same machine setting. High numbers of teeth are required for a high hogging performance.

##### Workpiece materials, machines, application

Please refer to the relevant product pages depending on the operation and profile.

##### Tool system



WM 500 1 04 Profile cutterhead with limiter, tool body in aluminium.

For profile depths up to maximum 15 mm and cutting widths of 50 mm. (WM 510 1 03)  
 For profile depths up to maximum 15 mm and cutting widths of 40 mm. (WM 500 1 04)  
 For small companies or craft. For spindle moulders or combination machines. More than 127 standard profile cutters and limitors available. If required Leitz can supply profile knives and limitors in HS quality to a special shape. Only a drawing or wood sample of the required profile is necessary to produce the special knives.

## 4. Manual feed

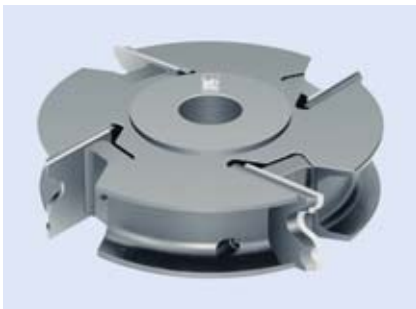
### 4.4 Profiling

#### 4.4.7 Multi-purpose profile cutterheads






WM 530 1 01 Profile cutterhead.  
 WM 530 1 02 Profile cutterhead.  
 WM 520 1 Profile cutterhead.  
 WM 540 1 Profile cutterhead.

For big profile depths up to maximum 45 mm and cutting widths up to 80 mm. Suitable for small and medium sized companies to produce special profiles. For machines with manual feed. Special profile knives in HS quality can be produced by the Leitz service stations on request. Only a sketch or wood sample of the required profile is necessary to produce special profile knives.



Profile cutterhead VariForm.

**VariForm** cutterheads are available in different designs and dimensions. The tool body is designed for mech. feed without limiter or for manual feed with limiter depending on the application. Please select the correct type of cutterhead for each application from the diagram below.

| Design variation                        | Profile depth up to 15/19 mm   | Profile depth up to 20 mm   | Profile depth up to 35 mm  |
|---|--|---|--|
| <b>MAN-feed</b><br>For spindle moulders | <br>Multi-purpose tool body | <br>Part profiled tool body,<br>U-profile | <br>Profiled tool body,<br>cranked right/left |
| Cutting width                           | 40/45 mm a. 50/60 mm   | 45/45 mm a. 50/60 mm  | 40 mm to 60 mm   |



### Profile cutterhead, aluminium tool body

**Application:**

For profiling, jointing and rebating.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Profile cutterhead with aluminium tool body for standard and special profile knives up to 50 mm cutting width and maximum profile depth 15 mm. Constant diameter by using changeable profile knives. Knife thickness 4 mm.



**D 108 mm - 148 mm**

WM 500 1 04, WM 500 1 06

| D   | SB      | BO | BO <sub>max</sub> | Z | n                 | QAL | ID              |
|-----|---------|----|-------------------|---|-------------------|-----|-----------------|
| mm  | mm      | mm | mm                |   | min <sup>-1</sup> |     |                 |
| 108 | 40      | 30 | 30                | 2 | 6000 - 10000      | SP  | <b>025685 ●</b> |
| 128 | 40 - 50 | 30 | 40                | 2 | 6000 - 9000       | SP  | <b>025815 ●</b> |
| 128 | 80      | 30 | 40                | 2 | 6000 - 8000       | SP  | <b>025816 ●</b> |
| 148 | 40 - 50 | 30 | 50                | 2 | 5500 - 7000       | SP  | <b>025691 ●</b> |

See section Knives and Spare Parts.

Table for diameters when using rebating and profile knives:

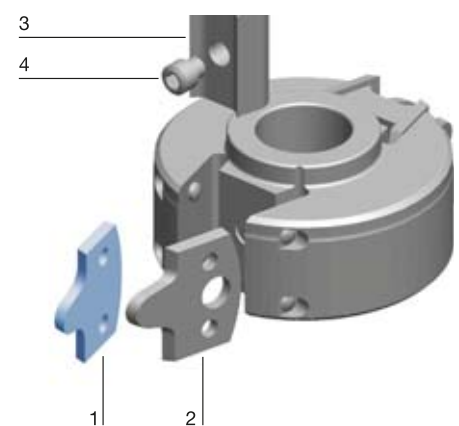
| D-mm<br>Tool<br>body | D-mm<br>with rebating<br>knife | D-mm<br>with profile<br>knife |
|----------------------|--------------------------------|-------------------------------|
| 93                   | 108                            | 130                           |
| 114                  | 128                            | 150                           |

**Spare knives:**

| Part-no. | BEZ          | ABM<br>mm   | QAL | ID              |
|----------|--------------|-------------|-----|-----------------|
| 1        | Rebate knife | 40x32.8x4   | SP  | <b>007104 ●</b> |
| 2        | Limiter      | 38.4x32.8x4 | ST  | <b>005586 ●</b> |

**Spare parts:**

| Part-no. | BEZ                    | ABM<br>mm   | ID              |
|----------|------------------------|-------------|-----------------|
| 3        | Clamping wedge         | 36x13.21x26 | <b>009756 ●</b> |
| 3        | Clamping wedge         | 56x13.21x26 | <b>009757 ●</b> |
| 4        | Allen screw with ISK 5 | M10x12      | <b>006044 ●</b> |
|          | Allen key              | SW 5        | <b>005446 ●</b> |





## 4. Manual feed

### 4.4 Profiling

#### 4.4.7 Multi-purpose profile cutterheads



#### Profile cutterhead

**Application:**

For deep one-sided profiles, maximum 45 mm depth.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutting width up to 50 mm. See illustration for usable profile area. Knife thickness 4.0 mm.



**MAN feed, for one sided profiles with SB 50 mm**

WM 530 1 01

| D   | TD  | SB | BO | BO <sub>max</sub> | Z | n                 | ID              |
|-----|-----|----|----|-------------------|---|-------------------|-----------------|
| mm  | mm  | mm | mm | mm                |   | min <sup>-1</sup> |                 |
| 200 | 148 | 50 | 30 | 40                | 2 | 4500 - 7000       | <b>029636 ●</b> |

Sales unit without knives and limitors.

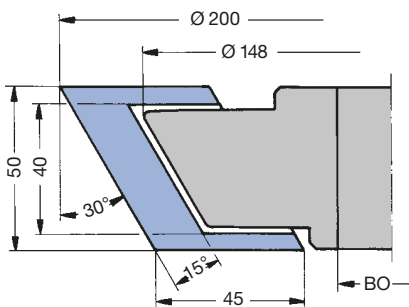
Note: State direction of rotation when ordering knives.

**Spare knives:**

| BEZ           | BEM | ABM       | QAL | ID              |
|---------------|-----|-----------|-----|-----------------|
|               |     | mm        |     |                 |
| Blank Knife   | R/T | 50.4x45x4 | HS  | <b>007297 ●</b> |
| Blank Knife   | R/B | 50.4x45x4 | HS  | <b>007298 ●</b> |
| Limiter blank | R/T | 48.8x45x4 | SP  | <b>005603 ●</b> |
| Limiter blank | R/B | 48.8x45x4 | SP  | <b>005604 ●</b> |

**Spare parts:**

| BEZ          | ABM          | ID              |
|--------------|--------------|-----------------|
|              | mm           |                 |
| Allen screw  | M10x16       | <b>006046 ●</b> |
| Allen key    | SW 5         | <b>005446 ●</b> |
| Double wedge | 49.2x13.2x26 | <b>009927 ●</b> |



**HS-special profiles and SP-profile limitors**

|                                 |                                    |            |
|---------------------------------|------------------------------------|------------|
| Profile knives set inc. limitor | PG I                               | SB = 50 mm |
| Profile knives set inc. limitor | PG II                              | SB = 50 mm |
| Set consists of:                | 2 HS-Profile knives; 2 SP-Limitors |            |

Profile knives and limitors produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**



### Profile cutterhead

#### Application:

For deep one-sided profiles with large profile depth, maximum 45 mm depth. Easy to use, no setting gauge required.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutting width up to 80 mm. See illustration for usable profile area. Knife thickness 4.0 mm.



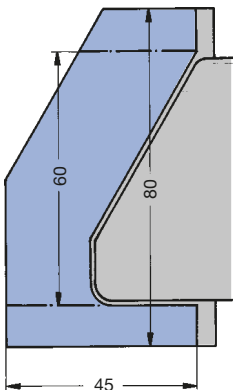
#### MAN feed, for one sided profiles with SB 60 - 80 mm

WM 530 1 02

| D   | SB      | BO | BO <sub>max</sub> | HD | PT <sub>max</sub> | Z | n                 | ID       |
|-----|---------|----|-------------------|----|-------------------|---|-------------------|----------|
| mm  | mm      | mm | mm                | mm | mm                |   | min <sup>-1</sup> |          |
| 180 | 60 - 80 | 30 | 40                | 80 | 45                | 2 | 4500 - 6000       | 026768 ● |
| 180 | 60 - 80 | 40 | 40                | 80 | 45                | 2 | 4500 - 6000       | 026769 □ |

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.



#### Spare knives:

| Part-no. | BEZ                    | ABM       | QAL | ID       |
|----------|------------------------|-----------|-----|----------|
|          |                        | mm        |     |          |
| 1        | Blank Knife R/B        | 60x60x6   | HS  | 007280 ● |
| 1        | Blank Knife R/B        | 80x60x6   | HS  | 007281 ● |
| 1        | Blank Knife R/T        | 60x60x6   | HS  | 007282 ● |
| 1        | Blank Knife R/T        | 80x60x6   | HS  | 007283 ● |
| 2        | Limiter blank R/B (60) | 58x59.2x6 | SP  | 005596 ● |
| 2        | Limiter blank R/B (80) | 78x59.2x6 | SP  | 005597 ● |
| 2        | Limiter blank R/T (60) | 58x59.2x6 | SP  | 005598 ● |
| 2        | Limiter blank R/T (80) | 78x59.2x6 | SP  | 005599 ● |

#### Spare parts:

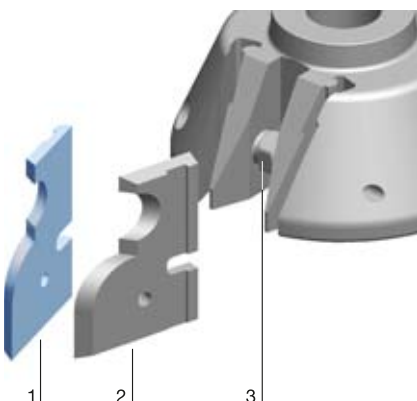
| Part-no. | BEZ            | ABM              | ID       |
|----------|----------------|------------------|----------|
|          |                | mm               |          |
| 3        | Clamping screw | M16x1.5x36 LH/RH | 005958 ● |
|          | Key            | SW 17            | 005456 ● |

#### HS-special profiles and SP-profile limitors

|                  |                       |                     |
|------------------|-----------------------|---------------------|
| PG I             | Set of profile knives | SB = 60 mm          |
| PG II            | Set of profile knives | SB = 60 mm          |
| PG I             | Set of profile knives | SB = 80 mm          |
| PG II            | Set of profile knives | SB = 80 mm          |
| Set consists of: |                       | 2 HS-Profile knives |
|                  |                       | 2 SP-Limitors       |

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**





### Profile cutterhead

#### Application:

For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.



#### MAN feed for symmetric profiles SB 60 - 80 mm

WM 520 1

| D   | SB      | BO | BO <sub>max</sub> | HD | PT <sub>max</sub> | Z | n                 | ID              |
|-----|---------|----|-------------------|----|-------------------|---|-------------------|-----------------|
| mm  | mm      | mm | mm                | mm | mm                |   | min <sup>-1</sup> |                 |
| 180 | 60 - 80 | 30 | 40                | 80 | 45                | 2 | 4500 - 6000       | <b>026651</b> ● |
| 180 | 60 - 80 | 40 | 40                | 80 | 45                | 2 | 4500 - 6000       | <b>026652</b> □ |

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.

#### Spare knives:

| Part-no. | BEZ           | ABM       | QAL | ID              |
|----------|---------------|-----------|-----|-----------------|
|          |               | mm        |     |                 |
| 1        | Blank Knife   | 60x60x6   | HS  | <b>007278</b> ● |
| 1        | Blank Knife   | 80x60x6   | HS  | <b>007279</b> ● |
| 2        | Limiter blank | 58x59.2x6 | SP  | <b>005594</b> ● |
| 2        | Limiter blank | 78x59.2x6 | SP  | <b>005595</b> ● |

#### Spare parts:

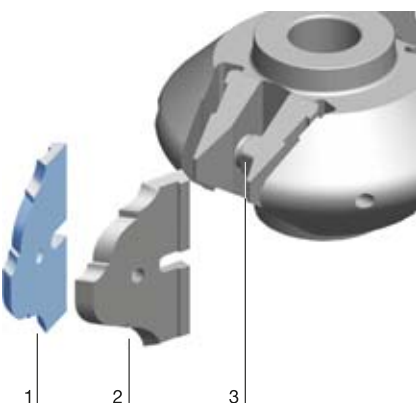
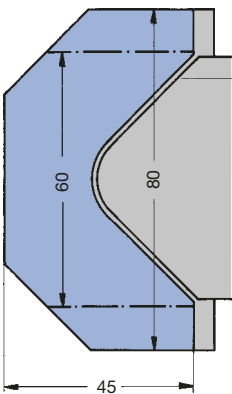
| Part-no. | BEZ            | ABM              | ID              |
|----------|----------------|------------------|-----------------|
|          |                | mm               |                 |
| 3        | Clamping screw | M16x1.5x36 LH/RH | <b>005958</b> ● |
|          | Key            | SW 17            | <b>005456</b> ● |

#### HS-special profiles and SP-profile limitors

|                  |                       |                     |
|------------------|-----------------------|---------------------|
| PG I             | Set of profile knives | SB = 60 mm          |
| PG II            | Set of profile knives | SB = 60 mm          |
| PG I             | Set of profile knives | SB = 80 mm          |
| PG II            | Set of profile knives | SB = 80 mm          |
| Set consists of: |                       | 2 HS-Profile knives |
|                  |                       | 2 SP-Limitors       |

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**





### Profile cutterhead

#### Application:

For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.



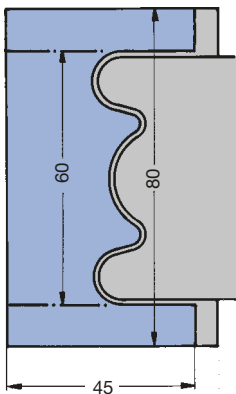
#### MAN feed for symmetric closed profiles SB 60 - 80 mm

WM 540 1

| D   | SB      | BO | BO <sub>max</sub> | HD | PT <sub>max</sub> | Z | n                 | ID       |
|-----|---------|----|-------------------|----|-------------------|---|-------------------|----------|
| mm  | mm      | mm | mm                | mm | mm                |   | min <sup>-1</sup> |          |
| 180 | 60 - 80 | 30 | 40                | 80 | 45                | 2 | 4500 - 6000       | 026865 ● |
| 180 | 60 - 80 | 40 | 40                | 80 | 45                | 2 | 4500 - 6000       | 026866 □ |

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.



#### Spare knives:

| Part-no. | BEZ           | ABM       | QAL | ID       |
|----------|---------------|-----------|-----|----------|
|          |               | mm        |     |          |
| 1        | Blank Knife   | 60x60x6   | HS  | 007276 ● |
| 1        | Blank Knife   | 80x60x6   | HS  | 007277 ● |
| 2        | Limiter blank | 58x59.2x6 | SP  | 005600 ● |
| 2        | Limiter blank | 78x59.2x6 | SP  | 005601 ● |

#### Spare parts:

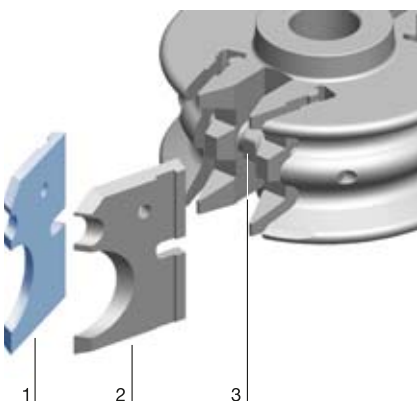
| Part-no. | BEZ            | ABM              | ID       |
|----------|----------------|------------------|----------|
|          |                | mm               |          |
| 3        | Clamping screw | M16x1.5x36 LH/RH | 005958 ● |
|          | Key            | SW 17            | 005456 ● |

#### HS-special profiles and SP-profile limitors

|                  |                       |                     |
|------------------|-----------------------|---------------------|
| PG I             | Set of profile knives | SB = 60 mm          |
| PG II            | Set of profile knives | SB = 60 mm          |
| PG I             | Set of profile knives | SB = 80 mm          |
| PG II            | Set of profile knives | SB = 80 mm          |
| Set consists of: |                       | 2 HS-Profile knives |
|                  |                       | 2 SP-Limitors       |

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**





### Profile cutterhead VariForm

#### Application:

For cutting profiles. Different knives with maximum 15 mm profile depth can be mounted.

#### Machine:

Spindle moulders and moulders, double-end tenoners, edgbanding machines etc.

#### Workpiece material:

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

#### Technical information:

Multi-purpose profile cutterhead for MAN feed with tungsten carbide special profile knives and backing plates and limitors. Resharpenable 3 to 4 times.



#### Tool body, MAN feed, Z 2

TT 531 1

| D   | TD  | SB      | BO | BO <sub>max</sub> | PT <sub>max</sub> | Z | n <sub>max</sub>  | ID       |
|-----|-----|---------|----|-------------------|-------------------|---|-------------------|----------|
| mm  | mm  | mm      | mm | mm                | mm                |   | min <sup>-1</sup> |          |
| 150 | 116 | 40 - 45 | 30 | 50                | 15                | 2 | 8000              | 135100 ● |
| 150 | 116 | 50 - 60 | 30 | 50                | 15                | 2 | 8000              | 135101 ● |

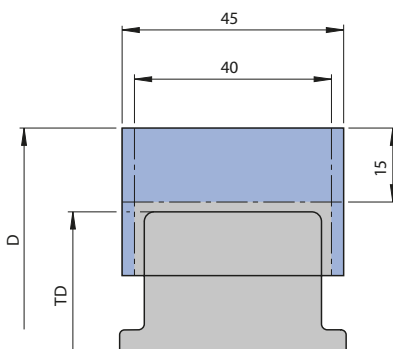
Supplied with clamping wedges, but without backing plates, limitors and knives.

#### Spare knives:

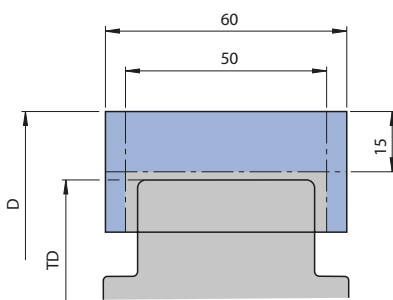
| Part-no. | SB | H  | PT <sub>max</sub> | ID       | ID       |
|----------|----|----|-------------------|----------|----------|
|          | mm | mm | mm                | HW-10F   | HW-30F   |
| 1        | 40 | 40 | 15                | 636227 ● | 636240 ● |
| 1        | 45 | 40 | 15                | 636231 ● | 636244 ● |
| 1        | 50 | 40 | 15                | 636284 ● | 636272 ● |
| 1        | 60 | 40 | 15                | 636288 ● | 636276 ● |

#### Spare parts:

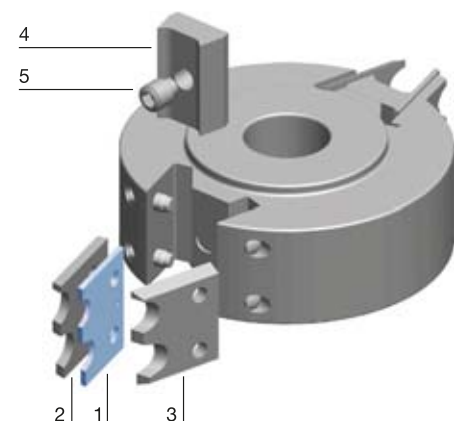
| Part-no. | BEZ                     | ABM                  | for SB | ID       |
|----------|-------------------------|----------------------|--------|----------|
|          |                         | mm                   | mm     |          |
| 2        | Backing plate VariForm  | for knives 40x40x2.1 | 40     | 645000 ● |
| 2        | Backing plate VariForm  | for knives 45x40x2.1 | 45     | 645001 ● |
| 2        | Backing plate VariForm  | for knives 50x40x2.1 | 50     | 645002 ● |
| 2        | Backing plate VariForm  | for knives 60x40x2.1 | 60     | 645003 ● |
| 3        | Limiter VariForm        | for knives 40x40x2.1 |        | 640000 ● |
| 3        | Limiter VariForm        | for knives 45x40x2.1 |        | 640001 ● |
| 3        | Limiter VariForm        | for knives 50x40x2.1 |        | 640002 ● |
| 3        | Limiter VariForm        | for knives 60x40x2.1 |        | 640003 ● |
| 4        | Clamping wedge          | 36x13.21x26          | 40/45  | 009756 ● |
| 4        | Clamping wedge VariForm | 44x13.21x24.25       | 50/60  | 009760 ● |
| 5        | Allen screw with ISK 5  | M10x12               |        | 006044 ● |
|          | Allen key               | SW 5, L100           |        | 117506 ● |



Tool body, SB 40/45 mm



Tool body, SB 50/60 mm





### Profile cutterhead VariForm

#### Application:

For cutting profiles. Different knives with maximum 20 mm profile depth can be mounted.

#### Machine:

Spindle moulders and moulders, double-end tenoners, edgbanding machines etc.

#### Workpiece material:

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

#### Technical information:

Multi-purpose profile cutterhead for MAN feed with tungsten carbide special profile knives and backing plates and limitors. Resharpenable 3 to 4 times.



#### Part profiled tool body, MAN feed, Z 2 (U-profile).

TT 531 1

| D   | TD  | SB | BO | BO <sub>max</sub> | PT <sub>max</sub> | Z | n <sub>max</sub>  | ID       |
|-----|-----|----|----|-------------------|-------------------|---|-------------------|----------|
| mm  | mm  | mm | mm | mm                | mm                |   | min <sup>-1</sup> |          |
| 180 | 165 | 40 | 30 | 50                | 20                | 2 | 7200              | 135120 ● |
| 180 | 165 | 60 | 30 | 50                | 20                | 2 | 7200              | 135122 ● |

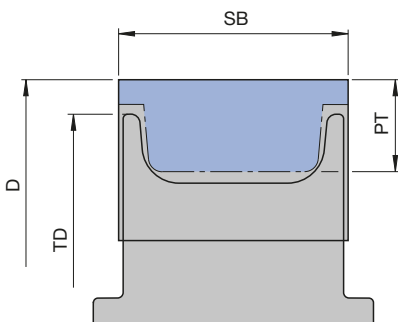
Supplied with clamping wedges, but without backing plates, limitors and knives.

#### Spare knives:

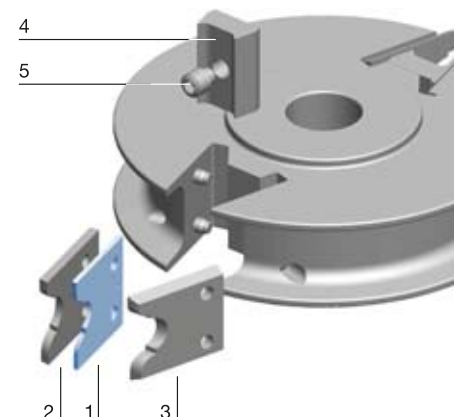
| Part-no. | SB | H  | PT | ID       | ID       |
|----------|----|----|----|----------|----------|
|          | mm | mm | mm | HW-10F   | HW-30F   |
| 1        | 40 | 45 | 20 | 636226 ● | 636239 ● |
| 1        | 60 | 45 | 20 | 636287 ● | 636275 ● |

#### Spare parts:

| Part-no. | BEZ                    | ABM                  | for SB | ID       |
|----------|------------------------|----------------------|--------|----------|
|          |                        | mm                   | mm     |          |
| 2        | Backing plate VariForm | for knives 40x45x2.1 |        | 645004 ● |
| 2        | Backing plate VariForm | for knives 60x45x2.1 |        | 645006 ● |
| 3        | Limiter VariForm       | for knives 40x45x2.1 |        | 640004 ● |
| 3        | Limiter VariForm       | for knives 60x45x2.1 |        | 640006 ● |
| 4        | Clamping wedge         | 36x13.21x26          | 40/45  | 009756 ● |
| 4        | Clamping wedge         | 56x13.21x26          | 60     | 009757 ● |
| 5        | Allen screw with ISK 5 | M10x12               |        | 006044 ● |
|          | Allen key              | SW 5, L100           |        | 117506 ● |



Tool body, U profile



| Problem   | Possible cause   | Action   |
|---|--|--|
| <b>Surface errors</b><br><b>Cutting quality</b>           | - RPM too low  | Increase RPM and cutting speed, increase tool diameter   |
|   | - Wrong cutting geometry (shear angle too small for solid wood)                                    | Measure, change tool   |
|   | - Spindle and tool tolerances too big  | Check motor bearings and tolerances  |
|   | - Unbalanced tool  | Check and balance  |
|   | - Cutting speed too high (tool rubs), number of teeth: feed speed ratio incorrect                  | Increase feed speed, reduce no. of teeth and RPM   |
|   | - Too few teeth, too high feed speed   | Adjust number of teeth and feed speed accordingly  |
| <b>Wavy, rough surface</b>                                | - Irregular workpiece feed   | Check feed or conveyor unit  |
|   | - Low feed roller pressure, worn feed rollers  | Increase feed roller pressure and re-machine grooves in rollers  |
|   | - Workpieces too narrow or too short   | Pay attention to machine manufacturer's guidelines   |
|   | - Chip removal too high  | Pre-relieve or machine in several passes   |
|   | - Resin built up, or blunt tool  | Clean and sharpen tool regularly   |
| <b>Surface errors</b><br><b>Burn marks</b>                | - Cutting speed too high   | Reduce RPM   |
|   | - Feed speed: number of teeth ratio wrong  | Adjust number of teeth and feed speed accordingly  |
|   | - Tool rotates on stationary workpiece   | Ensure constant feed through the machine   |
| <b>Surface errors</b><br><b>Tear outs</b>                 | - Wood moisture content too low  | Check drying process   |
|   | - Knotty wood  | Optimise with crosscut saw and longitudinal joints   |
| <b>Surface errors</b><br><b>Chip marks</b>                | - Incorrect cutting geometry for workpiece material  | Check, adjust or use new tool  |
|   | - Gap between knife and wedges   | Clean and carefully mount knife and wedge  |
|   | - Gullet too small   | Check and enlarge  |
|   | - Extraction hood and chip removal unit insufficient   | Contact machine manufacturer   |
|   | - Weak dust extraction   | Guideline: 30 m s <sup>-1</sup> air speed  |
| <b>Profile error in workpiece – angle error – uneven</b>  | - Tool profile sets not identical, e.g. with sets for cutting with/against feed                    | Check and adjust tool set  |
|   | - Spindle not exactly vertical in feed direction or table plane                                    | Check spindle is vertical with dial gauge at two positions with moving spindle (top and bottom of spindle) |
|   | - Worn table and fence   | Rework or replace table and fence  |
|   | - Angle tolerance between table and fence too large or incorrect adjustment of fence and zero line | Check and adjust angles, adjust fence to tool zero diameter  |
| <b>Power consumption of motor</b><br><b>Feeding force</b> | - Resin built up on tool, blunt tool   | Clean and sharpen tool regularly   |
|   | - Tool gullet too small  | Check and correct  |
|   | - Shear angle too small  | Correct or use new tool  |
|   | - Cutting section too large  | Relieve profile or machine in several passes   |

## 4. Manual feed

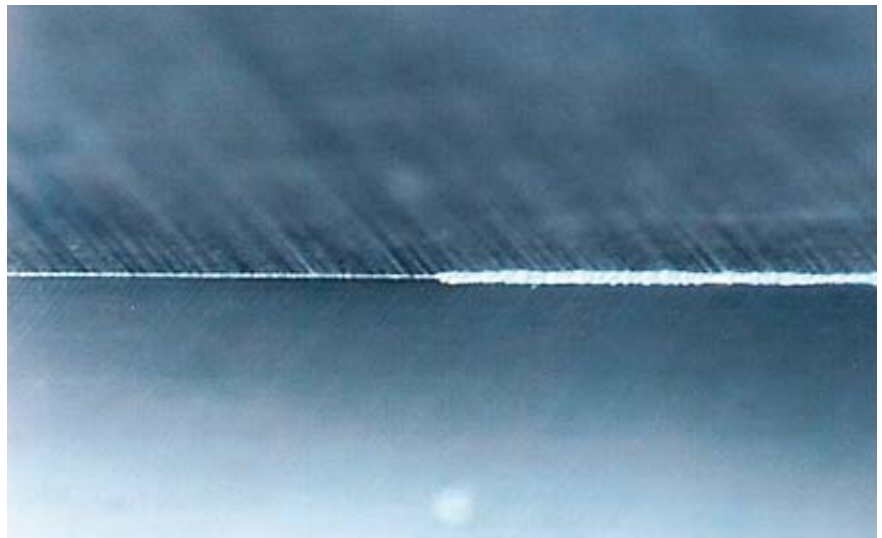
### Signs of wear to HW cutting edges

#### Rounding of cutting edges

Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

Tipped tools must be resharpened regularly to ensure the economic efficiency of the tool.

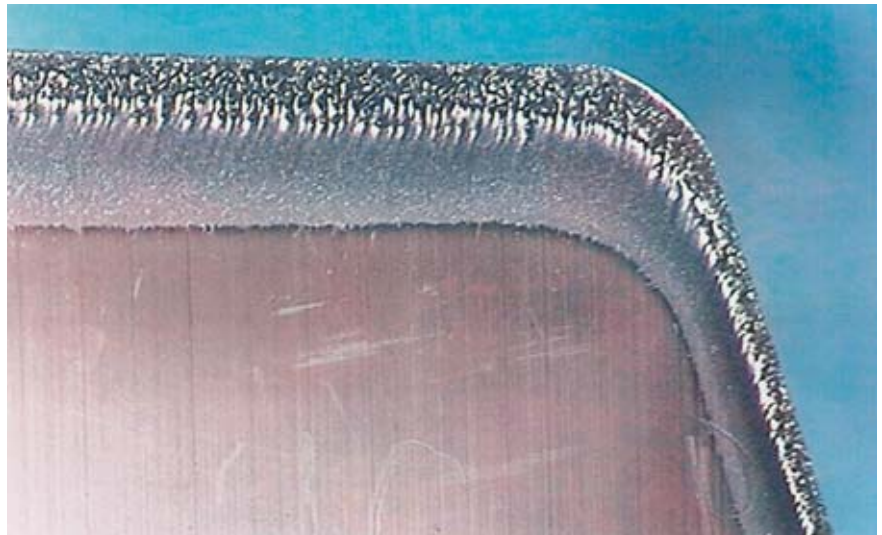


Typical cutting edge wear after machining spruce.

#### Chemical wear to cutting edges

When machining workpiece materials with a high tannic acid content (e.g. oak), the wear to the cutting edges is a combination of mechanical and chemical wear.

The cobalt binder material in the tungsten carbide is etched away by a chemical action prematurely damaging the cutting material.



Chemical influence – cutting edge wear – after machining of oak.

#### Cutting edge damage through incorrect repair

With cutterhead/cutter set tools with HW cutting edges, the knives must be turned or replaced at the end of their performance time.

Resharpener on the face is not possible for safety reasons as it leads to a loss of clamping force and gaps between the knife and the clamping wedge, affect the surface quality.

Tools with turnblade/replaceable knives must be thoroughly cleaned and carefully mounted when changing knives.



Damaged cutting edges due to incorrect repair.



## 4. Manual feed

### Signs of wear to DP cutting edges

#### Rounding of cutting edges

Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

Resin build up can develop on the cutting edges because of the long performance time.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

Run time performance can be increased by removing the resin build-up.



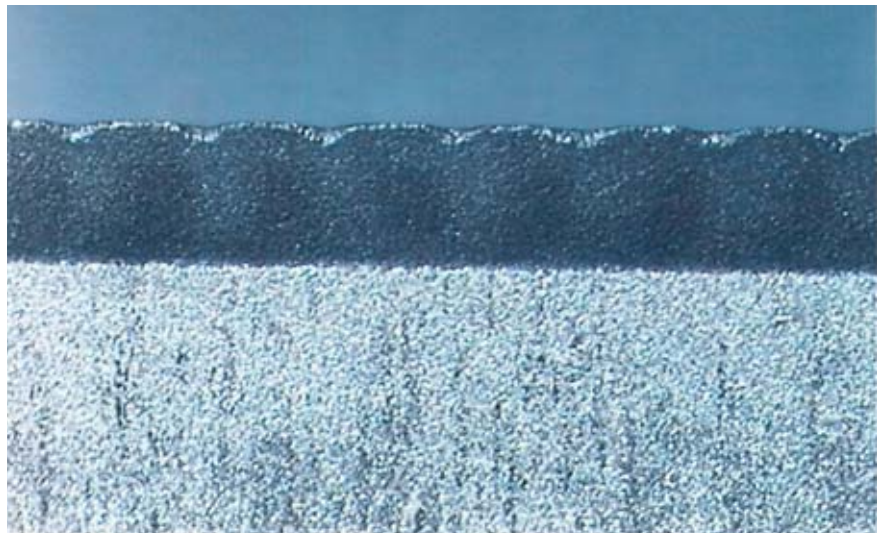
Cutting edge wear after machining GFK.

#### Rounding cutting edges and small chips

The cutting edge is damaged by small chips not caused by the usual wear when machining some wood-derived materials.

This is usually caused by foreign objects such as mineral particles in the work-piece material.

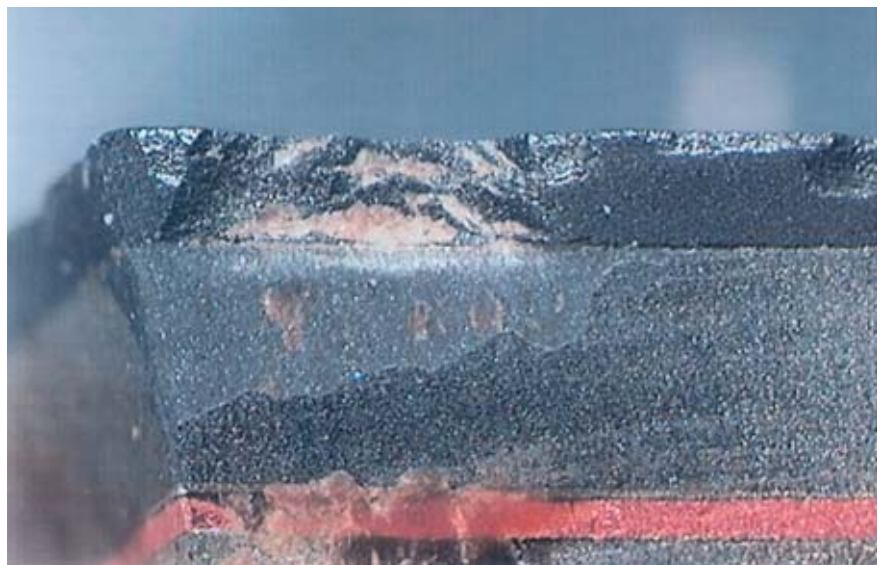
The wear to the cutting edges and the size of the chips to the cutting edge are important factors for economically efficient repair. Increasing cutting forces can totally destroy the cutting edges.



Cutting edge wear and cracks after machining HPL/CPL.

#### Cutting edge destruction

The cutting edge can be destroyed when machining non-uniform materials containing mineral or metallic particles. These particles cannot be detected prior to machining and limit the use of DP (DIA) tools for machining such materials.



Cutting edge destruction by metallic particles.

# Enquiry/order form special tools – manual feed

**Customer details: Customer number:**

(if known)

Enquiry  
 Order

Delivery date: (not binding)   CW

Company: \_\_\_\_\_

Street: \_\_\_\_\_

Date: \_\_\_\_\_

Town/Postcode: \_\_\_\_\_

Enquiry/order no.: \_\_\_\_\_

Country: \_\_\_\_\_

Tool ID: (if known) \_\_\_\_\_

Phone/fax: \_\_\_\_\_

No. of pieces: \_\_\_\_\_

Contact person: \_\_\_\_\_

Signature: \_\_\_\_\_

## Work piece material:

- Solid wood           Type: \_\_\_\_\_
- Wood-derived mat.   Type: \_\_\_\_\_
- Coating               Type: \_\_\_\_\_
- Other                 Type: \_\_\_\_\_
- Finish hogging

Moisture content: \_\_\_\_\_ %

Density: \_\_\_\_\_ g/cm<sup>3</sup>

Additional information: \_\_\_\_\_

## Machine:

(Spindle moulder, moulder, double-end tenoner edgebanding machines, window machines etc.)

Manufacturer: \_\_\_\_\_

Year: \_\_\_\_\_

Type: \_\_\_\_\_

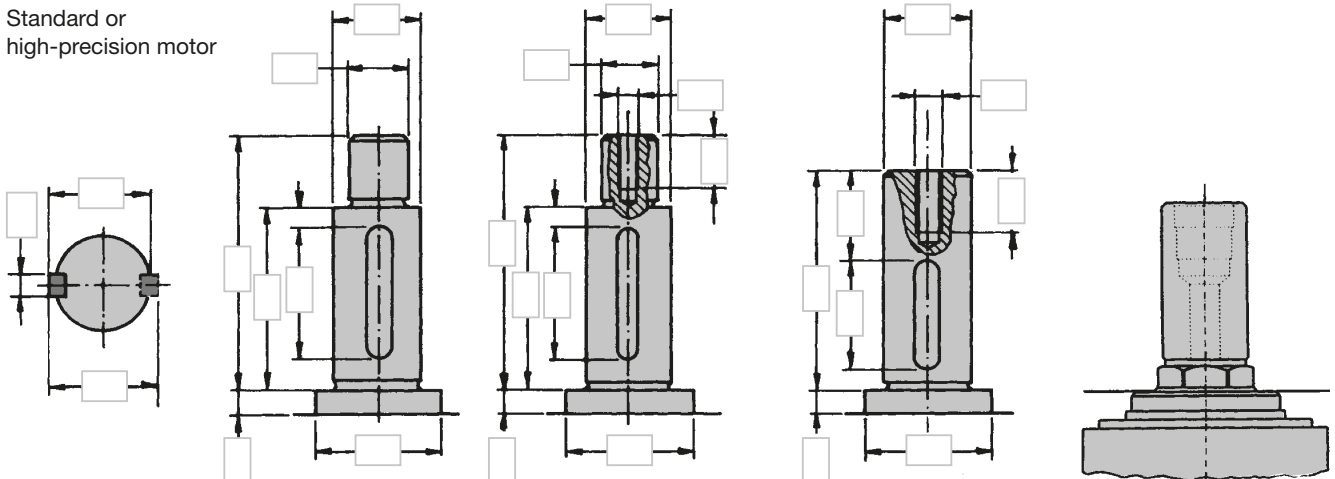
Spindle sequence in feed direction:

- e.g.: 1 bottom, 2 right hand, 3 left hand, 4 top, 5 multi-purpose
- or: 1 scoring, 2 hogging, 3 cutting, 4 square cutting, 5 finish cutting
- or: 1 sawing, 2 slotting/tenoning, 3 cutting with feed, 4 cutting against feed

| Motor no.: | Power:   | RPM:                    | Spindle dimension: | add. Information: |
|------------|----------|-------------------------|--------------------|-------------------|
| 1          | _____ kW | _____ min <sup>-1</sup> | _____ mm           | _____             |
| 2          | _____ kW | _____ min <sup>-1</sup> | _____ mm           | _____             |
| 3          | _____ kW | _____ min <sup>-1</sup> | _____ mm           | _____             |
| 4          | _____ kW | _____ min <sup>-1</sup> | _____ mm           | _____             |
| 5          | _____ kW | _____ min <sup>-1</sup> | _____ mm           | _____             |

Please state direction of rotation (LH/RH) or cutting direction (GGL/GLL) for each spindle.

Standard or high-precision motor



## Enquiry/order form special tools – manual feed

### Tool:

Tool type (see product information): (e.g. single part/tipped-/tool combination)

Dimension:

Diameter \_\_\_\_\_ mm

Cutting width: \_\_\_\_\_ mm

Bore: \_\_\_\_\_ mm

No. of teeth: \_\_\_\_\_

Cutt. mat:

- HL
- HS
- ST
- HW
- DP

Adapter:

- No adaptor required
- Sleeve with anti-twist device
- Sleeve without anti-twist device
- Quick clamping element
- Hydro clamping element

Direction of rotation:

- Right hand rotation
- Left hand rotation

Cutting direction:

- Against feed
- With feed

Type of feed:

- Manual feed (MAN)
- Mechanical feed (MEC)

Feed speed: \_\_\_\_\_ min<sup>-1</sup>

Cutting width (SB): \_\_\_\_\_ mm

Cutting depth: \_\_\_\_\_ mm

Notes:

Zero-diameter: \_\_\_\_\_ mm

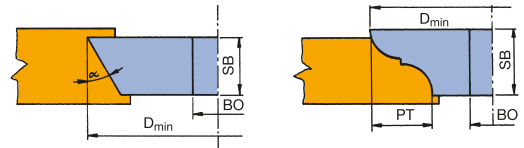
Max. diameter.: \_\_\_\_\_ mm

Zero-height: \_\_\_\_\_ mm

Clamping length: \_\_\_\_\_ mm

Application:

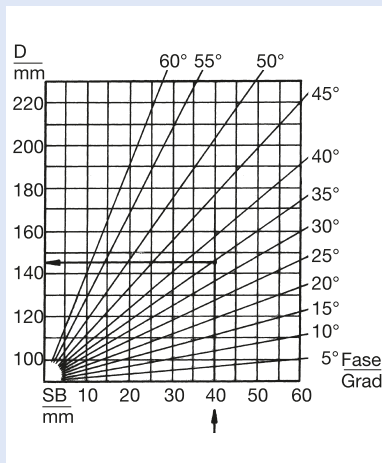
- |              |                                      |                                       |   |
|--------------|--------------------------------------|---------------------------------------|---|
| Solid wood   | <input type="checkbox"/> along grain | <input type="checkbox"/> across grain | <input type="checkbox"/> end grain                  |
| Wood-derived | <input type="checkbox"/> top layer   | <input type="checkbox"/> middle layer | <input type="checkbox"/> top layer and middle layer |



### Technical information:

Tipped tool (bevel-/profile router):  
Design: BG-Test, Z 2, round design  
mech. feed, Z 3, Z 4, round design,  
tooth shape: with/without spurs

Chart to determine min. tool diameter:  
Valid for bevel cutterblock BO – 30 mm:  
For bore 40 mm: D + 10 mm  
For bore 50 mm: D + 20 mm



### Formula to determine tool diameter:

Valid for profile cutterblock BO – 30 mm:

For bore 40 mm: D + 10 mm

For bore 50 mm: D + 10 mm

**Formula:  $D_{min} = 100 + 2 \times PT$  (mm)**

### Note:

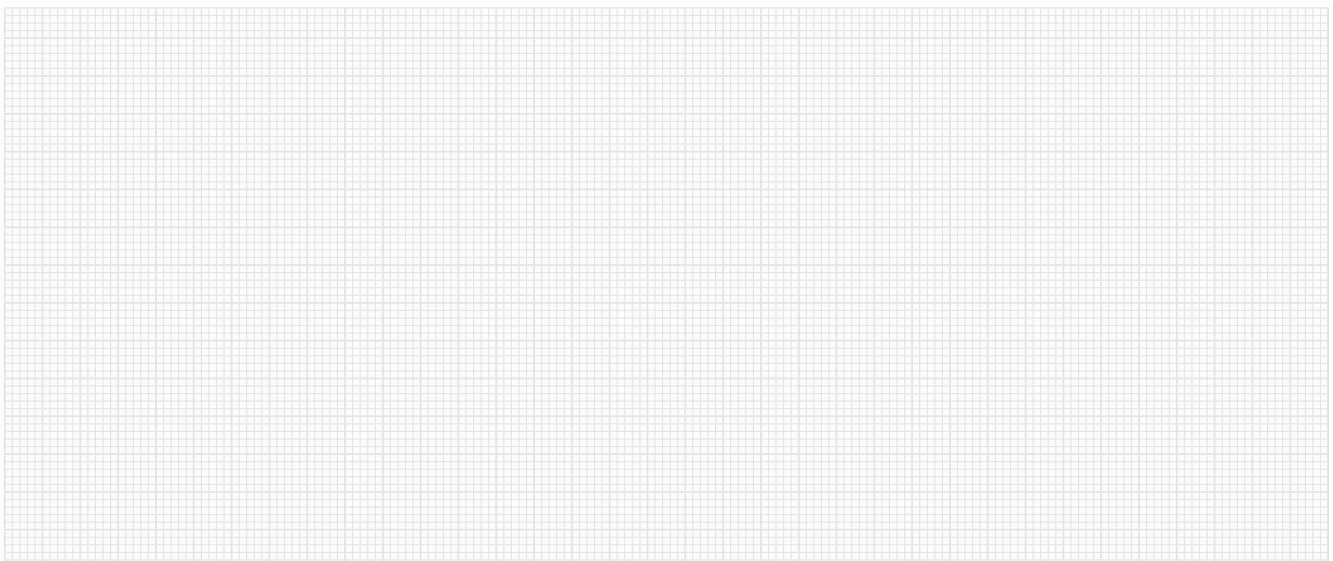
Angles exceeding 45° and large profile depths require large diameters. The maximum possible RPM for the cutterblock diameter must not be exceeded. Profile sketches or profile drawings must show clearly if the workpiece material (wood) or cutterblock is shown. Please state side to table, direction of rotation, dimensions and conditions of application on all workpiece samples or drawings.

Tool combination with turnblade-/exchangeable knives:

**Formula:  $D_{min} = 80 \times 2 \times PT$  (mm)** – Valid for BO – 30 mm

Sketch for application plan, profile drawing, special motor spindle, etc.

Please specify workpiece support and fence side and/or workpiece face side top/bottom.

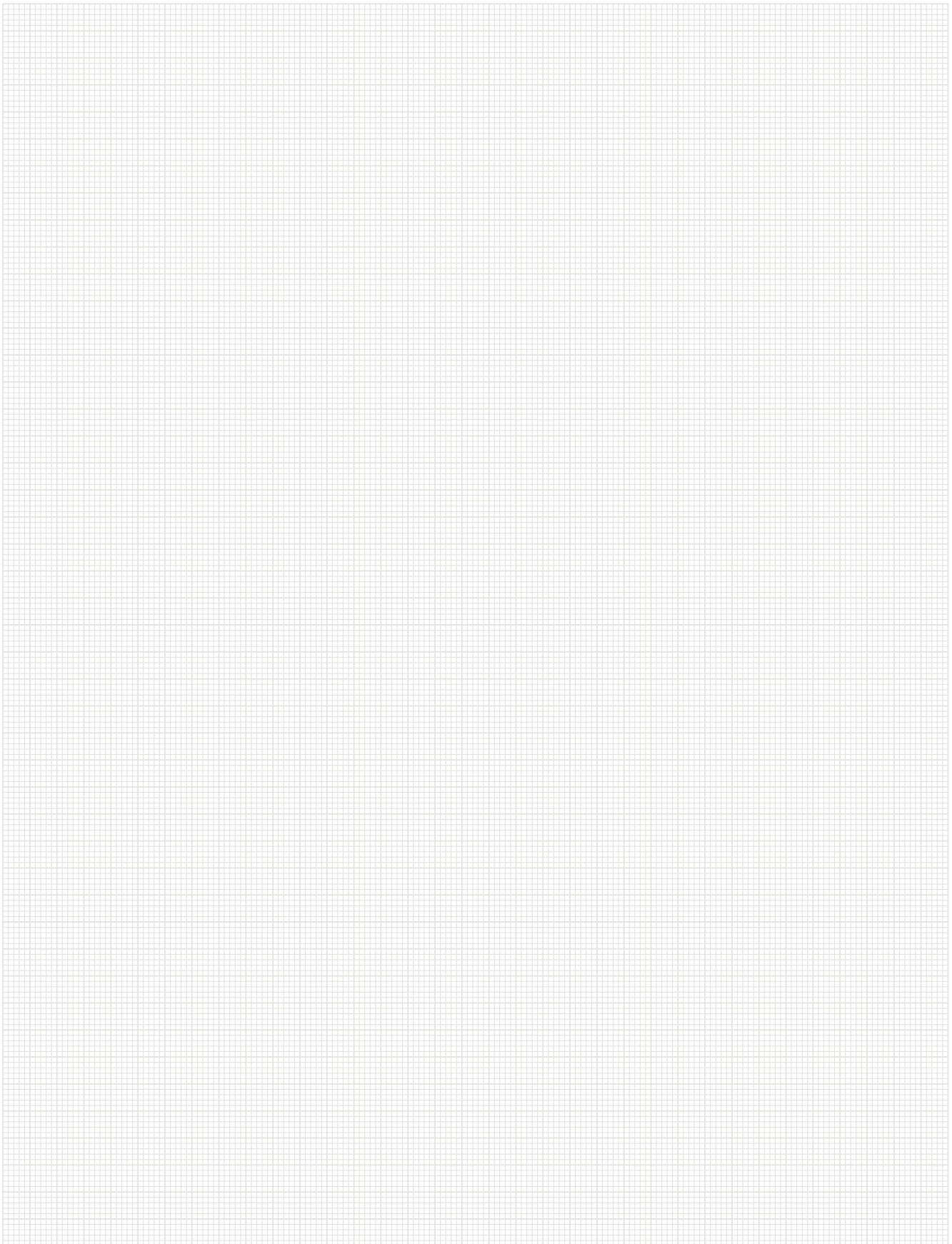


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| 020694 □ | 6    | 125135   | 28   | 128131   | 8    |          |      |
| 020697   | 6    | 125136   | 28   | 128134   | 9    |          |      |
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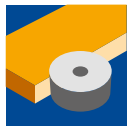
## Key to pictograms



Grooving,  
horizontal  
and vertical



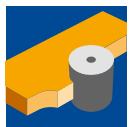
Interchangeable  
knives



Jointing



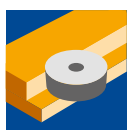
Mechanical  
knife clamping,  
reversible



Copy  
shaping



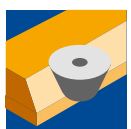
Mechanical  
knife clamping,  
non-adjustable



Rebating



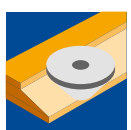
Resharpenable  
cutting face



Bevelling



Resharpenable  
clearance face



Panel  
raising



Alloyed  
tool steel



Profiling



High-speed  
steel



Profiling  
joints



Tungsten  
carbide



Manual  
feed



Polycrystalline  
diamond (PCD)



Tipped tool



Carbide  
metal coating



Light alloy  
body

